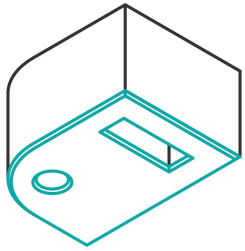
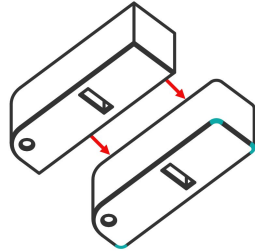


Design Rules for FFF 3D Printing

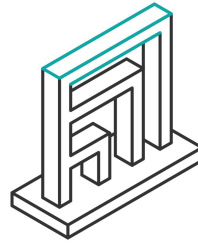
Full guide available at: www.HydraResearch3d.com/design-rules



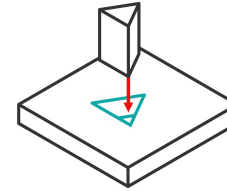
Base Chamfers
~0.3mm



Base Corners
 $R > 4\text{mm}$



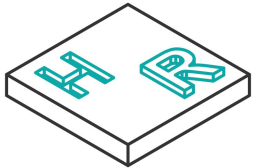
Bridging
<10mm



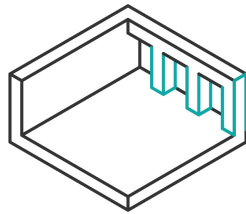
Clearance
~0.3mm loose/~0.15mm tight



Emboss & Engrave Horizontal
>0.9mm wide, <0.9mm deep



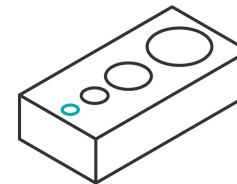
Emboss & Engrave Vertical
>0.9 mm wide, <2mm high



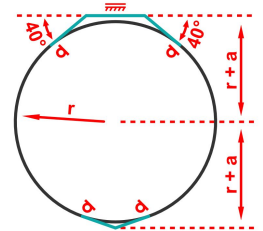
Feature Size
>1.8 mm



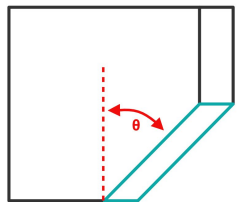
Fillets
>ø1mm, NO downward fillets



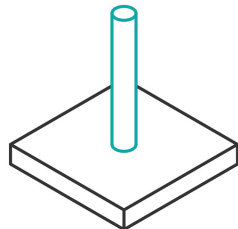
Hole Size
>ø2mm



Holes Horizontal
 $a \approx 0.3\text{mm}$



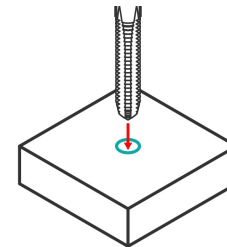
Overhangs
<50°



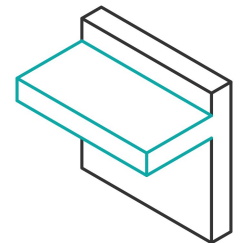
Pins
>ø1.8mm



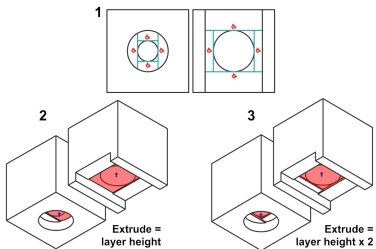
Threads Modeled
>M5/UNC #10



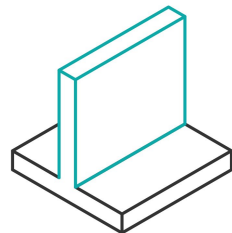
Threads Post-Process
Tap:90%/Self-Tap:96%/Insert:98%



Unsupported Edges
<0.9mm



Unsupported Holes



Wall Thickness
>0.9mm