MASSIVit 3D

Cascade Pump Company HLC100 casting pattern

Estimation

Size

295.91 mm / 11.65 in

431.8 mm / 17 in

431.8 mm / 17 in

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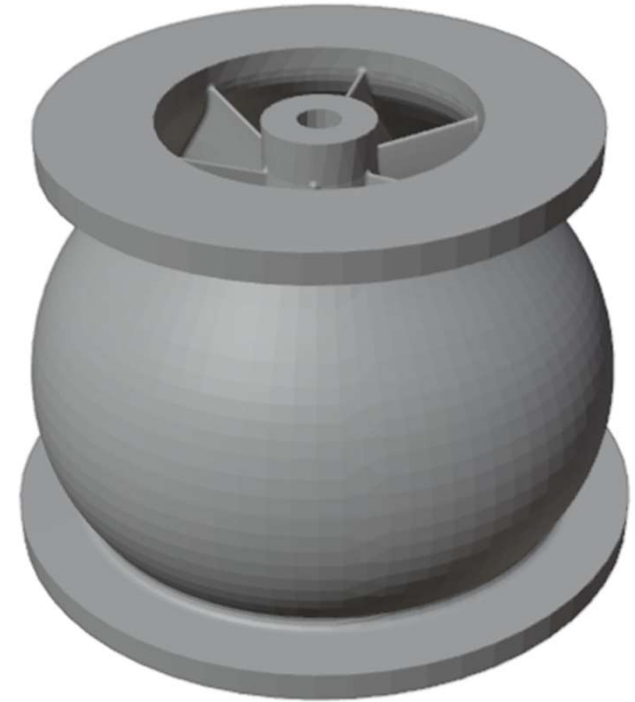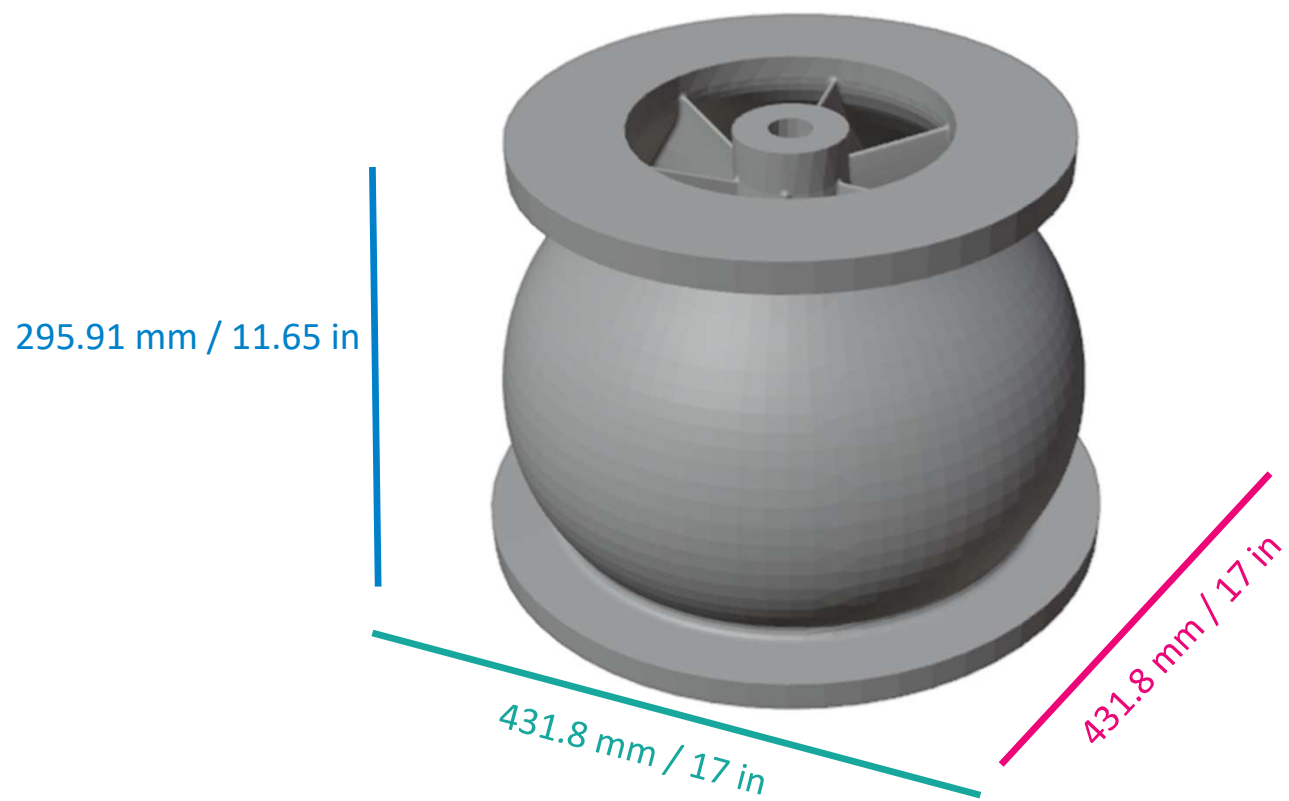
Data

Print Mode	Layer Thickness (mm)	Wall Width (mm)	Time (Hours)	Material (Kg)
Normal Mega	1.3 mm	3.2 mm	08:18	6.60
Normal Double	1.3 mm	4.4 mm	09:49	7.70
Quality Mega	1.0 mm	2.85 mm	11:15	5.64
Quality Double	1.0 mm	3.6 mm	16.20	5.85
High-Resolution double	0.8 mm	3.2 mm	23:16	5.09

Material consumption/cost

Print Mode	Layer Thickness	Wall Width	Material	Dimengel 90	Dimengel 100	Dimengel 110
Normal Mega	Layer Thickness: 1.3mm	Wall Width: 3.2mm	Material: 6.60kg	Dimengel 90: $ 435.60	Dimengel 100: $ 660.00	Dimengel 110: $ 660.00
Normal Double	Layer Thickness: 1.3mm	Wall Width: 4.4mm	Material: 7.70kg	Dimengel 90: $ 508.20	Dimengel 100: $ 770.00	Dimengel 110: $ 770.00
Quality Mega	Layer Thickness: 1.0mm	Wall Width: 2.85mm	Material: 5.64kg	Dimengel 90: $ 372.24	Dimengel 100: $ 564.00	Dimengel 110: $ 564.00
Quality Double	Layer Thickness: 1.0mm	Wall Width: 3.6mm	Material: 5.85kg	Dimengel 90: $ 386.10	Dimengel 100: $ 585.00	Dimengel 110: $ 585.00
High Resolution double	Layer Thickness: 0.8mm	Wall Width: 3.2mm	Material: 5.09kg	Dimengel 90: $ 335.94	Dimengel 100: $ 509.00	Dimengel 110: $ 509.00

Dimengel 90:	Same capabilities like Dimengel 100 but grey and less expensive:	$ 66/kg
Dimengel 100:	White translucent:	$ 100/kg
Dimengel 110:	White translucent, only available for MASSIVit 5000:	$ 100/kg

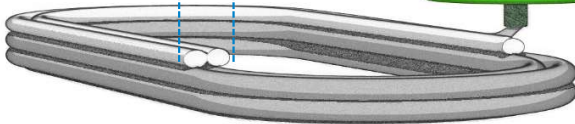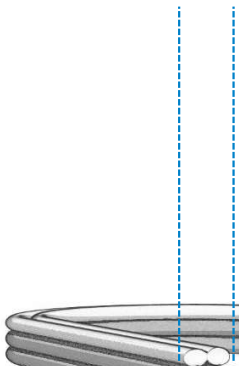MASSIVit 3D

Layer Thickness & Wall Width

If selected print mode is Quality Double the layer height stands at 1.0 mm and the wall width at 3.6 mm
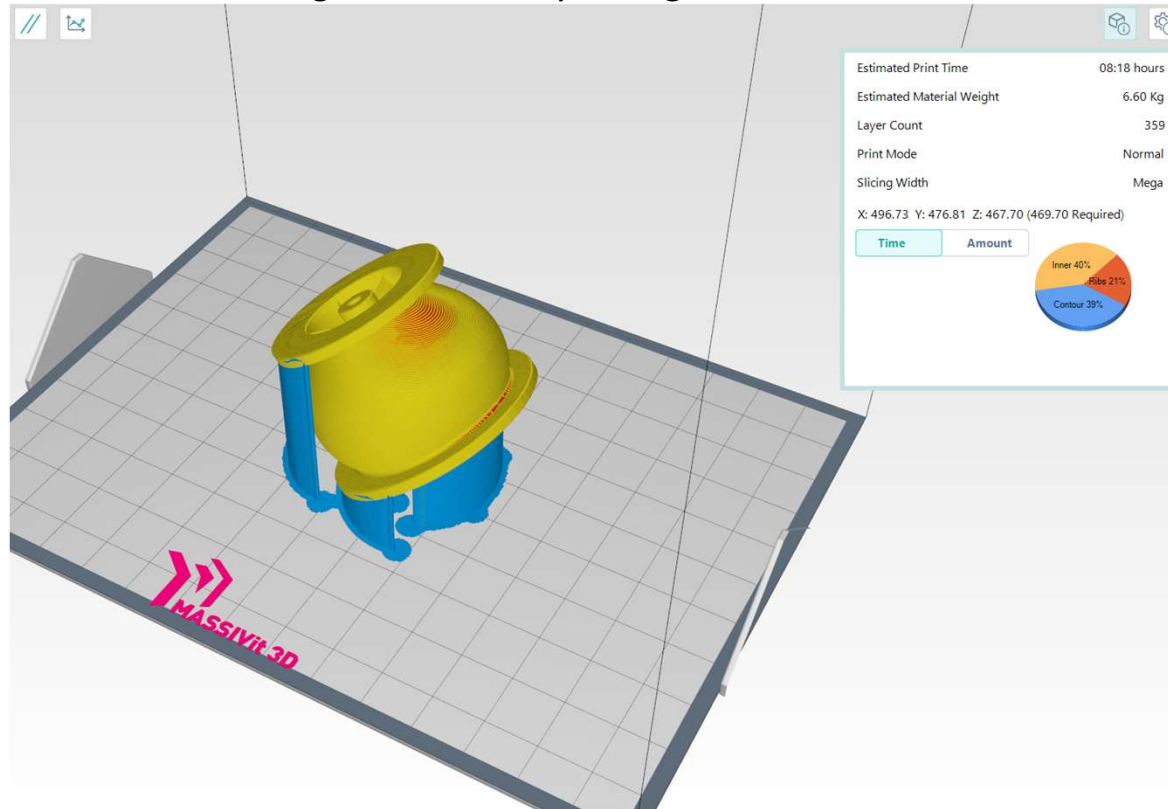
3.6 mm

1.0 mm

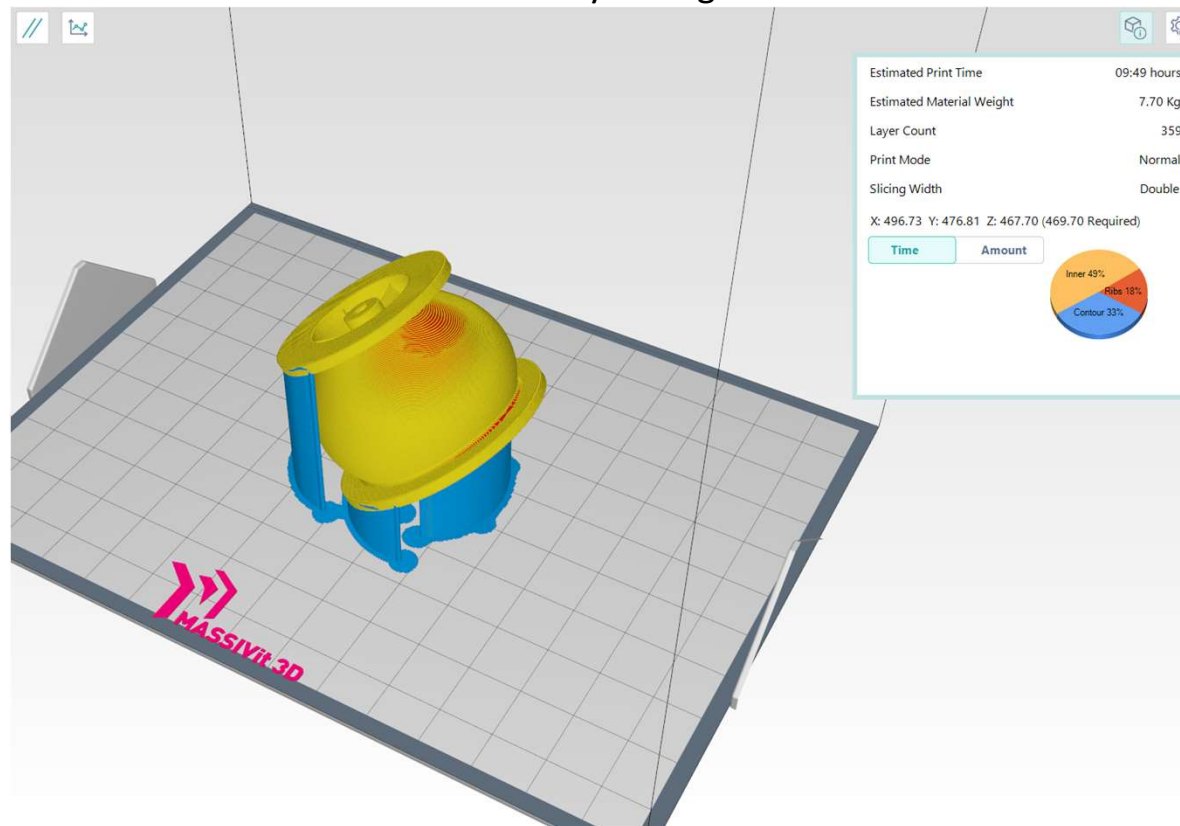Our print mode is the combination of layer thickness along with wall width.

MASSIVit 3D

Print Orientation, Mode and Support Structure

Normal Mega – 1.3 mm layer height and 3.2 mm thickness
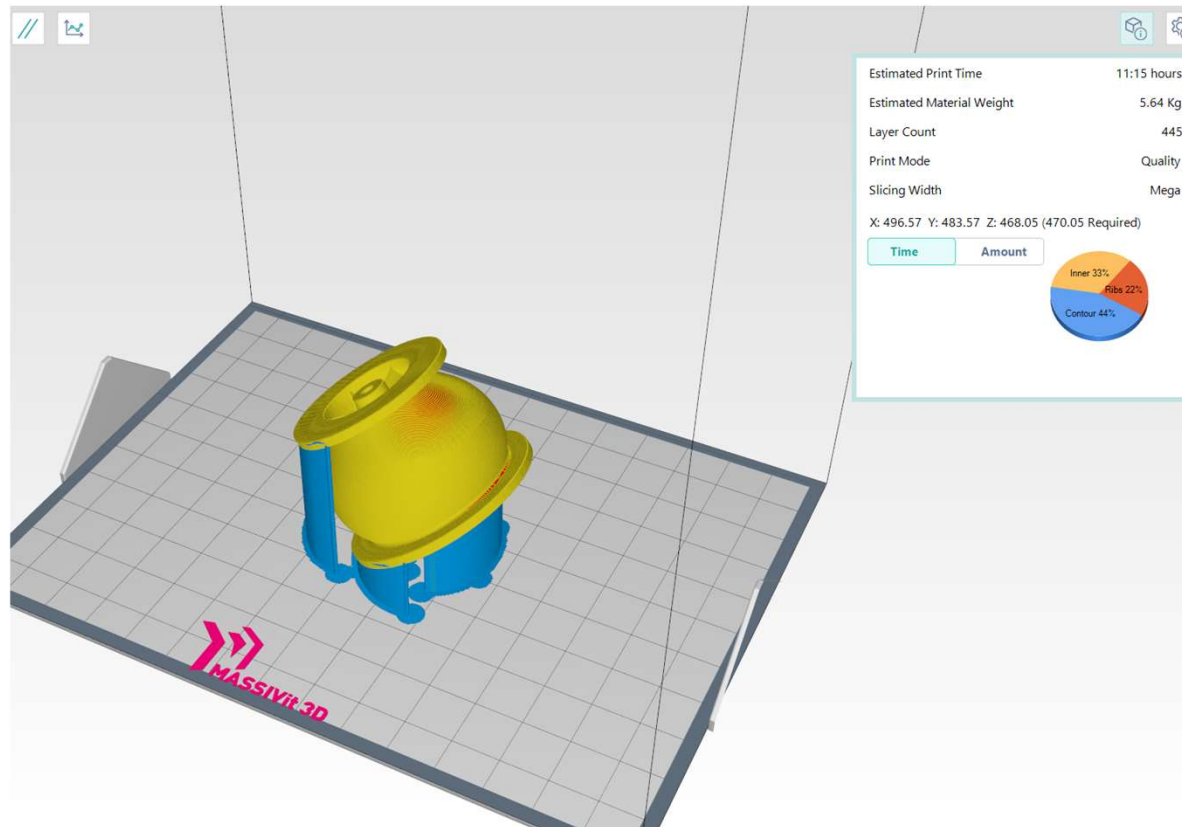
MASSIVit 3D

Print Orientation, Mode and Support Structure

Normal Double – 1.3 mm layer height and 4.4 mm thickness

Print Orientation, Mode and Support Structure

Quality Mega – 1.0 mm layer height and 2.85 mm thickness

Estimated Print Time	11:15 hours
Estimated Material Weight	5.64 Kg
Layer Count	445
Print Mode	Quality
Slicing Width	Mega

X: 496.57 Y: 483.57 Z: 468.05 (470.05 Required)

Time | Amount
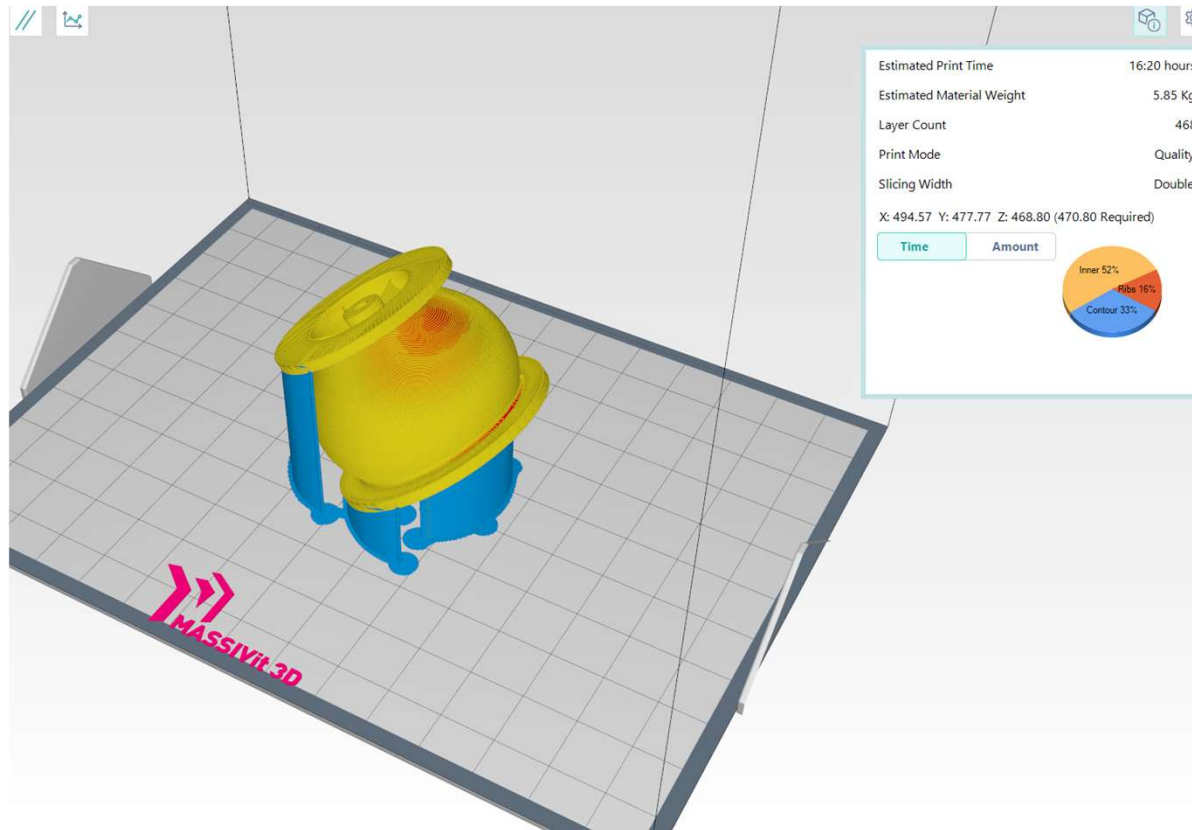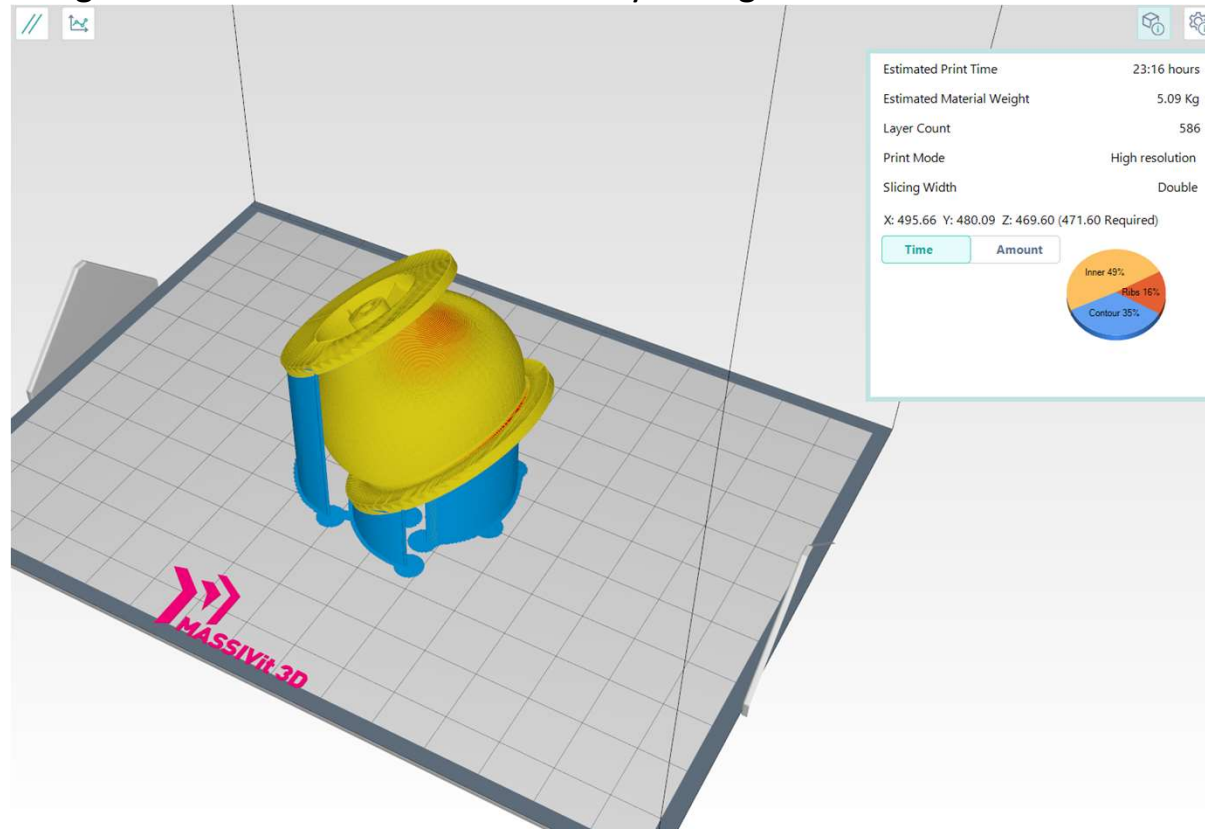
Inner 33%
Ribs 22%
Contour 44%

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Print Orientation, Mode and Support Structure
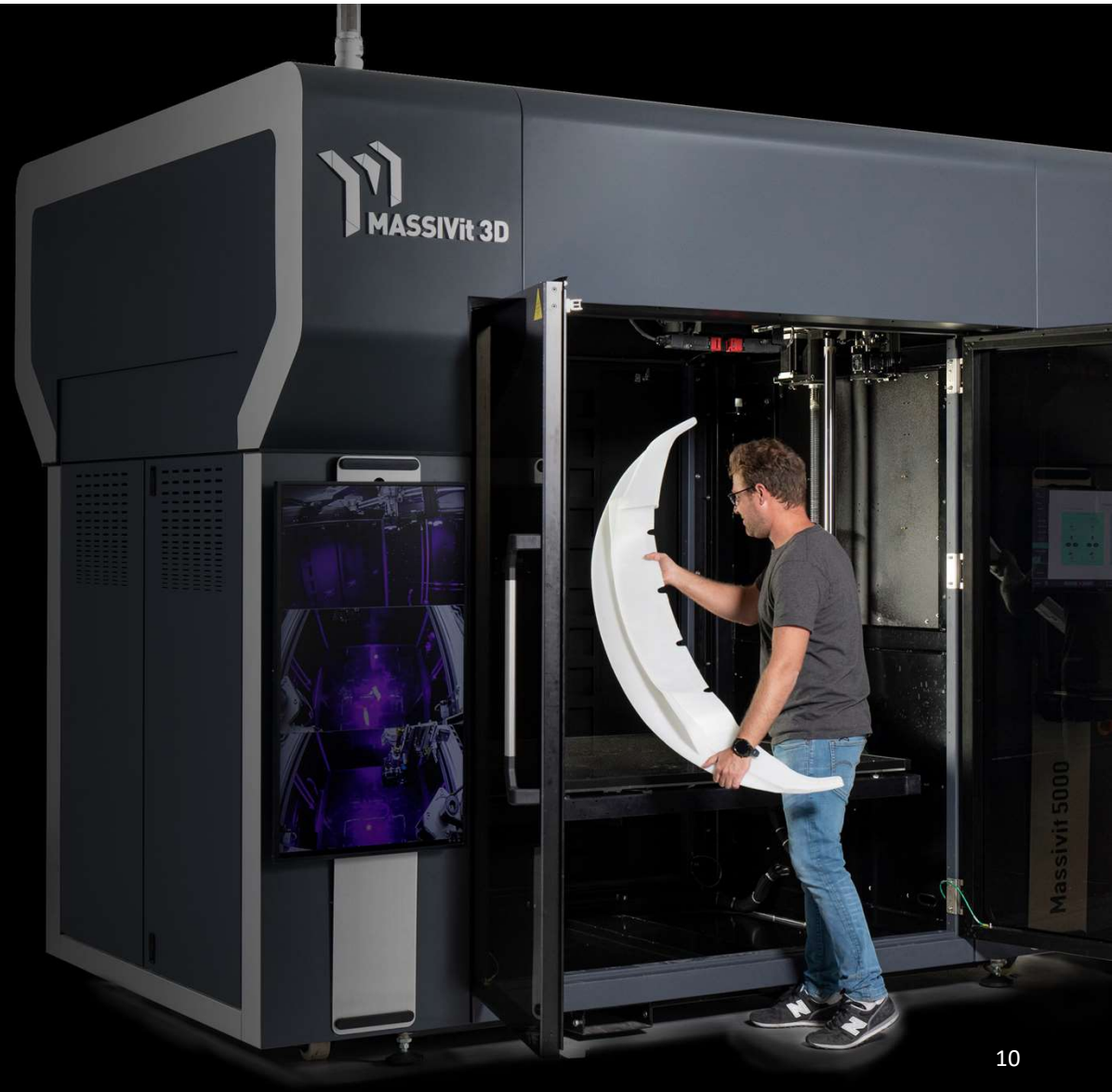
Quality Double – 1.0 mm layer height and 3.6 mm thickness

Print Orientation, Mode and Support Structure

High-Resolution Double – 0.8 mm layer height and 3.2 mm thickness

Estimated Print Time	23:16 hours
Estimated Material Weight	5.09 Kg
Layer Count	586
Print Mode	High resolution
Slicing Width	Double

X: 495.66 Y: 480.09 Z: 469.60 (471.60 Required)

Inner 49%
Ribs 16%
Contour 35%

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Thank You