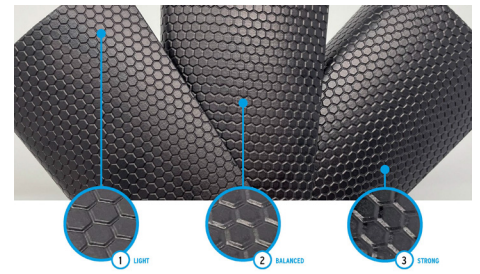


Guideline for VaporFusing - Surface smoothing

VaporFuse Surfacing from DyeMansion is a finishing process based on the condensation of vaporized VaporFuse Eco Fluid on the surface of the part. The hanging of the part in the basket carrier ensures that the steam can freely access the surface of the part. For this purpose, mounting options in the form of an eyelet on the part are necessary.



- Possible warping by VaporFuse Surfacing can be prevented if large changes in thickness are avoided and a minimum wall thickness for PA-materials and 1.5.. for TPE materials is recommended.
- A maximum wall thickness of up to 1.5mm is recommended for all materials. These measures also reduce induced stress during the printing process. In general, thermal stresses during the printing process must be minimized as much as possible.
- Narrow gaps may accumulate Eco Fluid. As a precaution the minimum gap size must be maintained. Moving parts may be merged during the process and the best way to avoid that is that the parts are separated and then mounted.
- Diameter and length ratios need to be considered on an application-specific basis. As a reference, a continuous channel with a diameter of 15mm and length of approx 250mm is processible.
- Geometric features with openings on both ends are preferable to features with deep one-sided openings (i.e. blind holes).

Properties	Value
Maximum part size	300 x 570 x 270mm
Recommended minimum wall thickness & transitions	1mm (PA), 1.5mm (TPE)
Recommended maximum wall thickness & transitions	1.5mm
Minimum Gap size	1.5mm
Channels & openings minimum diameter	15mm
Channels & openings maximum length	250mm