



**DYEMANSION ON-DEMAND
FINISHING & TRYMANSION
GUIDELINES**

GENERAL INFORMATION

TryMansion is our offer for first free of charge benchmarks. For small volumes we offer our finishing and coloring solutions as On-Demand Finishing.

These guidelines provide all important informations you have to know and facilitate the ordering process.

WE KINDLY ASK YOU TO ENCLOSE A COMPLETED ORDER FORM WITH EVERY DELIVERY FOR OUR ON-DEMAND FINISHING.

The order form for our On-Demand Finishing can be downloaded and filled out [here](#). If you would like to attach your own order form, it should contain the following information:



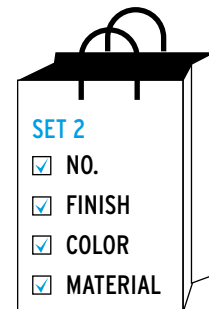
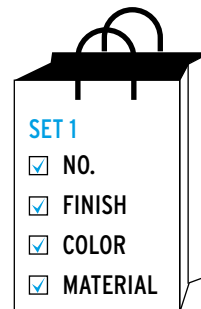
- Company name
- Contact person
- Exact color specification
- Desired finish
- Material specification of parts
- Number of parts per set
- Total weight of parts per set
- Delivery address
- Customer reference number (if available)

TRYMANSION: TRY DYEMANSION TECHNOLOGY FREE OF CHARGE

Here we accept **non-depowdered** parts. In our TryMansion Service we can process maximum of 3 parts per set and a total of 5 sets.

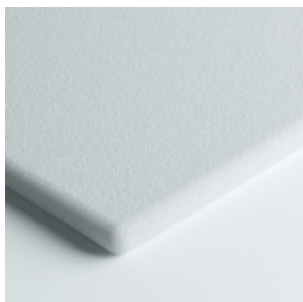


To make the process easier, please pack the sets individually and label them accordingly with the information listed here.

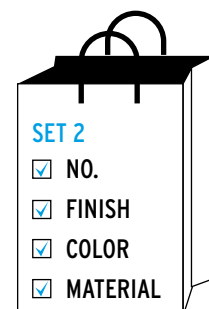
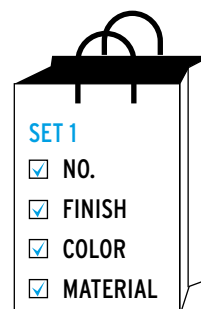


ON-DEMAND FINISHING: FAST FINISHING SERVICE FOR SMALL ORDERS

Here we accept only already **depowdered** parts.



To make the process easier, please pack the sets individually and label them accordingly with the information listed here.













COMPATIBLE TECHNOLOGIES

The entire DyeMansion Print-to-Product workflow and every single process step is compatible with all Powder Bed Fusion technologies for example with SLS (Selective Laser Sintering) and MJF (Multi Jet Fusion) / HSS (High Speed Sintering). Process parameters and temperature curves can be adapted to the respective needs.

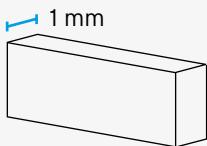
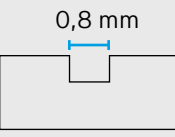

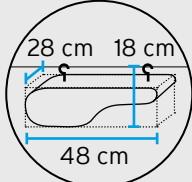
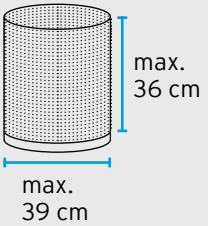


Parts that have been produced with other technologies such as FDM / FFF, SLA, DLP or CDLP / CLIP are welcome on request.

Ready-to-use VaporFuse Surfacing processes are available for the following materials: PA12, PA11 and TPU (X92A-2). Other materials are welcome on request.

COLOR OPTIONS & RAW MATERIAL

COLOR OPTIONS	WHITE RAW MATERIAL	GRAY RAW MATERIAL
STANDARD COLORS	 Developed for PA2200 with PSS finish. Colors can deviate in other materials and/or other finishes.	 Deviation due to the gray base material.
COLOR SYSTEMS (E.G., RAL)	 The RAL Classic (semi matt) colors offered by DyeMansion have been developed on PA2200 with the DyeMansion PSS finish. Colors can deviate on other materials and/or other finishes.	 Limited variety, dark colors and Black possible.
COLOR OF CHOICE		 Limited variety, dark colors and Black possible.
AUTOMOTIVE COLORS ^x (TRYMANSION ONLY)		 Limited variety, dark colors and Black possible.
NEON COLORS ^x		

BASIC REQUIREMENTS

	CLEANING (TRYMANSION ONLY)	POLYSHOT SURFACING (PSS)	VAPORFUSE SURFACING (VFS)	DEEPDYE COLORING (DDC)
MIN. WALL THICKNESS				
MIN. GAP DIMENSION				—
PARTS MOUNTING (HOOK)	—	—		—
MAX. DIMENSIONS	Non-limiting	Non-limiting	 <p>Possible from 01/01/20: maximum (LxWxH) 57 x 30 x 27 cm</p>	
MOVING PARTS	✓	✓	✗	✓
ENCLOSED POWDER HULL-AND-CORE	✓	✓	✓	✗
HOLLOW SPACES 	Limited	Limited	Limited	Limited
UNDERCUTS 	Limited	Limited	✓	✓

IMPORTANT NOTES

GENERAL

In order to keep the required delivery time to a minimum, small parts (<1.5 g) from a quantity of 100 items are no longer individually counted in the incoming and outgoing goods inspections, but are check weighed. Therefore, excess or short deliveries of parts of up to 5 % cannot be objected to. Likewise, there may be color deviations on small parts, as they may not be able to be blasted.

CLEANING & POLYSHOT SURFACING

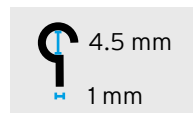
Please note that filigrane structures can break during automated depowdering as well as PolyShot Surfacing.

If the minimum gap dimension is not taken into account, PolyShot Surfacing may cause blasting material to stick in gaps of the parts (e.g. in writing). If this involves a great deal of effort to remove the blasting material, DyeMansion reserves the right to charge for the additional work (see price list) or to ship the components not free of blasting material.

For a glossier look, PolyShot Surfacing is repeated by default after DeepDye Coloring.

VAPORFUSE SURFACING

For the mounting in the DyeMansion Powerfuse S the parts require a hook. For heavy parts (about 400 g) we recommend to construct two hooks.



The hook should have an inside diameter of 4.5 mm and the fixing point a diameter of 1 mm.

If the part is not equipped with suitable mounting, DyeMansion can provide the mounting for an extra fee.

Powder residues on the parts can lead to formation of bubbles. In addition, we recommend rounding off inside edges with an angle $\leq 90^\circ$ in order to prevent formation of bubbles.

The surface is not smoothed at the spots where the mounting was located. At these spots there may be color deviations.

DEEPDYE COLORING

It should be noted that the spots that were damaged during the removal of powder (burned surface) cannot be colored correctly. We recommend at least 30 cm distance and maximum 3 bar.

For materials without titanium dioxide, the translucency of the material can lead to larger color deviations. For materials containing titanium dioxide, similar effects occur only at wall thicknesses below 1.5 mm.

Powder residues on the parts can lead to color deviations and inhomogeneous coloring.



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