TRUMPF TruLaser Cell 3000 with TruDisk 6001 (NOTE: 6 kW laser can run as low as 200 W)

Nozzles available:

Pay careful attention to the powder size ranges for each nozzle.
Lower limit: Powders smaller than 15 µm will not work with the fine nozzles and are not permitted.
Upper limit: While 90 µm is specified as the upper limit for some of the nozzles, powders commonly available with a 106 µm upper limit typically work with those nozzles. Though not guaranteed, they may be used.

Coax (fine)
• powder spot size 0.5 mm
• power 200 W to 0.5 kW
• tilt 0-10°
• for use with fine powders and printing fine features/knife edges

Coax (standard)
• powder spot size 0.9 mm
• power 200 W to 1.0 kW
• tilt 0-10°
• most common, for use with standard powders

SO 12 (3-beam)
• powder spot size 2.5 mm
• power 1.0 kW to 3.0 kW
• tilt 0-90°

EHLA (multijet, 7)
• powder spot size 3 mm
• power 200 W to 8 kW
• tilt 0-90°

<table>
<thead>
<tr>
<th>Nozzle</th>
<th>Coax nozzle fine</th>
<th>Coax nozzle</th>
<th>3 Beam Nozzle SO 12</th>
<th>MultiJet</th>
</tr>
</thead>
<tbody>
<tr>
<td>Ø powder spot</td>
<td>0,5 mm</td>
<td>0,9 mm</td>
<td>2,5 mm</td>
<td>&lt;3 mm</td>
</tr>
<tr>
<td>Max. power</td>
<td>0,5 kW</td>
<td>1 kW</td>
<td>3 kW</td>
<td>8 kW</td>
</tr>
<tr>
<td>Stand-off</td>
<td>7</td>
<td>7</td>
<td>12</td>
<td>13,5</td>
</tr>
<tr>
<td>Max. tilting angle nozzle vs. horizontal</td>
<td>0° - 10°</td>
<td>0° - 10°</td>
<td>0° - 90°</td>
<td>0° - 90°</td>
</tr>
<tr>
<td>Typical grain size</td>
<td>15 – 45 µm</td>
<td>45 – 90 µm</td>
<td>45 – 90 µm</td>
<td>15 – 45 µm</td>
</tr>
</tbody>
</table>