



S240 Design Guidelines

Design Feature	Recommended	Advanced
MAXIMUM PART SIZE	100 × 100 × 75 mm	
MINIMUM PART SIZE	1 mm ³	0.5 mm ³
MINIMUM FEATURE SIZE	0.05 mm	0.01 mm
MINIMUM HOLE DIAMETER (VERTICAL)	0.05 mm	0.04 mm
MINIMUM HOLE DIAMETER (HORIZONTAL)	0.15 mm	0.1 mm
MINIMUM WALL THICKNESS (SUPPORTED)	0.05 mm	0.02 mm
MINIMUM WALL THICKNESS (UNSUPPORTED)	0.1 mm	0.05 mm
MINIMUM UNSUPPORTED OVERHANG ANGLE	30°	20°
MAXIMUM BRIDGED OVERHANG LENGTH	1.5 mm	5 mm/10 mm (rigid material)
MAXIMUM NON-BRIDGED OVERHANG LENGTH	0.3 mm	0.5 mm
ASPECT RATIO FOR CHANNELS*	100:1	500:1 for > ø 0.1 mm
ASPECT RATIO FOR PINS & PILLARS*	40:1	100:1 for > ø 0.1 mm
MINIMUM FEATURE CLEARANCE	0.1 mm	0.05 mm
RECOMMENDED CHANNEL SHAPE > ø 100 µm	rectangular or circular	
RECOMMENDED CHANNEL SHAPE < ø 100 µm	circular	
PART-TO-PART SPACING	0.1 mm	0.05 mm
LAYER HEIGHT	0.01 - 0.05 mm	
SUPPORT STRUCTURE SHAPE	cone	
SUPPORT STRUCTURE CONE TOP DIAMETER	0.08 - 0.2 mm	
SUPPORT STRUCTURE CONE BASE DIAMETER	0.1 - 1 mm	