

Table of Contents

TABLE 1 MECHANICAL PROCESSING	2
TABLE 2 3D PRINTING.....	2
TABLE 3 COATINGS LIGHTLINES	2
TABLE 4 HORTI CULTURE	2
CONTACT	3
LATEST VERSION	3

Veko Uses the following Tolerances for the following processing types unless otherwise specified on drawing.

TABLE 1 MECHANICAL PROCESSING

Processing Type	DIN / ISO / NEN - A	DIN / ISO / NEN - B
Aluminium Extrusion Profiles	NEN-EN 755-9	VDI3400 24
Aluminium Casting	DIN ISO 8062 Grade 3	VDI3400 30
Thermoplastics Extruded Profiles	DIN 16941 2A & 2B	
Molded Rubber Parts	DIN ISO 3302-1-M2	VDI3400 24
Plastics Mouldings	DIN 16901-130	VDI3400 24
Sheetmetal	DIN ISO 2768-M	DIN ISO 2768-K
CNC Machining	ISO 2768-M	ISO 2768-K VDI3400 24
Wire EDM	+0.1 mm for dimension up to LxW150 mm and height up to 500mm	

TABLE 2 3D PRINTING

3D Printing Type	Tolerances
FDM Fused Deposition Modeling	Dimensions Accuracy $\pm 0.4\%$ with minimum of ± 0.4 mm Layer Height 100 μm Infill 40%
SLA Stereolithography	Dimensions Accuracy $\pm 0.3\%$ with minimum of ± 0.3 mm Layer Height 50 μm
SLS Selective Laser Sintering	Dimensions Accuracy $\pm 0.3\%$ with minimum of ± 0.3 mm Layer Height 100 μm
MJF Multi Jet Fusion	Dimensions Accuracy $\pm 0.3\%$ with minimum of ± 0.3 mm Layer Height 80 μm

TABLE 3 COATINGS LIGHTLINES

Coatings Lightline	Thickness
Anodizing	AA 25 (25 μm) <u>ISO 7599</u> Industrial
Hard Anodizing	40 μm
Powder Coating	60-80 μm <u>EN 12206-1</u>
Lacquering	<u>ISO 8442</u>

TABLE 4 HORTI CULTURE

Coatings Horticulture	Thickness
Anodizing	AA 20 (20 μm) <u>ISO 7599</u> Industrial
Powder Coating	60-80 μm <u>EN 12206-1</u>

CONTACT

Veko Lightsystems
The Netherlands
Witte Paal 38, 1742 NL Schagen
Postbus 168, 1740 AD Schagen
T +31 224 273 273

LATEST VERSION

Veko is free to change this norm document without notification at any time, for the latest version always visit our website.

Main Website

<https://www.veko.com/>

Norm Document(s)

<https://www.veko.com/production-norms.html>