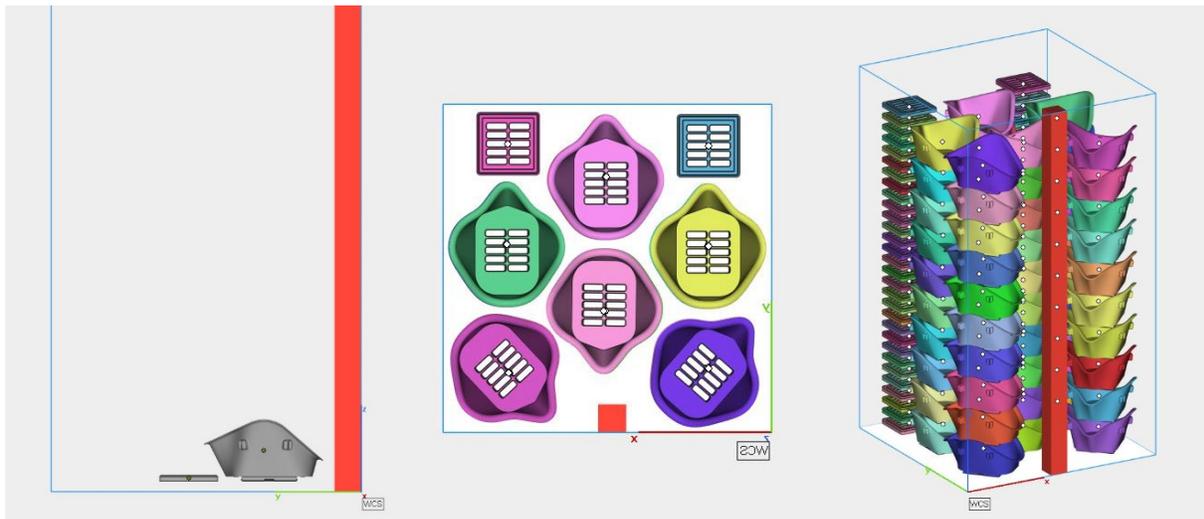




Manufacturing Guidance for 3D Printed Nylon Surgical Masks

Build Orientation

- For most efficient nesting and good print quality, place front portion of mask facing down and stack vertically.
- We recommend placing the filter enclosure cover in horizontal orientation to ensure consistent scaling. Grouping the filter enclosure covers together in a cage can speed up post-processing by allowing parts to be cleaned together rather than individually.
- You can nest parts as close as 1.5 mm for good and consistent part quality.
- Exemplary nesting of a P396:



Individual orientation

Top view

Full job (60 pairs)

- Total build quantity and layout will vary per system type (P1/P3/P7).

Machine Parameters

- Depending on the system you have available, we recommend using

	P110 or older	P396 or older	P770 or older
Parameter Setting (PPP)	EOS (PA2200_100_xxx)	EOS (PA2200_120_x_Balance)	EOS (PA2200_120_x_Balance)
Material EOS PA2200 blend ratio	50-50 (virgin/recycled)	50-50 (virgin/recycled)	50-50 (virgin/recycled)

With proper powder handling including an MQS, you can also run at a 40-60 ratio (virgin/recycled).



Post Processing

- Break out parts from print cake (ensure print cake temperature $\leq 60^{\circ}\text{C}$ to prevent warping).
- Remove excess powder from parts.
- Blast parts with glass bead media for further depowdering.
- Rinse parts with water to remove remaining media and dry parts using compressed air.