

### Tolerances, Additive Manufacturing of plastic parts

A dialogue regarding important dimensions is always preferable, regardless of size and shape. The geometry of bigger parts can possibly affect normal tolerances. With additive manufacturing there is always a chance that measurements in Z can deviate  $\pm$  two layer thicknesses.

SLS (mm)	-700	700-
Tolerance	$\pm 0.1 +0,2\%$	Dialogue

Big SLS-parts are made in segments and merged with glue, often using fixtures.  
Maximum build envelope: 700 x 380 x 580 mm.

SLA (mm)	-3	-30	-120	-400	-1000	1000-
Tolerance	$\pm 0.1$	$\pm 0.2$	$\pm 0.3$	$\pm 0.5$	$\pm 0.8$	Dialogue

Dimensions for SLA Class B are 0.05-0.1 mm greater than nominal.  
Maximum build envelope: 750 x 650 x 550 mm.

FDM (mm)	-3	-30	-120	-400	400-	
Tolerance	$\pm 0.1$	$\pm 0.2$	$\pm 0.3$	$\pm 0.5$	Dialogue	

Shape accuracy using the FDM-process is excellent.  
Maximum build envelope: 406 x 355 x 406 mm.