



DYEMANSION ON-DEMAND FINISHING SERVICE GUIDELINES

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DYEMANSION ON-DEMAND FINISHING SERVICE OVERVIEW

Fast finishing service for smaller orders

- Smaller orders & serial orders
- Preparation of the parts
- Maximum dimensions

COMPATIBLE PRINTING TECHNOLOGIES AND MATERIALS

DyeMansion Services: On-Demand Finishing Service or TryMansion Benchmark Service

- Materials
- Compatible technologies

AVAILABLE POST-PROCESSING COMBINATIONS IN THE ON-DEMAND FINISHING SERVICE

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- Possible process combinations in the On-Demand Finishing service

PROCESS-RELEVANT GUIDELINES FOR POLYSHOT SURFACING, DEEPDYE COLORING AND VAPORFUSE SURFACING

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- PolyShot Surfacing Design Guidelines
- VaporFuse Design Guidelines
- DeepDye Coloring Guidelines

REQUEST FOR QUOTATION & ORDERING PROCESS

Overview: The ordering process

- Request for Quotation
- Sending the parts without offer

CONTACT MUNICH & AUSTIN

ON-DEMAND FINISHING SERVICE & TRYMANSION BENCHMARK
SERVICE IN MUNICH, GERMANY AND AUSTIN, UNITED STATES

DYEMANSION ON-DEMAND FINISHING SERVICE OVERVIEW

Fast finishing service for smaller jobs

SMALLER ORDERS & SERIAL ORDERS

We offer in-house finishing services for smaller orders.

The goal of our On-Demand Finishing service is to best support our customers with smaller orders and to support customers who do not yet have their own [DyeMansion workflow](#) yet.

If you want to finish series and larger orders, we have a [wide partner network](#) and can connect you with one of our production partners for series productions at any time. Please contact us for this purpose in.

PREPARATION OF THE PARTS

Our workflow also includes various systems to clean parts in a flawless automated way.

However, we do not offer de-powdering in our On-Demand Finishing Service.

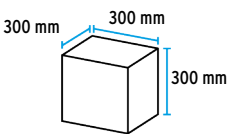
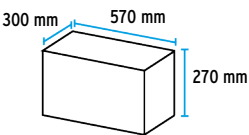
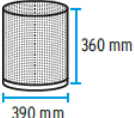
Therefore, we ask you to send your parts to us in the On-Demand Finishing Service **completely free of powder.**

If the parts show powder residues or arrive undecorated, we reserve the right to charge for the depowdering or, in case of repeated occurrence, to return the parts to you for cleaning.

In addition, the parts should already arrive sorted according to the desired sets (color, finish).

Please **separate small parts with a weight < 1.5 g.**

MAXIMUM DIMENSIONS

 <p>MAXIMUM SIZE</p>	<p>PolyShot Surfacing 300 mm x 300 mm x 300 mm (L x W x H) Larger parts possible when switching to manual operation.</p>
 <p>MAXIMUM SIZE</p>	<p>VaporFuse Surfacing 570 mm x 300 mm x 270 mm (L x W x H)</p>
 <p>MAXIMUM SIZE</p>	<p>DeepDye Coloring 390 mm x 360 mm (Ø x H)</p>

COMPATIBLE PRINTING TECHNOLOGIES AND MATERIALS

DYEMANSION SERVICES: ON-DEMAND FINISHING SERVICE OR TRYMANSION BENCHMARK SERVICE

MATERIALS

Please let us know which material you would like us to process when you make your inquiry.
An exact material specification is essential for the process adaptation of the individual processing steps.

If we have not yet defined exact processes for your desired material, we will be happy to offer you a test as part of a free feasibility study.

If you have any uncertainties regarding the material, please feel free to contact your [ODS_contact](#).

COMPATIBLE TECHNOLOGIES

Available for On-Demand Finishing service:



SLS



MJF
SAF
HSS

The most common hard & flexible polymers of the categories: PA 11, PA 12 & TPU .

Additional materials can be requested as a Trymansion (Free Feasibiltiy study):



FDM
FFF



SLA



DLP





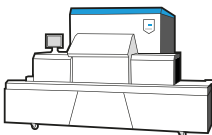


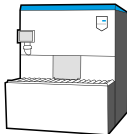

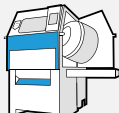
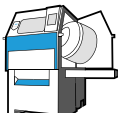


CDLP
CLIP

AVAILABLE POST-PROCESSING COMBINATIONS IN THE ON-DEMAND FINISHING SERVICE

FINISHING OPTIONS OVERVIEW

ASSIGNED PROCESSES TO MACHINES

CLEANING	SURFACING		COLORING
		OR	
PolyShot Cleaning* PSC	PolyShot Surfacing PSS	VaporFuse Surfacing VFS	DeepDye Coloring DDC
			
Powershot DUAL Performance	Powerfuse S & Powerfuse S PP automatic loading		
			
Powershot C Performance	Powershot S Performance	Powerfuse S & Powerfuse S PP manual loading	DM60 & DM60 Black
			
Powershot C	Powershot S		

*PolyShot Cleaning (depowdering) is offered for TryMansion Benchmark Service only, not for On-Demand Finishing Service jobs.

For more information on our systems, please visit our website at <https://dyemansion.com/products/> or send us an inquiry via the [contact](#) form.

POSSIBLE PROCESS COMBINATIONS IN THE ON-DEMAND FINISHING SERVICE

LIGHT BASE MATERIAL

Surface finishing		PolyShot Surfacing (PSS)		VaporFuse Surfacing (VFS)	
Optional: DeepDye Coloring (DDC)		Black	All colors except black	Black	All colors except black
Material hardness	hard	DDC+PSS Final Touch	PSS Pre-Blasting + DDC + PSS Final Touch	VFS+DDC	
	elastic	No PSS, DDC only (PSS has no effect)		VFS+DDC on request tbd *1)	VFS+DDC selected color *2)

DARK BASE MATERIAL

Surface finishing		PolyShot Surfacing (PSS)		VaporFuse Surfacing (VFS)	
Optional: DeepDye Coloring (DDC)		Black	All colors except black	Black	All colors except black
Material hardness	hard	DDC+PSS Final Touch		VFS+DDC	
	elastic	No PSS, DDC only (PSS has no effect)		VFS+DDC on request, tbd *1)	VFS+DDC only on recommendation *3)

*1) Black coloration on VFS finish for elastic materials on request

*2) Selected colors are recommended. Please request

*3) Parts become almost black after vapor smoothening, so the choice of light colors is limited here



NOTE

- ✓ PSS = PolyShot Surfacing
- ✓ VFS = VaporFuse Surfacing
- ✓ DDC = DeepDye Coloring
- ✓ When coloring parts with light base material in black, the PolyShot finish is applied exclusively after coloring to allow as much dye as possible to penetrate the part
- ✓ When coloring parts with light base material in multicolored, the PolyShot finish must take place before coloring so that the surface is leveled, and the color can penetrate homogeneously into the part. Post-blasting after coloring is used for further scratch resistance, better haptics, and a glossy, elegant look.
- ✓ When coloring parts with dark base material in black & in color, the PolyShot finish is applied exclusively after coloring to allow as much dye as possible to penetrate the part
- ✓ Elastic materials are not treated with the PolyShot Finish, as this step provides no effect on these special base materials
- ✓ PolyShot Surfacing and VaporFuse Surfacing can also be done without combining with DeepDye Coloring
- ✓ The VaporFuse Surfacing takes place before the coloring process

PROCESS-RELEVANT GUIDELINES FOR POLYSHOT SURFACING, DEEPLYE COLORING AND VAPORFUSE SURFACING

IMPORTANT NOTES ON DESIGNING YOUR PARTS FOR THE BEST POSSIBLE QUALITY

We have prepared **Guidelines for you for all technologies** for which we offer processing in the On-Demand Finishing Service.

In these guidelines you can find relevant information regarding design, printing & pre-treatment to achieve the best possible quality result in combination of your print and our post-processing solutions.

[PolyShot Surfacing Guidelines](#) | [VaporFuse Surfacing Guidelines](#) | [DeepDye Coloring Guidelines](#)

REQUEST FOR QUOTATION & ORDERING PROCESS

OVERVIEW: THE ORDERING PROCESS

You are welcome to request a quote from your On-Demand Finishing Service contact at any time or send the parts directly to On-Demand Finishing Service for processing.

REQUEST FOR PROPOSAL

Please send your request to your [ODS contact person](#).

WHAT DO WE NEED FOR A QUOTATION?

- ✓ Exact material specification
- ✓ Desired finish
- ✓ Exact color specification
- ✓ STL file or optionally STEP file
- ✓ Number of parts

If you do not have an STL file available or do not want to share this information, a weight specification is also sufficient.

For better advice regarding possible sources of error or especially for VaporFuse Surfacing, we recommend that you send us the STL file as well, since better advice can be given here in advance.

Feel free to send your parts to us afterwards using the [On-Demand Service Order Form](#).

The parts should arrive already completely de-powdered.

In addition, the parts should already arrive sorted according to the desired sets (color, finish).

Please **separate small parts with a weight < 1.5 g**.

Upon receipt of the goods, you will receive an order confirmation with the date of shipment.

SENDING THE PARTS WITHOUT OFFER

Please feel free to send the parts to your ODS contact. For this purpose, you are welcome to fill out the [On -Demand Service Order Form](#) and enclose it with the parts.

The parts should arrive already completely de-powdered.

In addition, the parts should already arrive sorted according to the desired sets (color, finish).

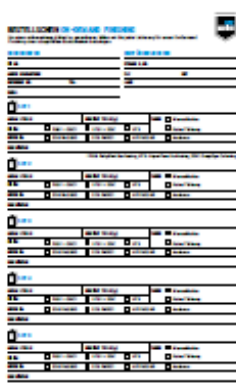
Please **separate small parts with a weight < 1.5 g.**

Upon receipt of the goods, you will receive an order confirmation with the date of shipment .

PROCESS OVERVIEW

As soon as you receive the offer, please fill in the On-Demand-Finishing order form and enclose it with your parts.

Please add parts with the same finish and color as one set in the order form. For each additional combination of finish and color, please add another set to the order form.




Please pack all parts of a set together and label the set with the corresponding number. In this way, your components can be clearly assigned to the sets on the order form.



Please enclose the filled out delivery bill with your parts and send the package to the appropriate address in Munich or Austin, TX (see next page).

CONTACT MUNICH & AUSTIN

ON-DEMAND FINISHING SERVICE IN MUNICH, GERMANY
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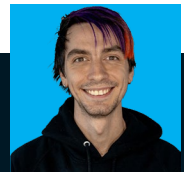
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