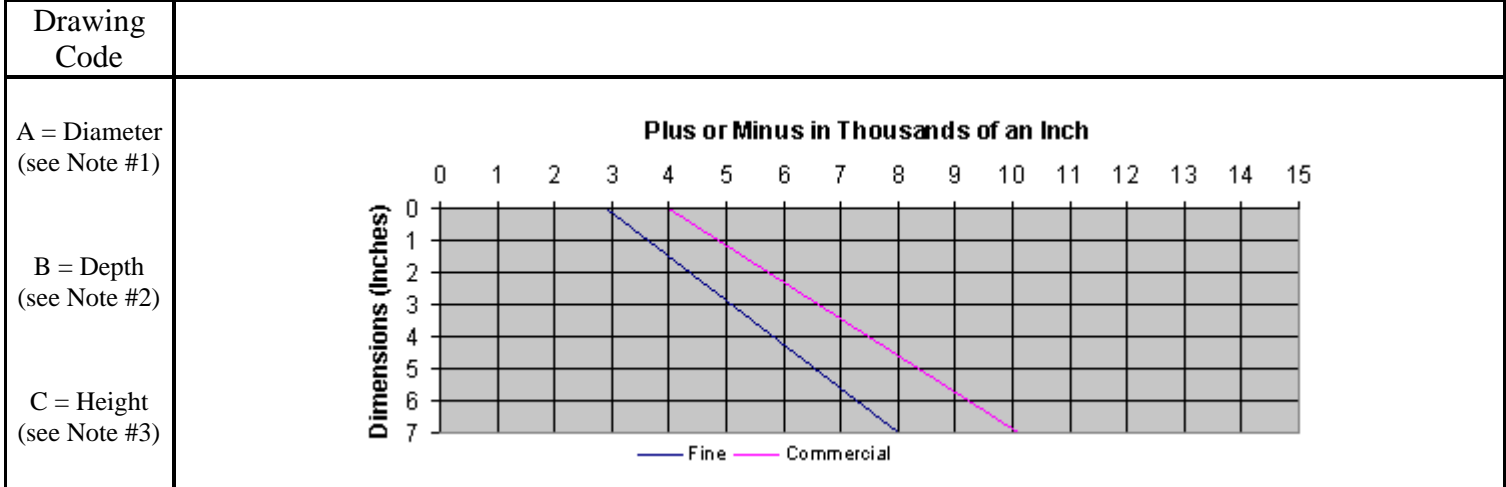
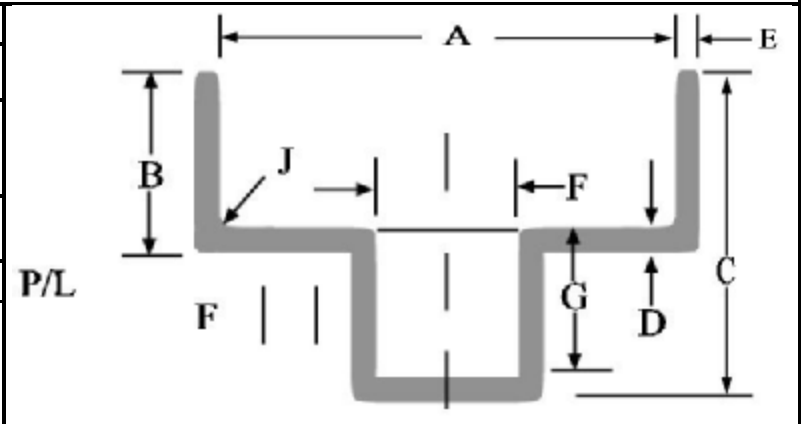


SICAM STANDARDS FOR SLA MODELS	Engineering and Technical Standards SLA RESINS
---------------------------------------	---

NOTE: The Commercial values shown below represent common production tolerances at the most economical level. The Fine values represent closer tolerances that can be held but at a greater cost.



	6.000 to 12.000 for each additional inch add (inches)	Comm. ±	Fine ±
		.0015	.001
D = Bottom Wall (see Note #3)		.002	.001
E = Side Wall (see Note #4)		.002	.001
F = Hole Size Diameter (see Note #1)	0.000 to 0.125	.002	.001
	0.125 to 0.250	.002	.002
	0.250 to 0.500	.002	.002
	0.500 & Over	.004	.003
G = Hole Size Depth (see Note #5)	0.000 to 0.250	.002	.002
	0.250 to 0.500	.002	.002
	0.500 to 1.000	.002	.002
Draft Allowances per side		0	0
Flatness (see Note #4)	0.000 to 3.000	.010	.010
	3.000 to 6.000	.010	.015
Thread Size (class)	Internal	1	2
	External	1	2
Concentricity (see Note #4)	(T.I.R.)	.005	.005
Thin Sections (see Note #5)		.010	.008
Surface Finish	(see Note #7)		
Text	(see Note #7)		



REFERENCE NOTES

These tolerances do not include allowances for aging characteristics of material.

Tolerances based on 1/8" wall section.

Grow direction must be taken into consideration.

Part design should maintain a wall thickness as nearly constant as possible. Complete uniformity in this dimension is impossible to achieve.

Beam diameter dependent.

These values should be increased whenever compatible with design and good molding technique.

Customer-Molder understanding necessary prior growing.