SICAM - HP MJF Process Tolerances

Dimension (mm)	Dimension (in.)	< +/- .1mm < +/- .004in	+/- .1mm +/- .004in	+/- .15mm +/- .006in	+/- .2mm +/- .008 in	+/- .25mm +/-.010in	+/- .3mm +/-.012in	+/- .35mm +/-.014in	+/- .4mm +/-.016in	+/-0.45mm +/-.018in	+/-0.5mm +/-.020in	+/-0.55mm +/-.022in	+/-0.6mm +/-.024in
<25.0 mm	<1 in	N	A	A	B	B	B	B	B	B	B	B	B
25-50 mm	1 - 2 in	N	A	A	B	B	B	B	B	B	B	B	B
50-75 mm	2-3 in	N	A	A	B	B	B	B	B	B	B	B	B
75-100 mm	3-4 in	N	A	A	B	B	B	B	B	B	B	B	B
100-125 mm	4-5 in	N	N	A	A	B	B	B	B	B	B	B	B
125-150 mm	5-6 in	N	N	N	A	A	B	B	B	B	B	B	B
150-175 mm	6-6.9 in	N	N	N	N	A	A	B	B	B	B	B	B
175-200 mm	6.9-7.9 in	N	N	N	N	N	A	A	B	B	B	B	B
200-225 mm	7.9-8.9 in	N	N	N	N	N	N	A	A	B	B	B	B
225-250 mm	8.9-9.8 in	N	N	N	N	N	N	N	A	A	B	B	B
250-275 mm	9.8-10.8 in	N	N	N	N	N	N	N	A	A	A	B	B
275-300 mm	10.8-11.8 in	N	N	N	N	N	N	N	A	A	A	A	B

Legend:

A = Maybe possible but would need to be verified with FAI on actual parts.

B = As per "HP MJF Process Tolerances".

N = Possible with secondary operation.

Notes:

Holes tighter than above tolerances can be held closer with secondary reaming operations

Any holes less than 3mm (.125in) need to be reamed.

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