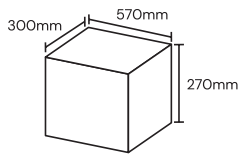


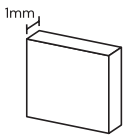
## Fastening guidelines

# Vaporfuse Surfacing



### Maximum Size

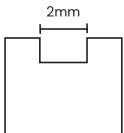
300 mm x 570 mm x 270 mm (L x W x H)



### Minimum wall thickness and transitions

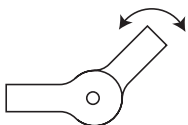
Possible warping by VaporFuse Surfacing can be prevented if large changes in thickness are avoided and a minimum wall thickness of 1 mm is taken into account.

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.



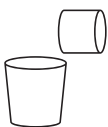
### Minimum gap size

Narrow gaps may accumulate Eco Fluid. As a precaution a minimum gap size of 2 mm must be maintained.



### Moving parts

Moving parts merge close to the contact points. Ideally, the parts are separated and mounted separately. Depending on the application, spacers or fixings can also be provided in the design to avoid contact.



### Channels and openings

Diameter and length ratios need to be considered on an application-specific basis. As a reference, a continuous channel with a diameter of 15 mm and a length of approx. 250 mm is processible.

Geometric features with openings on both ends are preferable to features with deep one-sided openings (i.e. blind holes).



### Corners

Rounded inner edges prevent the accumulation of Eco Fluid.

For more information

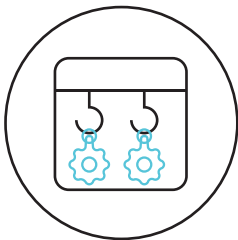
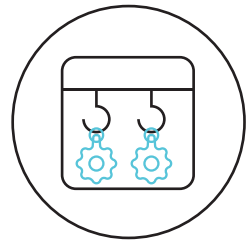
[info@all3dlabs.com](mailto:info@all3dlabs.com)

[www.all3dlabs.com](http://www.all3dlabs.com)



VaporFuse Surfacing is a finishing process based on the condensation of vaporized VaporFuse Eco Fluid on the surface of the part.

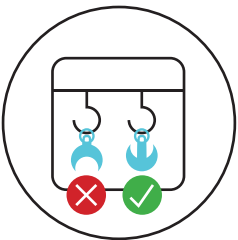
The hanging of the part in the basket carrier ensures that the steam can freely access the surface of the part. For this purpose, mounting options in the form of an eyelet on the part are necessary.



## Eyelets for mounting

Ideally, the eyelet is positioned so that the weight of the part is transferred evenly while hanging.

Depending on the weight and material, the eyelet must be sufficiently sized. In the case of flexible materials, we recommend stronger eyelets in order to be able to absorb the weight of the part.



## Hanging Alignment

Large upward facing sinks should be avoided, as condensed Eco Fluid can accumulate and not drain properly.