Plastic laser-sintering system for the
direct manufacture of series, spare parts,
functional prototypes and patterns for
investment or vacuum casting

**The technology:**
Laser-sintering – the key to e-Manufacturing

Laser-sintering is well known as the technology of choice for ensuring the quickest route from product idea to market launch. Innovative companies from a broad range of industries are using this technology for e-Manufacturing – the fast, flexible and cost-effective production directly from electronic data for every phase of the product life cycle.

**The system:**
e-Manufacturing for the industrial environment

The EOSINT P 395 is a highly productive thermoplastics laser-sintering system. With this system fully functional plastic parts can be manufactured which are used for product development, in serial production or for spare part production. The system can create parts without the need for support structures. The maximum building height of 620 mm enables the construction of larger plastic components without the need for subsequent joining processes. The modular nature of the EOSINT P 395 offers great flexibility with regard to functionality and budget.

The completely re-engineered laser optics module (SurfaceModule) improves the quality of vertical surfaces into regions which up until now had been exclusive to the FORMIGA. The recoating unit in the EOSINT P 395 has also been further improved. The introduction of Part Property Profiles (PPPs) has led to the integration into the EOSINT P 395 of EOS’s highly successful blade cartridge concept, which was introduced in 2007 and simplifies the adjustments and change of the layer thickness.

Special parameter sets can be applied according to material, layer thickness and usage type in order to achieve standardized PPPs. By doing this, it is possible to achieve for example either great cost benefits, or the reproduction of the finest of details. If special parameter sets are not required, the initial necessary investment decreases accordingly. Parameter sets and other modules can be added at any time. In order to optimize process flows, the technology also provides Integrated Process Chain Management (IPCM). This includes automatic powder conveying, an unpacking station and a powder recycling facility, all of which maintain dust-free as well as ergonomic working conditions. In addition to the exchangeable frame docking system, these features guarantee maximum use of the machine’s capacity.

The distinctive features of the EOSINT P 395 system are the quality of the parts it produces, its productivity, high degree of automation, professional materials management, and the ergonomically designed peripherals. These features make the system an ideal production tool for the economical batchsize optimized manufacture of parts at all stages of the product life cycle. The system is therefore perfectly suited for an industrial environment.
The software:
Automatically achieving maximum productivity
EOS offers various software packages for processing CAD data and tracking production flows. EOSPACE was developed to provide users with an overview of all production-related data at any desired point in time. The software processes production data for freely definable timeframes and displays it clearly. The user’s requirements are accommodated within the integrated Basic, Quality Assurance, Controlling and Machine Park Management (MPM) modules. They ensure that production flows are easily trackable and manageable.

### Technical Data

<table>
<thead>
<tr>
<th>Feature</th>
<th>Specification</th>
</tr>
</thead>
<tbody>
<tr>
<td>Effective building volume</td>
<td>340 mm x 340 mm x 620 mm</td>
</tr>
<tr>
<td>Building speed (material-dependent)</td>
<td>up to 31 mm/h</td>
</tr>
<tr>
<td>Layer thickness (material-dependent)</td>
<td>0.06 – 0.10 – 0.12 – 0.15 – 0.18 mm</td>
</tr>
<tr>
<td>Support structure</td>
<td>not necessary</td>
</tr>
<tr>
<td>Laser type</td>
<td>CO₂, 50 W</td>
</tr>
<tr>
<td>Precision optics</td>
<td>F-theta-lens</td>
</tr>
<tr>
<td>Scan speed</td>
<td>up to 8 m/s</td>
</tr>
<tr>
<td>Power supply</td>
<td>32 A</td>
</tr>
<tr>
<td>Power consumption (nominal)</td>
<td>2 kW</td>
</tr>
<tr>
<td>Nitrogen generator</td>
<td>integrated (optional)</td>
</tr>
<tr>
<td>Compressed air supply</td>
<td>minimum 5,000 hPa; 6 m³/h</td>
</tr>
</tbody>
</table>

### Dimensions (B x D x H)

- System incl. switchgear cabinet: 1,840 mm x 1,175 mm x 2,100 mm
- Control terminal: 950 mm x 700 mm x 1,550 mm
- Powder conveying system: 1,480 mm x 1,170 mm x 1,470 mm
- Unpacking station: 1,190 mm x 620 mm x 1,500 mm
- Recommended installation space: 4.3 m x 3.9 m x 3.0 m
- Weight: approx. 1,060 kg

### Data preparation

- Software: EOS RP Tools; EOSPACE 1.2; Magics RP (Materialise)
- CAD interface: STL. Optional: converter to all common formats
- Network: Ethernet

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