



**TYPICAL TOLERANCE GUIDE SHEET – GLOUCESTER UK.**

ARRK prides itself on providing toleranced components. The following are general tolerances which apply to ARRK’s prototyping capabilities.

Please note that higher tolerances can be guaranteed with prior agreement between the customer and ARRK.

Due to the need to supply quickly, ARRK provides external 3 axis check on all components as a standard, with the exception of C grade sl’s, which are cross referenced to machine calibration bars this is deemed a standard prototyping protocol. CMM is also available at an additional cost.

These external tolerances supersede all production drawing tolerances.

Process	Nominal Tolerance (mm)	Dimensional Tolerance (mm)	i.e. 100	i.e.200
SLA	0.15	± 0.15 per 100	99.85 – 100.15	199.70 – 200.30
SLA ABS	0.30	± 0.30 per 100	99.70 – 100.30	199.40 – 200.60
SLS	0.25	± 0.25 per 100	99.75 – 100.25	199.50 – 200.50
PU	0.20 + SL Master Tol	± 0.20 per 100	99.80 – 100.20	199.60 – 200.40
Quick Cast	0.15	± 0.15 per 100	99.85 – 100.15	199.70 – 200.30
CNC	Upon Request			

**FOUNDRY – FUNCTIONAL DIMENSIONS**

MILLIMETERS		INCHES	
Dimension	Tolerance	Dimension	Tolerance
Up to 150mm	± 0.4mm	Up to 6	± 0.016”
Up to 250mm	± 0.5mm	Up to 10	± 0.020”
Up to 350mm	± 0.8mm	Up to 14	± 0.032”
Up to 500mm	± 1.5mm	Up to 20	± 0.060”

Closer tolerances are generally attainable by utilising additional operations.

**Non-Functional Dimensions:** Where design permits the above tolerances should be increased by 50%.