

3D printing standards

Process	Min. wall thickness	Layer height	Max. build size	Tolerance
FDM	1.0 mm	100 – 300 μm	500 * 500 * 500 mm	$\pm 0.3\%$ with a lower limit of ± 0.3 mm (± 0.012 ")
SLA	1.0 mm	50 – 100 μm	250 * 250 * 250 mm	$\pm 0.5\%$ with a lower limit of ± 0.5 mm (± 0.020 ")
PolyJet	/	32 μm	380 x 250 x 200 mm	$\pm 0.1\%$ with a lower limit of ± 0.1 mm (± 0.004 ")
SLS	1.0 mm	100 μm	420 * 500 * 420 mm	$\pm 0.5\%$ with a lower limit of ± 0.15 mm (± 0.006 ")