

## 3D Process Comparison Chart

	FDM	SLA	SLS	MJF	ADAM	DMLS	POLYJET	CLIP
<b>Applications</b>	Manufacturing Tooling Final Part Production Functional prototypes Gauges End Effectors Material & Durability Testing Heat Resistance	Fit Checks Master Patterns Rapid Tooling High Surface Finishes Part Accuracy Heat Resistance Moisture Resistance Clear Finishes Bio-Compatibility	Fit Checks Master Patterns Material & Durability Testing End Use Production Heat & Moisture Resistance UL 94-Rated Bio-Compatibility	Form, Fit & Function Prototyping Snap Fits Master Patterns Material & Durability Testing End Use Production Heat Resistance Color Printing	Mfg. Tooling Final Part Production Functional Prototypes Gauges End Effectors Material & Durability Testing Heat Resistance Maintenance Repair Operations (MRO)	Direct tooling inserts Production parts Functional Prototypes Machined/Cast Production Part Replacement	Fit Checks Rapid Tooling High Surface Finishes Part Accuracy Marketing Samples Heat Resistance Clear Finishes Overmold Processing Color Printing	Fit Checks Material & Durability Testing Master Patterns Rapid Tooling Fixtures High Surface Finishes Part Accuracy End Use Production Heat & Moisture Resistance
<b>Build Volume</b>	24" x 36" x 24"	20" x 20" x 11"	26" x 15" x 22"	15" x 11" x 15"	11.8" x 8.66" x 7.08"	8" x 5" x 5"	20" x 15" x 8"	7.4" x 4.6" x 12.8"
<b>Layer Thickness</b>	0.002"	0.004", 0.006"	0.004"	0.003"	100 microns	100 microns	0.006" to 0.00055"	To 60 microns
<b>Material Options</b>	Nylon 6, Carbon Fiber Kevlar, Fiberglass & HSHT Fiberglass, ABS- M30, PC/PC-ISO, Ultem	Accura Xtreme Grey ABS, Accura SL7810 White ABS, Accura SL 5530 Amber, Accura SL 7545 Clear, Accura SL 7870 ClearVue Clear ABS, Somos Evolve 128 White ABS, Polypropylene	Nylon PA (Polyamide)  Nylon GF (Glass Filled)	PA12 (Nylon)	17-4 Stainless Steel, 316L Stainless Steel, A-2 Tool Steel, D-2 Tool Steel, Titanium Ti-6Al-4V, 7075 Aluminum, 6061 Aluminum, Inconel 625	Maraging Steel MS1, Nickel Alloy IN718, Stainless Steel GP1, Stainless Steel PH1, Cobalt Chrome MP1, Aluminum AlSi10Mg, Titanium Ti64	Vero Rigid Polypropylene Clear Digital ABS	(RPU) Rigid Polyurethane, (FPU) Flexible Polyurethane (EPU) Elastomeric Polyurethane, (CE) Cyanate Ester, (EPX) Epoxy, (UMA) Urethane Meth- acrylate, (DPR) Dental, (SIL) Silicone
<b>Finish Options</b>	F1: Quick Finish F4: Primer Finish F5: Painted Finish Metal Finish: G1/ Primer/ Plated	F1: Quick Finish F2: Bead Blast F3: Smooth Finish F4: Paint Ready F5: Painted Finish Mold Ready Finish Quick Cast Finish Quick Clear Finish Supreme Clear	F2: Bead Blast F4: Primer F5: Painted Finish Dyed Finish	F2: Bead Blast F4: Primer F5: Painted Finish	F1: Quick Finish	F1: Quick Finish		F1: Quick Finish F5: Painted Finish Supreme Clear
<b>Lead Times</b>	Standard 3 – 5 days	Standard 3 – 5 days	Standard 5 – 7 days	Standard 5 – 7 days	Ships in 2 weeks	Ships in 2 weeks	Standard 5 – 7 days	Standard 5 – 7 days
<b>Minimum Feature Size</b>	0.025"	0.025 – 0.035"	0.030"	0.030"	0.025"	0.025"	0.030"	0.025 – 0.035"