

Parameter sheet

Machine, software and material parameters

FORMIGA P 100 / PSW 3.3

FORMIGA P 110, EOSINT P 395, EOSINT P 800 / PSW 3.6

EOSINT P 760, EOSINT P 800 / PSW 3.7

EOS P 396, EOSINT P 760, EOS P 770, EOSINT P 800, EOS P 800 / PSW 3.8

Material-specific parameters

Material-specific parameters are included in the EOS default jobs.
EOS default jobs may not be changed.

☞ Process software → **Options** menu → **HWI** options → *HWI parameters* window → *Material* tab → *Load EOS default job* button → *EOS_DefaultJobs* folder → *<material type>* folder → *<material type><layer thickness><version_number>.eosjob*

Shrinkage scaling FORMIGA P 100 / FORMIGA P 110

The materials approved for the machine are listed in the latest issue of the material information *Compatibility Material – P Machines*.

The values given are for guidance in %.

Scaling Material	FORMIGA P 100				FORMIGA P 110			
	X Axis	Y Axis	Z Axis		X Axis	Y Axis	Z Axis	
			0 mm	300 mm			0 mm	300 mm
PA 1101	4.0	4.0	3.4	2.5	4.0	4.0		
PA 1102 black	4.0	4.0	3.5	2.8	4.0	4.0	3.5	2.8
PA 2200	3.2	3.2	2.2	1.6	3.2	3.2	2.6	2.0
PA 2201	3.2	3.2	2.2	1.6	3.2	3.2	2.6	2.0
PA 2221	3.2	3.2	2.4	2.0	3.2	3.2		
PA 3200 GF	2.4	2.4	1.7	1.2	2.4	2.4	1.9	1.3
Alumide®	2.0	2.2	1.5	1.1	2.0	2.2	2.0	1.3
PrimePart® ST	2.8	3.0	2.4	1.5	3.0	3.0	2.4	1.6
PrimeCast® 101	0.7 - 1.0	0.7 - 1.0	0.0 - 0.1 *	0.0 - 0.1 *	0.7 - 1.0	0.7 - 1.0	0.0 - 0.1 *	0.0 - 0.1 *
PA 2105	3.5	3.5	2.5	2.0	3.5	3.5		

* For small parts (< 100 mm), a negative scaling factor might be necessary.

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Shrinkage scaling EOS P 396

The materials approved for the machine are listed in the latest issue of the material information *Compatibility Material – P Machines*.

The values given are for guidance in %.

Material \ Scaling	X Axis	Y Axis	Z Axis EOS P 396	
			0 mm	600 mm
PA 1101	4.0	4.0	2.9	2.5
PA 1102 black	3.9	3.9	3.8	2.4
PA 2200	3.2	3.2	2.55	1.4
PA 2201	3.2	3.2	2.2	1.6
PA 2202 black	3.5	3.5	2.8	1.8
PA 2221	3.2	3.2	2.55	1.4
PA 2241 FR	3.1	3.1	2.55	1.4
PA 3200 GF	2.4	2.4	1.7	1.2
Alumide®	2.0	2.2	1.5	1.1
CarbonMide®	0.5	2.0	3.6	2.2
PrimePart® ST	2.6	2.8	1.1	1.1
PrimeCast® 101	0.7 - 1.0	0.7 - 1.0	0.0 - 0.1 *	0.0 - 0.1 *

* For small parts (< 100 mm), a negative scaling factor might be necessary.

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Shrinkage scaling EOS P 770 / EOS P 800

The materials approved for the machine are listed in the latest issue of the material information *Compatibility Material – P Machines*.

The values given are for guidance in %.

Material	Scaling		Z Axis			
	X Axis	Y Axis	EOS P 770		EOS P 800	
			0 mm	600 mm	0 mm	250 mm
PA 1101	4.2	4.2	2.9	2.5		
PA 1102 black	3.9	3.9	3.5	2.8		
PA 2200	3.2	3.2	2.65	1.45		
PA 2201	3.2	3.2	2.2	1.6		
PA 2221	3.2	3.2	2.65	1.45		
PA 2241 FR	3.1	3.1	2.65	1.45		
PA 3200 GF	2.4	2.4	1.7	1.2		
Alumide®	2.2	2.2	1.5	1.1		
PrimeCast® 101	0.7 - 1.0	0.7 - 1.0	0.0 - 0.1 *	0.0 - 0.1 *		
EOS PEEK HP3	4.5 ± 0.5	4.5 ± 0.5			4.5 ± 0.5	3.0 ± 0.5

* For small parts (< 100 mm), a negative scaling factor might be necessary.

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Shrinkage scaling EOSINT P 395 / EOSINT P 760 / EOSINT P 800

The materials approved for the machine are listed in the latest issue of the material information *Compatibility Material – P Machines*.

The values given are for guidance in %.

Material \ Scaling	X Axis	Y Axis	Z Axis					
			EOSINT P 395		EOSINT P 760		EOSINT P 800	
			0 mm	600 mm	0 mm	600 mm	0 mm	250 mm
PA 1101	4.2	4.2	2.9	2.5	2.9	2.5		
PA 1102 black	3.9	3.9	3.7	2.3	3.5	2.8		
PA 2200	3.2	3.2	2.55	1.4	2.65	1.45		
PA 2201	3.2	3.2	2.2	1.6	2.2	1.6		
PA 2202 black	3.5	3.5	2.8	1.8				
PA 2210 FR**	3.4	3.4	2.2	1.6	2.2	1.6		
PA 2221	3.2	3.2	2.55	1.4	2.65	1.45		
PA 2241 FR	3.1	3.1	2.55	1.4	2.65	1.45		
PA 3200 GF	2.4	2.4	1.7	1.2	1.7	1.2		
Alumide®	2.2	2.2	1.5	1.1	1.5	1.1		
CarbonMide®	0.5	2.0	3.6	2.2				
PrimePart® ST	2.6	2.8	1.1	1.1				
PrimeCast® 101	0.7 - 1.0	0.7 - 1.0	0.0 - 0.1 *	0.0 - 0.1 *	0.0 - 0.1 *	0.0 - 0.1 *		
EOS PEEK HP3	4.5 ± 0.5	4.5 ± 0.5					4.5 ± 0.5	3.0 ± 0.5

* For small parts (< 100 mm), a negative scaling factor might be necessary.

** *BasicModule* optics only

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Beam Offset

FORMIGA P 100 / FORMIGA P 110 / EOSINT P 395 / EOS P 396 / EOSINT P 760 / EOS P 770 / EOSINT P 800 / EOS P 800

The materials approved for the machine are listed in the latest issue of the material information *Compatibility Material – P Machines*.

The values given are for guidance in mm

Machine / Material	EOS default job	FORMIGA P 100	FORMIGA P 110	EOSINT P 395	EOS P 396	EOSINT P 760	EOS P 770	EOSINT P 800 / EOS P 800
PA 1101	PA1101_100_0xx	0.20						
	PA1101_120_0xx			0.22	0.25	0.22	0.22	
PA 1102 black	PA1102_120_0xx			0.20	0.20	0.22	0.22	
	PA1102_100_0xx	0.20	0.20					
PA 2200	PA2200_060_0xx		0.21	0.20	0.20	0.20	0.20	
	PA2200_100_1xx		0.24	0.25	0.27	0.25	0.28	
	PA2200_120_1xx		0.29	0.33	0.35	0.33	0.35	
	PA2200_150_0xx			0.36	0.38	0.36	0.36	
	PA2200_180_0xx			0.40	0.42	0.40	0.40	
PA 2201	PA2201_100_0xx		0.28	0.25	0.25	0.25	0.25	
	PA2201_120_0xx			0.33	0.33	0.33	0.33	
	PA2201_150_0xx			0.36	0.36	0.36	0.36	
PA 2202 black	PA2202_150_0xx			0.35	0.35			
PA 2210 FR*	PA2210FR_150_0xx			0.33		0.33		
PA 2221	PA2221_100_0xx			0.25	0.27	0.25	0.25	
	PA2221_120_0xx			0.33	0.35	0.33	0.33	
	PA2221_150_0xx			0.36	0.38	0.36	0.36	
PA 2241 FR	PA2241FR_100_0xx			0.27	0.27	0.27	0.27	
	PA2241FR_150_0xx			0.33	0.33	0.33	0.33	
PA 3200 GF	PA2201GB_100_0xx		0.29	0.33		0.33	0.33	
	PA2201GB_120_0xx			0.33	0.33	0.33	0.33	
	PA2201GB_150_0xx			0.33	0.35	0.33	0.33	
Alumide®	PA2203ALG_100_0xx		0.25	0.33		0.33	0.33	
	PA2203ALG_120_0xx			0.33	0.33	0.33	0.33	
	PA2203ALG_150_0xx			0.33	0.33	0.33	0.33	
CarbonMide®	PA2202CF_150_0xx			0.43	0.43			
PrimePart® ST	PEBA2301_100_0xx	0.40	0.50					
	PEBA2301_150_0xx			0.40	0.40			



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Machine / Material	EOS default job	FORMIGA P 100	FORMIGA P 110	EOSINT P 395	EOS P 396	EOSINT P 760	EOS P 770	EOSINT P 800 / EOS P 800
PrimeCast® 101	PS3302_100_0xx		0.25					
	PS3302_150_0xx			0.20	0.20	0.20	0.20	
PA 2105	PA2105_060_0xx		0.16					
EOS PEEK HP3	PAEK1304_120_0xx							0.39

* BasicModule optics only

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Heating

The materials approved for the machine are listed in the latest issue of the material information *Compatibility Material – P Machines*.

The values given are for guidance. During the commissioning of the machine EOS Service defines which nominal temperatures are to be set.

☞ *Process software* → **Options** menu → **HWI options** → *HWI parameters window* → *Material* tab

Material \ Nominal temp. [°C]	FORMIGA P 100		FORMIGA P 110		EOSINT P 395/EOS P 396	
	Process chamber	Removal chamber	Process chamber	Removal chamber	Process chamber	Removal chamber
PA 1101	180 - 190	150			180 - 195	150
PA 1102 black	178 - 186	150	178-186	150	180 - 195	150
PA 2200	168 - 170	150	168 - 170	150	170 - 185	130
PA 2201	171 - 173	150	169 - 171	150	170 - 185	130
PA 2202 black					170 - 185	135
PA 2210 FR*					170 - 185	130
PA 2221	170 - 172	150			170 - 185	130
PA 2241 FR					170 - 185	130
PA 3200 GF	168 - 170	150	168 - 170	150	170 - 185	130
Alumide®	171 - 173	150	170 - 172	150	170 - 185	130
CarbonMide®					170 - 185	130
PrimePart® ST	130	70	130	70	125 - 140	50
PrimeCast® 101	107 - 109	60	104 - 106	60	103 - 107	50
PA 2105			169 - 171	155		

Material \ Nominal temp. [°C]	EOSINT P 760/EOS P 770			EOSINT P 800 / EOS P 800		
	Process chamber	Building platform	Exchangeable frame	Process chamber	Building platform	Exchangeable frame
PA 1101	180 - 195	160	140			
PA 1102 black	180 - 186	160	140			
PA 2200	170 - 180	160	140			
PA 2201	170- 180	160	140			
PA 2210 FR*	170- 180	160	140			
PA 2221	170 - 180	160	140			
PA 2241 FR	170 - 180	160	140			
PA 3200 GF	170- 180	160	140			
Alumide®	170- 180	160	140			
PrimeCast® 101	103 - 107	50	50			
EOS PEEK HP3				365 - 369	343 - 347	343 - 347

* *BasicModule* optics only

Parameter sheet

Determine building temperature with *OEPs (original EOS parameter sets)*: Non-curl temperature + material-dependent temperature offset

The non-curl temperature is determined on commissioning the material. The building temperature to be set subsequently is calculated by adding the material-specific temperature offset to the non-curl temperature (at the related recommended material refreshing ratio). The result is a general figure that may need to be adjusted to the specific case depending on the part requirements.

The materials approved for the machine are listed in the latest issue of the material information *Compatibility Material – P Machines*.

Material \ Temperature offset [°C]	FORMIGA P 100	FORMIGA P 110	EOSINT P 395	EOS P 396	EOSINT P 760	EOS P 770	EOSINT / EOS P 800
PA 1101	*		*	*	*		
PA 1102 black	*	*	*	*	*		
PA 2200	4 - 5	4 - 5	7	7	7	7	
PA 2201		1 - 2	1	1	1	1	
PA 2202 black			*	*			
PA 2210 FR**			1 - 2		1 - 2		
PA 2221	4 - 6		7	7	5 - 6	5 - 6	
PA 2241 FR			3	3	3	3	
PA 3200 GF		4 - 5	4	4	2 - 3	2 - 3	
Alumide®		4 - 5	3	3	2 - 3	2 - 3	
CarbonMide®			3	3			
PrimePart® ST	3	*	3	3			
PrimeCast® 101							
PA 2105		1					
EOS PEEK HP3							*

* Specific method for determining building temperature

** *BasicModule* optics only

Parameter sheet

Determine start temperature for PPPs (Part Property Profile parameter sets): Non-curl temperature + PPP-dependent temperature offset

The non-curl temperature is determined on commissioning the material. The start value for the subsequent determination of the PPP building temperature is calculated by adding the temperature offset to the non-curl temperature (at the related recommended material refreshing ratio). Only the determination of the PPP building temperature as defined by EOS by means of part tests and an evaluation file will enable the PPP part properties to be achieved.

Temperature offset Material	FORMIGA P 110	EOSINT P 395	EOS P 396	EOSINT P 760	EOS P 770
PA 2200 - <i>TopQuality</i>	4 - 5 **	*		*	
PA 2200 - <i>Performance</i>	4 - 5 **	*	*	*	*
PA 2200 - <i>Balance</i>	4 - 5 **	7	7	5 - 6	4 - 5
PA 2200 - <i>Speed</i>		*		*	
PA 2200 - <i>TopSpeed</i>		*		*	

* See Online Training Center *Building temperature determination* - <https://s.eos.training/>

** PPP building temperature search not approved

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Warm up phase


The materials approved for the machine are listed in the latest issue of the material information *Compatibility Material – P Machines*.

 *Process software* → **Start building process** button

		FORMIGA P 100 / P 110	EOSINT P 395	EOS P 396	EOSINT P 760	EOS P 770	EOSINT / EOS P 800
Minimum warm up time [min]	PA 1101	Auto	180	180	180	180	
	PA 1102 black	Auto	180	180	180	180	
	PA 2200	Auto	120	120	180	180	
	PA 2201	Auto	120	120	180	180	
	PA 2202 black		180	180			
	PA 2210 FR*		180	180	180		
	PA 2221	Auto	120	120	180	180	
	PA 2241 FR		120	120	180	180	
	PA 3200 GF	Auto	120	120	180	180	
	Alumide®	Auto	120	120	180	180	
	CarbonMide®		120	120			
	PrimePart® ST	Auto	120	120			
	PrimeCast® 101	Auto	120	120	180	180	
	PA 2105	Auto					
EOS PEEK HP3						Auto	
Powder base thickness [mm]		Auto	Auto	Auto	Auto	Auto	Auto
Powder base thickness [mm] using PA 2202 black			9	9			
Additional layers when nominal temperature of exchangeable frame is reached.							0

* *BasicModule* optics only

Settings heating radiator EOSINT P 800 / EOS P 800


 Guidance values for position and orientation settings of the heating radiators in the process chamber

	Heating radiator				corners
	left	right	front	rear	
Distance to side wall [mm]	43 ± 2	43 ± 2	128 ± 2	103 ± 2	
Distance to building plane [mm]	230 ± 2	230 ± 2	270 ± 2	254 ± 2	
Orientation [°]	47 ± 1	47 ± 1	109 ± 1	108 ± 1	
Weighting (base value) [%]	60	60	100	70	125

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Compressed air admission pressure

The materials approved for the machine are listed in the latest issue of the material information *Compatibility Material – P Machines*.

 Pneumatic service unit

		FORMIGA P 100 / P 110	EOSINT P 395 / EOS P 396	EOSINT P 760 / EOS P 770	EOSINT P 800 / EOS P 800
Nitrogen supply [bar]		5.5	5.5	5.5	5.5
Fluidisation [bar]	PA 1101		2		
	PA 1102 black		2		
	PA 2200		2		
	PA 2201		2		
	PA 2202 black		2		
	PA 2210 FR*		2		
	PA 2221		2		
	PA 2241 FR		2		
	PA 3200 GF		2		
	Alumide®		2		
	CarbonMide®		2		
	PrimePart® ST		4		
	PrimeCast® 101		2		
	PA 2105				
	EOS PEEK HP3				

* BasicModule optics only

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Nitrogen / Compressed air flow rate

The materials approved for the machine are listed in the latest issue of the material information *Compatibility Material – P Machines*.

☞ Clearing, fluidisation flow rate and sealing air indicators

	FORMIGA P 100/110	EOSINT P 395	EOS P 396	EOSINT P 760	EOS P 770	EOSINT / EOS P 800
Clearing nozzle pyrometer [l/min]	4 ± 0,5	4	4	1,5 ± 0,5	4	3,5 ± 0,5
Clearing nozzle F-Theta lens / Window for the F-Theta lens / Laser Window [l/min]	11 ± 1	<i>BasicModule</i> 10,5 ± 0,5	13 ± 0,5	<i>BasicModule</i> 16 ± 0,5	13 ± 0,5	2 x 12 ± 0,5
		<i>SurfaceModule</i> 13 ± 0,5		<i>SurfaceModule</i> 13 ± 0,5		
Cooling [l/min]	1,5 ± 0,5					
Fluidisation [l/min]	PA 1101	5	5			
	PA 1102 black	5	5			
	PA 2200	10	10			
	PA 2201	10	10			
	PA 2202 black	5	5			
	PA 2210 FR*	8				
	PA 2221	10	10			
	PA 2241 FR	10	10			
	PA 3200 GF	5	5			
	Alumide®	5	5			
	CarbonMide®	8	8			
	PrimePart® ST	15	15			
	PrimeCast® 101	8	8			
	PA 2105					
EOS PEEK HP3						
Sealing air <i>SurfaceModule</i> optics [l/min]		1 ± 0,5	1 ± 0,5	1 ± 0,5	1 ± 0,5	

* *BasicModule* optics only

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Blade geometry FORMIGA P 100 / FORMIGA P 110

☞ Shape of recoater blade

	FORMIGA P 100			FORMIGA P 110		
	Curved (1213-0109)	Curved (2200-4502)	Flat (2200-4119)	Curved (1213-0109)	Curved (2200-4502)	Flat (2200-4119)
PA 1101	X					
PA 1102 black	X			X		
PA 2200	X				X	
PA 2201	X				X	
PA 2221	X					
PA 3200 GF	X				X	
Alumide®			X		X	
PrimePart® ST		X			X	
PrimeCast® 101			X			X
PA 2105						X

Blade geometry FORMIGA P 110

☞ The required shape of recoater blade depending on the used *Part Property Profile*

Blade geometry Part Property Profile	Curved (1213-0109)	Curved (2200-4502)	Flat (2200-4119)
PA 2200 <i>TopQuality</i>			X
PA 2200 <i>Performance</i>		X	
PA 2200 <i>Balance</i>		X	

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Blade modules

EOSINT P 395, EOS P 396

The materials approved for the machine are listed in the latest issue of the material information *Compatibility Material – P Machines*.

☞ The required blade module depending on the used EOS default job (for *Original EOS Parameterset* or *Part Property Profile*) and the machine.

Blade module Material	EOS default job	EOSINT P 395			EOS P 396		
		I (green)	II (blue)	III (red)	I (green)	II (blue)	III (red)
PA 1101	PA1101_120_0xx			X			X
PA 1102 black	PA1102_120_0xx			X			X
PA 2200	PA2200_060_0xx	X			X		
	PA2200_100_1xx		X			X	
	PA2200_120_1xx		X				X
	PA2200_150_0xx			X			X
	PA2200_180_0xx			X			X
PA 2201	PA2201_100_0xx		X			X	
	PA2201_120_0xx		X			X	
	PA2201_150_0xx			X			X
PA 2202 black	PA2202_150_0xx			X			X
PA 2210 FR*	PA2210FR_150_0xx			X			
PA 2221	PA2221_100_0xx		X			X	
	PA2221_120_0xx		X				X
	PA2221_150_0xx			X			X
PA 2241 FR	PA2241FR_100_0xx		X			X	
	PA2241FR_150_0xx			X			X
PA 3200 GF	PA2201GB_100_0xx			X			
	PA2201GB_120_0xx			X			X
	PA2201GB_150_0xx			X			X
Alumide®	PA2203ALG_100_0xx			X			
	PA2203ALG_120_0xx			X			X
	PA2203ALG_150_0xx			X			X
CarbonMide®	PA2202CF_150_0xx			X			X
PrimePart® ST	PEBA2301_150_0xx			X			X
PrimeCast®	PS3302_150_0xx			X			X
EOS PEEK HP3	PAEK1304_120_0xx						

* BasicModule optics only

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Blade modules

EOSINT P 760, EOS P 770, EOSINT P 800, EOS P 800

The materials approved for the machine are listed in the latest issue of the material information *Compatibility Material – P Machines*.

☞ The required blade module depending on the used EOS default job (for *Original EOS Parameterset* or *Part Property Profile*) and the machine.

Blade module Material	EOS default job	EOSINT P 760			EOS P 770			EOSINT / EOS P 800 II
		I (green)	II (blue)	III (red)	I (green)	II (blue)	III (red)	
PA 1101	PA1101_120_0xx			X			X	
PA 1102 black	PA1102_120_0xx			X			X	
PA 2200	PA2200_060_0xx	X			X			
	PA2200_100_1xx		X			X		
	PA2200_120_1xx		X			X		
	PA2200_150_0xx			X			X	
	PA2200_180_0xx			X			X	
PA 2201	PA2201_100_0xx		X			X		
	PA2201_120_0xx		X			X		
	PA2201_150_0xx			X			X	
PA 2202 black	PA2202_150_0xx							
PA 2210 FR*	PA2210FR_150_0xx		X					
PA 2221	PA2221_100_0xx		X			X		
	PA2221_120_0xx		X			X		
	PA2221_150_0xx			X			X	
PA 2241 FR	PA2241FR_100_0xx		X			X		
	PA2241FR_150_0xx			X			X	
PA 3200 GF	PA2201GB_100_0xx		X			X		
	PA2201GB_120_0xx		X			X		
	PA2201GB_150_0xx		X			X		
Alumide®	PA2203ALG_100_0xx		X			X		
	PA2203ALG_120_0xx		X			X		
	PA2203ALG_150_0xx		X			X		
CarbonMide®	PA2202CF_150_0xx							
PrimePart® ST	PEBA2301_150_0xx							
PrimeCast®	PS3302_150_0xx		X			X		
EOS PEEK HP3	PAEK1304_120_0xx							X

* BasicModule optics only

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Settings recoater blade gap EOSINT P 800 / EOS P 800

☞ Guidance values for the distance of the recoater blade to the building plane

	Recoater blade gap	
	front	rear
Aluminum building plane [mm]	1.8 ± 0.1	1.8 ± 0.1
Steel building plane [mm]	1.0 ± 0.1	1.0 ± 0.1

Settings dust protection ducts EOSINT P 800 / EOS P 800

☞ Guidance values for the distance of the upper side of the recoater to the dust protection ducts

	Dust protection duct	
	front	rear
Distance to recoater [mm]	2.5 ± 0.2	2.5 ± 0.2

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Type of fluidisation EOSINT P 395 / EOS P 396

☞ Adjustments at the pneumatic service unit

	EOSINT P 395 / EOS P 396 Type of fluidisation
PA 1101	Pulsed operation
PA 1102 black	
PA 2200	
PA 2201	
PA 2202 black	
PA 2210 FR	
PA 2221	
PA 2241 FR	
PA 3200 GF	
CarbonMide®	
PrimePart® ST	
PrimeCast® 101	Continuous operation
Alumide®	

Powder conveying Vibro-Kit

EOSINT P 395, EOS P 396, EOSINT P 760, EOS P 770, EOSINT P 800, EOS P 800

☞ Adjustments at switching cabinet of powder conveying Vibro-Kit

	EOSINT P 395 / EOS P 396	EOSINT P 760 / EOS P 770	EOSINT / EOS P 800
Compressed air supply [bar]	6	6	6
Activation of powder conveying Vibro-Kit	PA 1101	Optional	Optional
	PA 1102 black	Optional	Optional
	PA 2200	Optional	Optional
	PA 2201	Optional	Optional
	PA 2202 black		
	PA 2210 FR		
	PA 2221	On	On
	PA 2241 FR		
	PA 3200 GF		
	Alumide®		
	CarbonMide®		
	PrimePart® ST		
	PrimeCast® 101		
	EOS PEEK HP3		

Parameter sheet

Powder refreshing

The materials approved for the machine are listed in the latest issue of the material information *Compatibility Material – P Machines*.

☞ The values given specify the minimal refreshing with new powder and may vary depending on application and environmental condition.

Material	EOSINT P 395, P 760, P 800, EOS P 396, P 770 Min. refreshing [%]	Powder bin FORMIGA P 100 * / FORMIGA P 110 *		
		Weight recycled powder [kg]	Weight new powder [kg]	Density [kg/l]
PA 1101	50	2.4	2.4	0.48
PA 1102 black	50	2,4	2,4	0,48
PA 2200	50	2.2	2.2	0.44
PA 2201	50	2.2	2.2	0.44
PA 2202 black	60	Not released		
PA 2210 FR	100	-		
PA 2221	30	3.1	1.3	0.44
PA 2241 FR	50	Not released		
PA 3200 GF	70	1.8	4.2	0.61
Alumide®	100	-		
CarbonMide®	100	-		
PrimePart® ST	50	1.85	1.85	0,37
PrimeCast® 101	10	5.4	0.6	0.61
PA 2105	50	2.2	2.4	0.44
EOS PEEK HP3	100	-		

* The values given are valid for a mixing process with the Mixing Station for a 15 l powder bin of the FORMIGA 100 / FORMIGA P 110 with a recommended filling level of 10 l and the min. refreshing.
ATTENTION! The density may vary.

Parameter sheet

Material humidity

The material humidity is referred to as the recommended value of relative humidity of powder in % mixed in the Mixing & Qualification Station (MQS). The plastic powder can not be used for the building process immediately. After discharging from the MQS it must be stored in the multibox for at least 24 hours.

☞ MQS control → *Produce mixed powder* dialog → *Conditioning (rel. Humidity)* check box

The materials approved for the machine and the MQS are listed in the latest issue of the material information *Compatibility Material- IPCM P plus*.

Material	Relative humidity [%]
PA 1101	45
PA 1102 black	45
PA 2200	45
PA 2201	45
PA 2202 black	35
PA 2221	45
PA 2241 FR	45
PA 3200 GF	45
PrimePart® ST	35
PrimeCast® 101	Not released
PA 2105	Not released

Parameter sheet

Cleaning interval laser window

EOSINT P 395 (with *SurfaceModule* optics)

EOS P 396

EOSINT P 760 (with *SurfaceModule* optics)

EOS P 770

The materials approved for the machine are listed in the latest issue of the material information *Compatibility Material – P Machines*.

- ☞ See the latest issue of the operating instructions (*Troubleshooting, Maintenance and Spare Parts manual, Inspection and servicing plans*) for the correct cleaning of the laser window.
The cleaning interval may vary depending on material.

Material \ Interval	EOSINT P 395 / EOS P 396 / EOSINT P 760 / EOS P 770	
	After the job	Weekly
PA 1101	X	
PA 1102 black	X	
PA 2200		X
PA 2201		X
PA 2202 black		X
PA 2221		X
PA 2241 FR	X	
PA 3200 GF		X
Alumide®		X
CarbonMide®		X
PrimePart® ST	X	
PrimeCast® 101		X