

Revision: 2.0							
Engr. Spec. #	Importance	Source	Specification (description)	Unit of Measure	Marginal Value	Ideal Value	Comments/Status
1.0			Spreader Head				
1.1	1	1.8	Speed	cm/s	> 1	> 2	ProMetal is 75 seconds per Layer
1.2	9	2.1	Powder Density Variation - In-Plane	%	< 5	< 0.1	ProMetal Variation Unknown
1.3	9	2.1	Powder Density Variation - Transverse	%	< 5	< 0.1	ProMetal Variation Unknown
1.4	3	2.2	Powder Density %	%	> 65	> 80	Percentage of Parent Metal Density
1.5	3	2.3	Surface Roughness Average	µm	< 3	0.5	
2.0			Platform				
2.1	9	1.2.1	Z Axis Resolution	µm	< 500	< 280	
2.2	1	1.2.3	Platform Parallelism	µm	< 78	< 10	marginal value represents .01 deg. across 450mm
2.3	3	1.2.2	Platform Size	mm	450 x 305 x 150	1500 x 750 x 700	LxWxH (18 x 12 x 6 in) Ideal value is ProMetal size
3.0			Powder				
3.1	1	3.1	Must Spread ProMetal Powder	Y/N	Yes	Yes	
4.0			Binder				
4.1	1	4.2	Viscosity	cP	40	20	

Engr. Spec. #: enables cross-referencing (traceability) and allows mapping to lower level specs within separate documents

Source: Customer need #, regulatory standard (eg. EN 60601), and/or "implied" (must exist but doesn't have an associated customer need)

Description: quantitative, measureable, testable details

*This table can be expanded to document test results