



## HLH DESIGN GUIDE

### MJF 3D PRINTING

#### Address

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HLH Proto LTD

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High Quality Rapid Prototypes,  
Rapid Injection Moldings and Rapid Parts

**TIPS & TRICKS:**

Wall thicknesses from 2.5 to 3.8 mm are ideal  
Susceptible to warping, large flat areas must be avoided  
Thin-walled or large, flat surfaces should be reinforced with ribs or gussets

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**BUILD VOLUME:** 380\*280\*380mm

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**MATERIALS:**

PA

**SURFACE FINISHES:**

Painting、  
Plate、  
Polish、  
Sand blasting

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**ADVANTAGES:**

Fast speed  
High quality printouts  
High-precision  
Low cost  
High density and low porosity

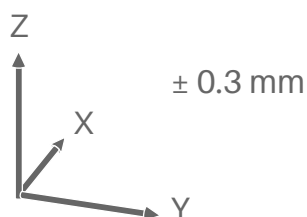
**DRAWBACKS:**

High cost of equipment and consumables  
Limited materials  
The raw parts are grey

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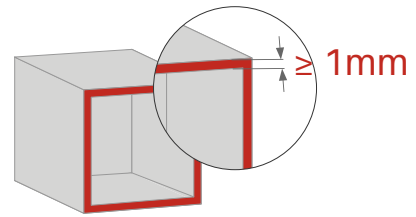
**TOLERANCES:**

± 0.3 mm is standard.



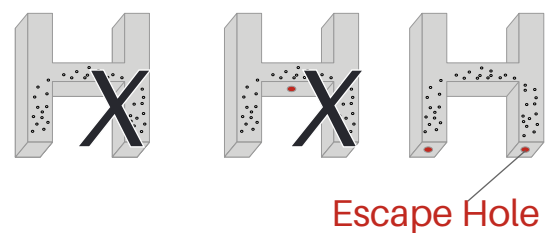
**WALLS:**

HLH recommend a wall thickness of at least 1 mm. Large parts may require larger wall thicknesses or added ribs or fillets for reinforcement.



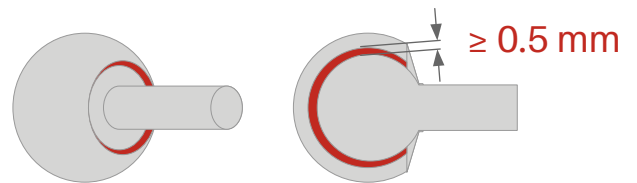
**HOLLOWING:**

We advise hollowing out a solid model as much as possible, and when the wall thickness exceeds 20 mm. This will save material and prevent sink marks. Holes is 2 mm, with a minimum of 1 mm.



**MATING PARTS:**

Minimum 0.5mm gap between axel and bore or other moving parts.



**EMBOSSSED AND ENGRAVED DETAILS:**

For embossed or engraved textures, we advise a minimum thickness of 0.25 mm. we recommend letters with a minimum line thickness of 0.5 mm, a depth of 1 mm, and an overall height of at least 2.5 mm.

