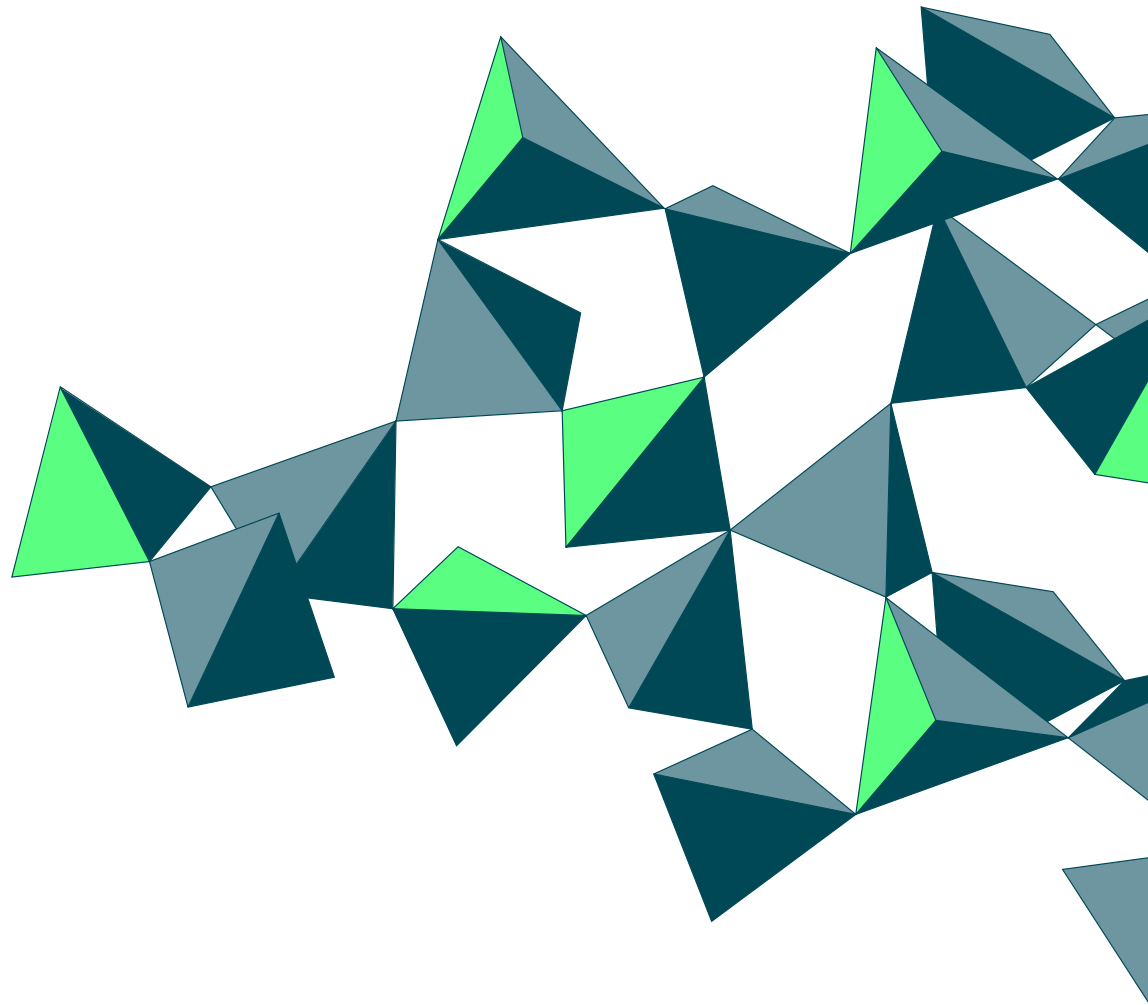


General Multi-Material Guidelines



Multi-Material Part Guidelines

ACEO® multi-material printing with silicones



ACEO® offers 3D multi-material printing of one part with up to four different silicones. The print process enables the combination of different hardness and/or colors.



Three materials printed in one go ...

For 3D parts that need support material, three different silicones can be used in combination with the support material.



Side view: three materials printed with support material (blue)

Any ACEO® Silicone GP material can be used. The material portfolio is described in the section “Available Silicone Elastomers” on page 10 of the General Design Guidelines.

This chapter provides design guidelines for multi-material parts including tips on organizing CAD files for ordering.

General Design Guidelines apply

To achieve the best print results for your multi-material model, we recommend you to follow the ACEO® guidelines described in the [“General Design Guidelines”](#) document. For special requirements we provide the [“Multi-Material Guidelines – Electrically Conductive”](#) and [“Multi-Material Guidelines – Hard/Soft Combinations”](#). Please note that comments on quality and visual appearance also apply to multi-material parts.

Multi-Material Guidelines

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Multi-Material CAD Model

Design Guidelines specific to multi-material silicone parts

In addition to the standard Design Guidelines for single material parts, there are a number of things to watch for multi-material designs:



- ▶ Avoid gaps between segments – especially in z-direction – as these would be filled with support material during printing



- ▶ If gaps are intended, please make sure you design channels to allow the support material to be washed out after printing



- ▶ Adjacent segments must be properly aligned to avoid unwanted gaps or overlaps and so that the edges form a uniform surface



- ▶ Misaligned segments need to be re-designed as they would cause issues during the print process

Preparing a multi-material CAD model

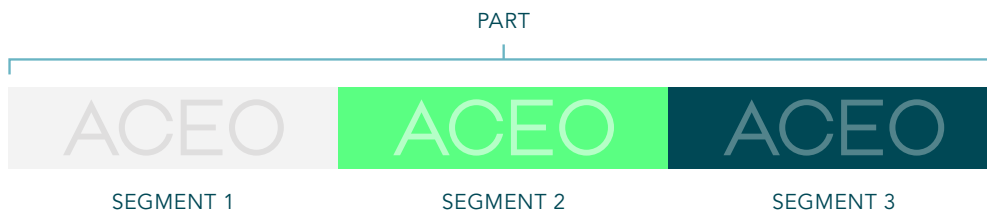
Definition: we define a “part” as the total printed product. A multi-material part consists of different materials for which the geometries need to be defined. For clarity reasons, we call these “segments”.

Multi-Material Guidelines

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Specific Guidelines

Multi-Material CAD Model



Multiple CAD Files

- ▶ Create files for each of the segments with the different material and/or color combination you desire
- ▶ You can combine multiple segments in one file as long as they represent only one material/color combination
- ▶ Create one file that contains all segments of the multi-material part. This file serves as an overview of your part and all contained segments
- ▶ Important: please make sure that your CAD-Software also exports the spatial relation between the different segments into the file. Otherwise we may not be able to reconstruct the alignment of the segments that make the part
- ▶ Export all files in “STEP” or “STL” format

CAD File Name Conventions

- ▶ Create one file that contains all segments of the multi-material part, file name convention: “MM_Part_<your file name>.ext”



- ▶ This file serves as an overview of your part and all contained segments
Example: MM_Part_MyTestFile.STL

- ▶ Create files for each of the segments, file name convention: "MM_Segment_0X_<Hardness>_<Color>_<your file name>.ext",
- ▶ Where "0X" stands for the segment number sequence like 01, 02, etc.
Example:



MM_Segment_01_ShoreA40_White_Cube.STL



MM_Segment_02_ShoreA40_Black_Cube.STL



MM_Segment_03_ShoreA30_Orange_Cube.ST

Multi-Material Guidelines

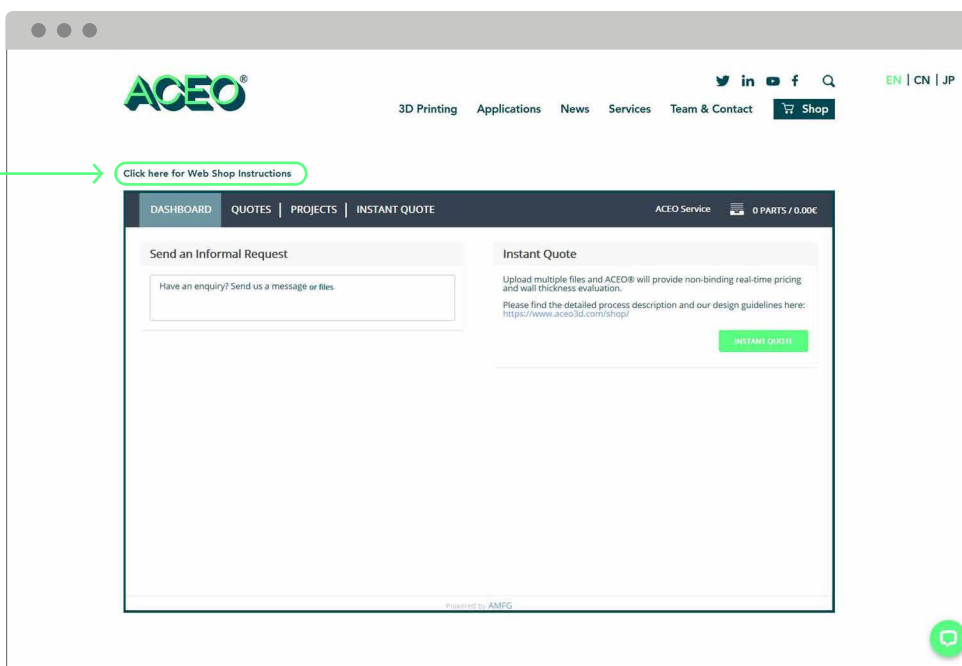
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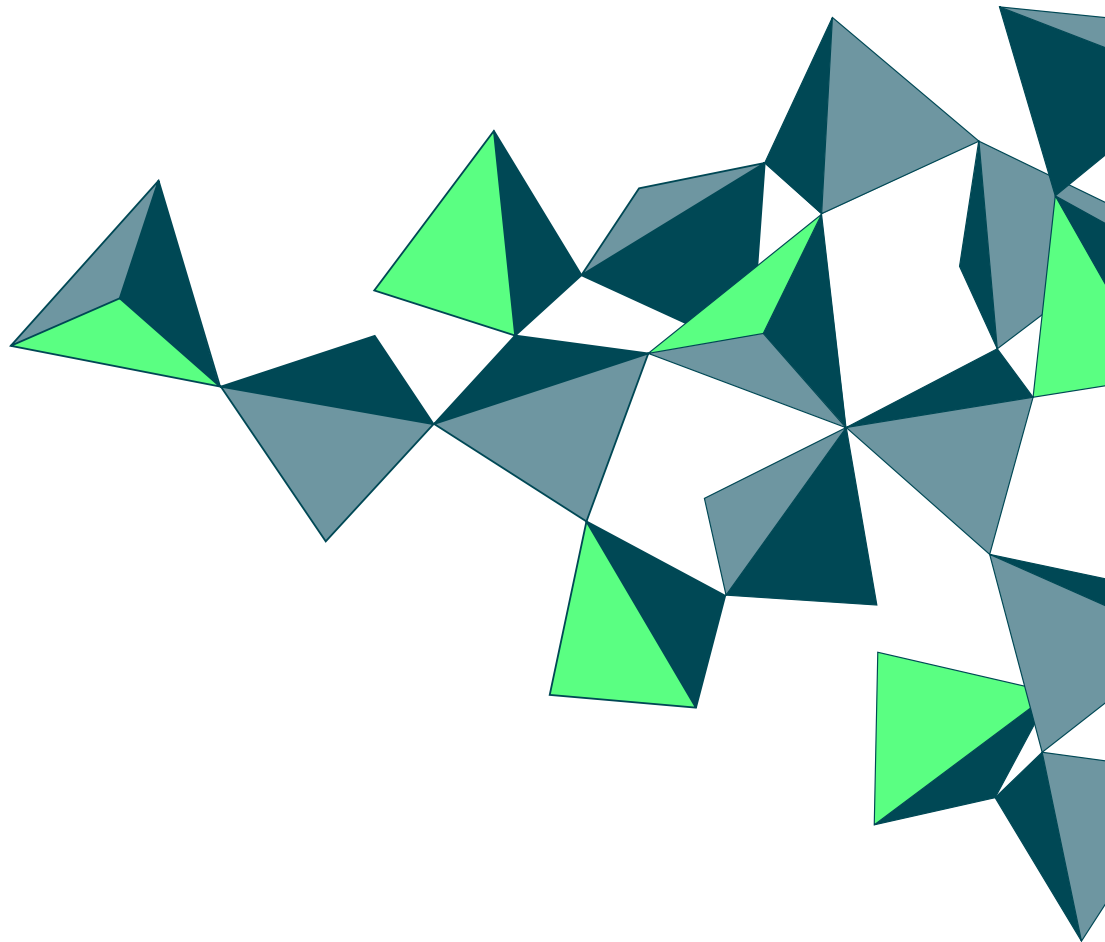
Uploading your set of files to the ACEO® web shop

When you start a new project please review our PDF document with instructions how to order a multi-material part. This document can be downloaded from the web shop start screen (see screen shot below) and provides information on how to prepare your CAD files and how to navigate the multi-material order process





IMAGINE ...
what could be your novel product design?



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