

FINISHING OPTIONS



SERVICE	SURFACE FINISH	DESCRIPTION
AM: SLA/SLS	Basic and Blast	Removal of all build support evidence and an even bead blasted finish
AM: SLA/SLS	Basic and Lacquer	Removal of all build support evidence and a coat of clear lacquer
AM: SLA	Delayer and Blast	Removal of all build support and layering evidence (where necessary) and an even bead blasted finish
AM: SLA	Delayer and Lacquer	Removal of all build support and layering evidence (very often on A and B surfaces where necessary) and a coat of clear lacquer
AM: SLA	Delayer, Lacquer and Polish	Removal of all build support and layering evidence (Very often on A and B surfaces where necessary) and a coat of clear lacquer and polish
RAPID TECHNOLOGIES: RIM/VAC	Smooth for Tooling	Other than heavily layered vertical surfaces which may need a level of delayering, apply a coat of primer and a rub back with a superfine pad to remove the dryness of the overspray, leaving a smooth to touch finish
AM: SLA/SLS RAPID TECHNOLOGIES: RIM/VAC	Functional Smooth	Fully delayer and rub back necessary surfaces and apply a coat of primer. Rework particularly bad areas if necessary. The final finish may still have a level of visible layering, imperfections and scratches.
AM: SLA/SLS RAPID TECHNOLOGIES: RIM/VAC AM: SLA/SLS RAPID TECHNOLOGIES: RIM/VAC	Functional smooth/Primer smooth Primer Smooth	Better than a Functional smooth but does not need to be as good as a primer smooth. (more layering, imperfections and scratches removed) Fully delayered on necessary surfaces and a smooth coat of primer. Removal of all imperfections and layering evidence
AM: SLA/SLS RAPID TECHNOLOGIES: RIM/VAC	Primer Smooth and Polish	Finish to primer smooth + smooth back and polish surfaces up to 4000/6000 Micro Mesh. This is to simulate what Toolmakers refer to as a "commercial polish"
AM: SLA/SLS RAPID TECHNOLOGIES: RIM/VAC	Satin Smooth	Finish to primer smooth + smooth application of necessary colour
AM: SLA/SLS RAPID TECHNOLOGIES: RIM/VAC	Lacquer	Finish to primer smooth + application of necessary colour + application of lacquer
AM: SLA/SLS RAPID TECHNOLOGIES: RIM/VAC	Lacquer and Polish	Finish to primer smooth + application of necessary colour + application of lacquer + highly polish
AM: SLA/SLS RAPID TECHNOLOGIES: RIM/VAC	Fine Spark VDI 30	Finish to primer smooth + application of necessary colour and 30 VDI spark texture

AM: SLA/SLS RAPID TECHNOLOGIES: RIM/VAC	Fine Spark VDI 33	Finish to primer smooth + application of necessary colour and 33 VDI spark texture
AM: SLA/SLS RAPID TECHNOLOGIES: RIM/VAC	Medium Spark VDI 36	Finish to primer smooth + application of necessary colour and 36 VDI spark texture
AM: SLA/SLS RAPID TECHNOLOGIES: RIM/VAC	Heavy Spark VDI 39	Finish to primer smooth + application of necessary colour and 39 VDI spark texture
AM: SLA/SLS RAPID TECHNOLOGIES: RIM/VAC CNC TECHNOLOGIES	Medium spatter	Finish to primer smooth + application of necessary colour and medium spatter finish (Small imperfections and scratches may be permissible as the spatter finish will disguise them)
AM: SLA/SLS RAPID TECHNOLOGIES: RIM/VAC CNC TECHNOLOGIES	Heavy spatter	Finish to primer smooth + application of necessary colour and heavy spatter finish (Small imperfections and scratches may be permissible as the spatter finish will disguise them)
AM: SLA/SLS RAPID TECHNOLOGIES: RIM/VAC CNC TECHNOLOGIES	Frosted Spark Applies to clear SLA, Vac and CNC parts	This is typically applied to areas of lenses and light guides. Perhaps a very slightly dry/sharp 30 -36 VDI finish using an eggshell finish rather than satin (this should give a slightly white appearance to a clear casting)

An Approximate guide to Gloss Levels (as a percentage)

Matt	0 - 20%
Eggshell	25% - 35%
Satin	35% - 80%
Gloss	80% - 90%
Polish (lens quality)	90% - 100%