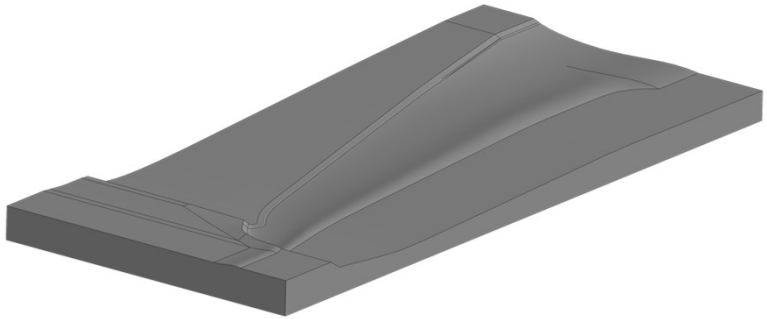
Massivit M1000

Composite Lay-up tool Time and Material Estimate

Adjusted a model

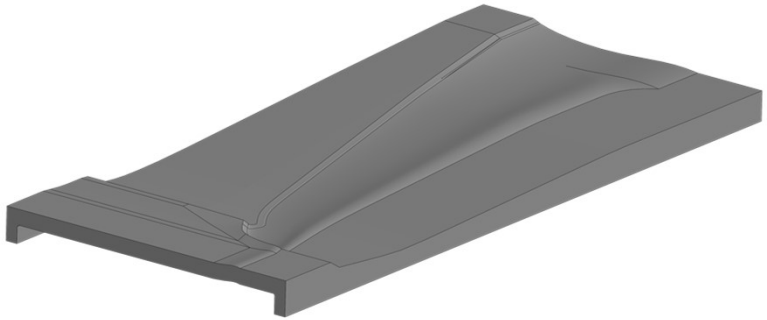
Adjustment was preformed to the part to accommodate a maximum thickness of 25 mm, this is to avoid high exothermal reaction during printing, by doing so we save casting material & reduced tool wight. Additionally, having a unified thickness will aid with heat transfer in an autoclave process.

Original Part



6.70 US gallon

Adjusted Part



4.40 US gallon

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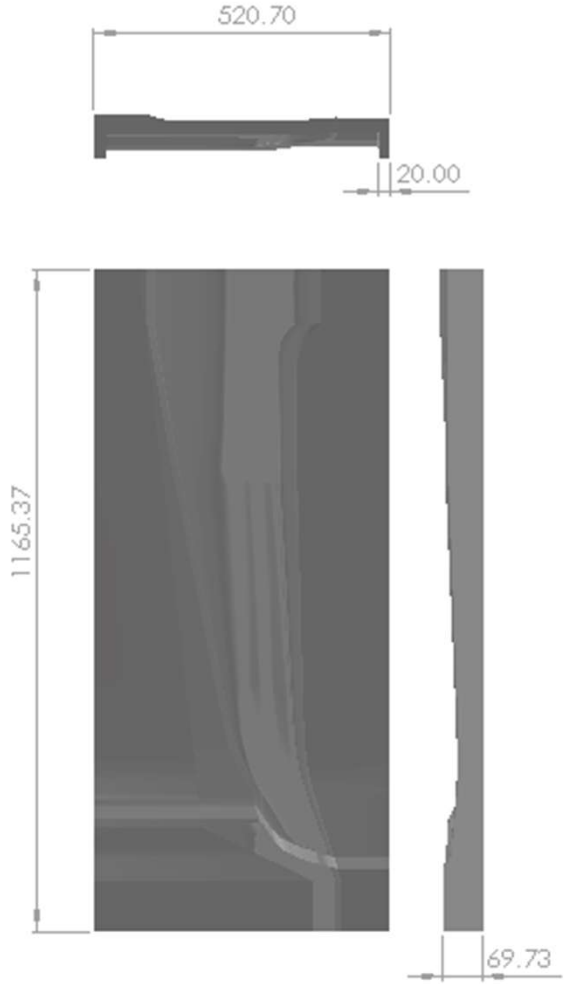
Size & dimensions



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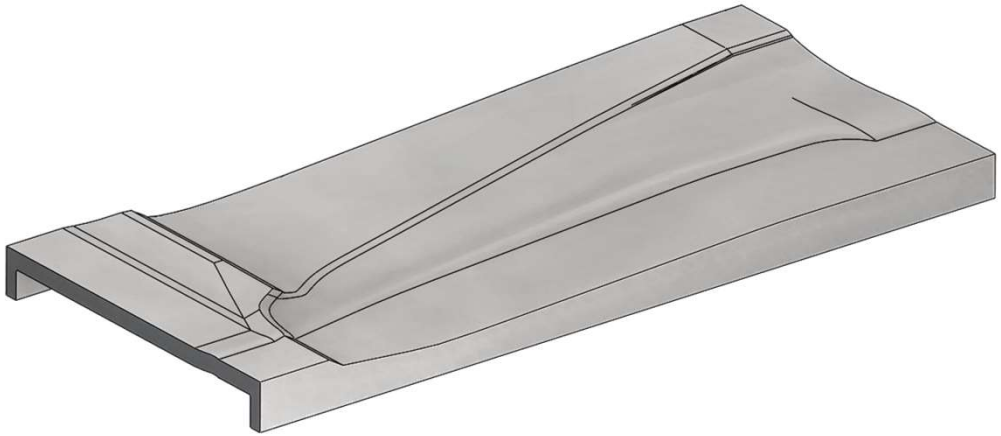
Details

Part:	Layer Thickness:	Casting cure material	Printing shell Material (Washable)	Total weight (Out of the printer)	Print time	Total weight (after shell removal)
L Lower V2 M10K	1 mm	17 Kg	7.8 Kg	24.8 Kg	21:32 hours	17 Kg



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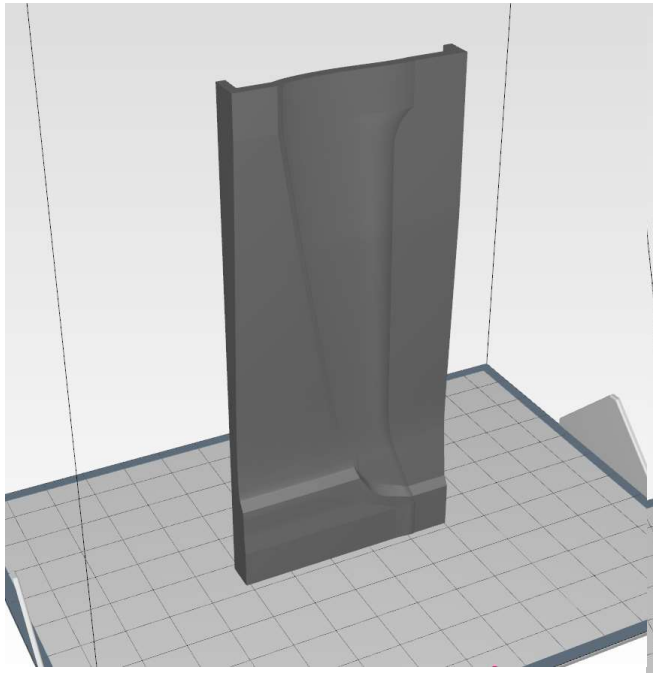
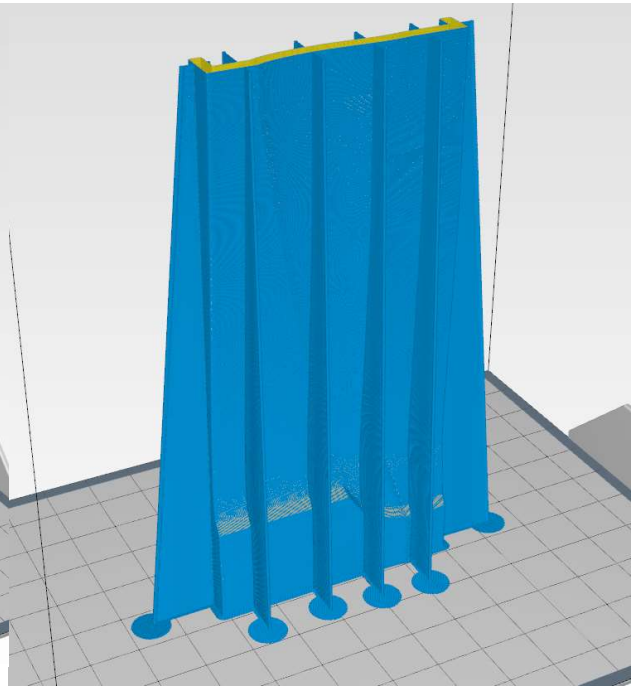
Printing orientation

Printing orientation:
Orientating the part standing on end ensures the best surface quality for the mold surface.



STL file



Tool path

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Thank You