





TOLERANCES							DIMENSIONS			PART SUPPLY			DESIGN INTENT		© COPYRIGHT		MANUFACTURING SKILLS QUEENSLAND		monochrome www.monochrome-design.com			
• Tolerances to ISO 2768-mK unless otherwise stated. • For dimensions under 0.5mm tolerance is ±0.05. • ISO 2768-1: Per below table (class indicated by check mark). • ISO 2768-2: K (medium)							• All dimensions are in millimetres unless otherwise indicated. • All dimensions to base of draft unless otherwise indicated.			• Printing technology: Fused Deposition Modelling (FDM). • Alternatively, Selective Laser Sintering (SLS), Stereolithography (SLA) or Multi Jet Fusion (MJF) may be used where FDM is unavailable. • Build Orientation: print part with Z-axis as indicated. This is critical for mechanical strength of the part. • Face marked 'A' is a primary cosmetic surface. • Orient part to minimise layer lines and support marks on this face. • Part to be free of excessive stringing, warping, delamination, and major layer shifts. • Remove all support structures. Marks/nibs from support material are permissible on non-critical/internal surfaces only. • Layer lines and some "stair-stepping" on angled/curved surfaces are acceptable. • Tap holes as specified. Do not print threads. • Machine critical bores and faces to specified tolerances after printing. • Align Z-seam on sharpest corner (or as indicated) to minimise visual impact.			Unless otherwise specified, fabricate per 3D model file. Drawing supplied for reference and inspection purposes only.				This drawing is supplied in confidence. Do not disclose to any third party without prior written consent from Manufacturing Skills Queensland					
LINEAR - PERMISSIBLE DEV. IN MM FOR RANGES IN NOMINAL LENGTHS							<div>• Critical inspection dimension: </div> <div>• Dimensions with ** may require adjustment during tool trials.</div> <div>• First article inspection number:  (supplier to provide FAI report detailing each of these dimensions).</div> <div>• Other dimensions for reference.</div>			PROJECT NAME		Headphone Stand		COLOUR: White		PART NAME: MONO_038-p322						
CLASS	0.5 - 6mm	6 - 30mm	30 - 120mm	120 - 400mm	Over 400mm																	
<input type="checkbox"/> FINE	±0.05mm	±0.1mm	±0.15mm	±0.2mm	±0.3mm																	
<input checked="" type="checkbox"/> MEDIUM	±0.1mm	±0.1mm	±0.3mm	±0.5mm	±0.8mm																	
<input type="checkbox"/> COARSE	±0.3mm	±0.5mm	±0.8mm	±1.2mm	±2.0mm																	
ANGULAR - PERMISSIBLE DEV. IN DEGREES & MINUTES FOR RANGES IN NOMINAL LENGTHS							SURFACE TEXTURE KEY (SPI STANDARD)			PROJECT NAME		Part Drawing		FINISH: Matte		DESCRIPTION: Diffuser Attachment		A3 SHEET 1 OF 1				
CLASS	0 - 10mm	10 - 50mm	50 - 120mm	120 - 400mm	Over 400mm	Refer to 3D part surface colouring for application <td colspan="2"></td> <td colspan="2"></td> <td colspan="2"></td>																
<input type="checkbox"/> FINE	±1°	±0°30'	±0°20'	±0°10'	±0°5'	Orange	Natural	Printed Finish														
<input checked="" type="checkbox"/> MEDIUM	±1°	±0°30'	±0°20'	±0°10'	±0°5'	Green	Sanded	Sanding (from 220 to 400 Grit)														
<input type="checkbox"/> COARSE	±1° 30'	±1°	±0°30'	±0°15'	±0°10'	Blue	Smooth	Vapour Smoothing														