NOTES:
1. CAD DATA SUPPLIED FOR FULL DEFINITION OF THIS PART
2. ALL DIMENSIONS QUERIED FROM CAD ARE BASIC
3. PART SHALL BE FREE OF INCLUSIONS OR CRACKS
4. REFER TO SHEET 2 FOR SLICER SETTINGS

		REVISIONS		
ZONE	REV.	DESCRIPTION	DATE	APPROVED
D3, E4	A	REMOVED FRONT HOLE, INCREASED SLIT CLEARANCE	2020-04-13	JB

DETAIL A
SCALE 1.5 : 1

B

C

⌓ 0.5 A B C

A

BUILD SURFACE

A

A

A
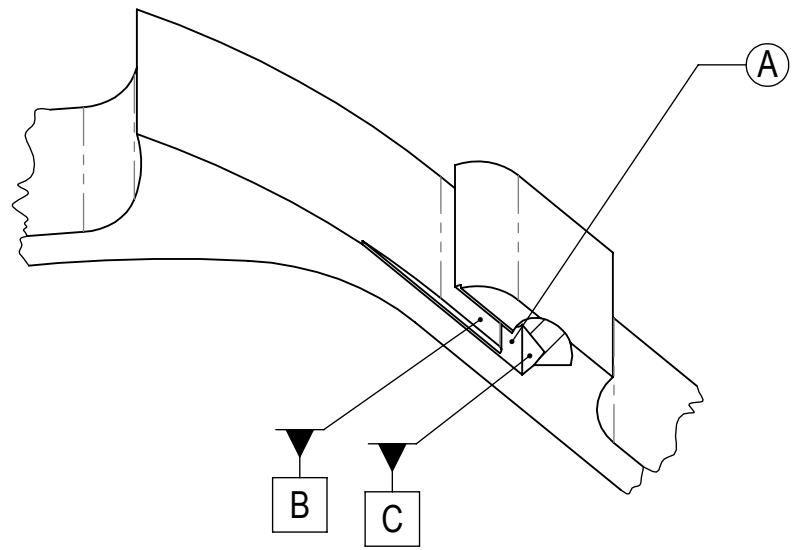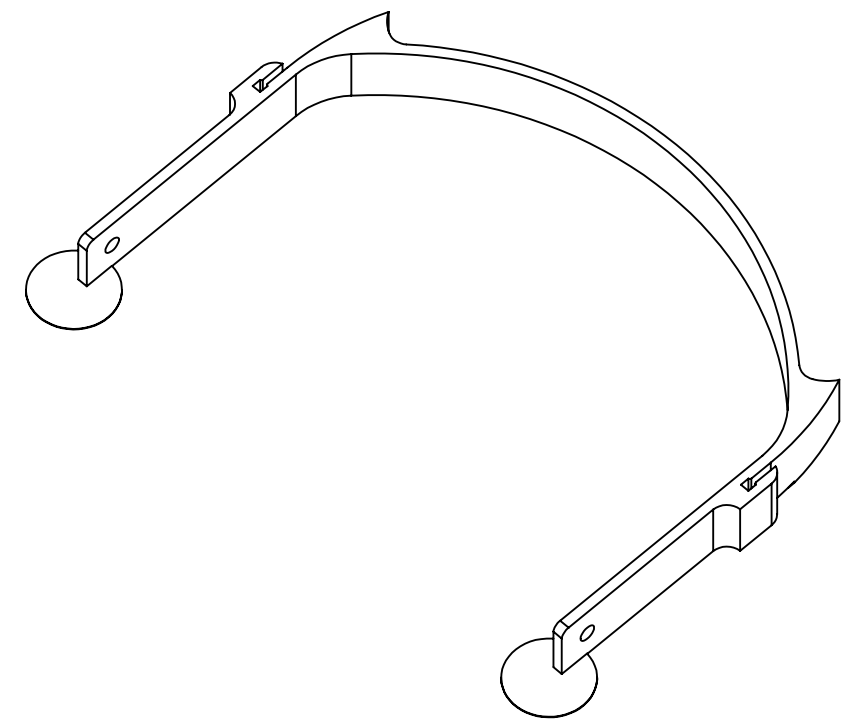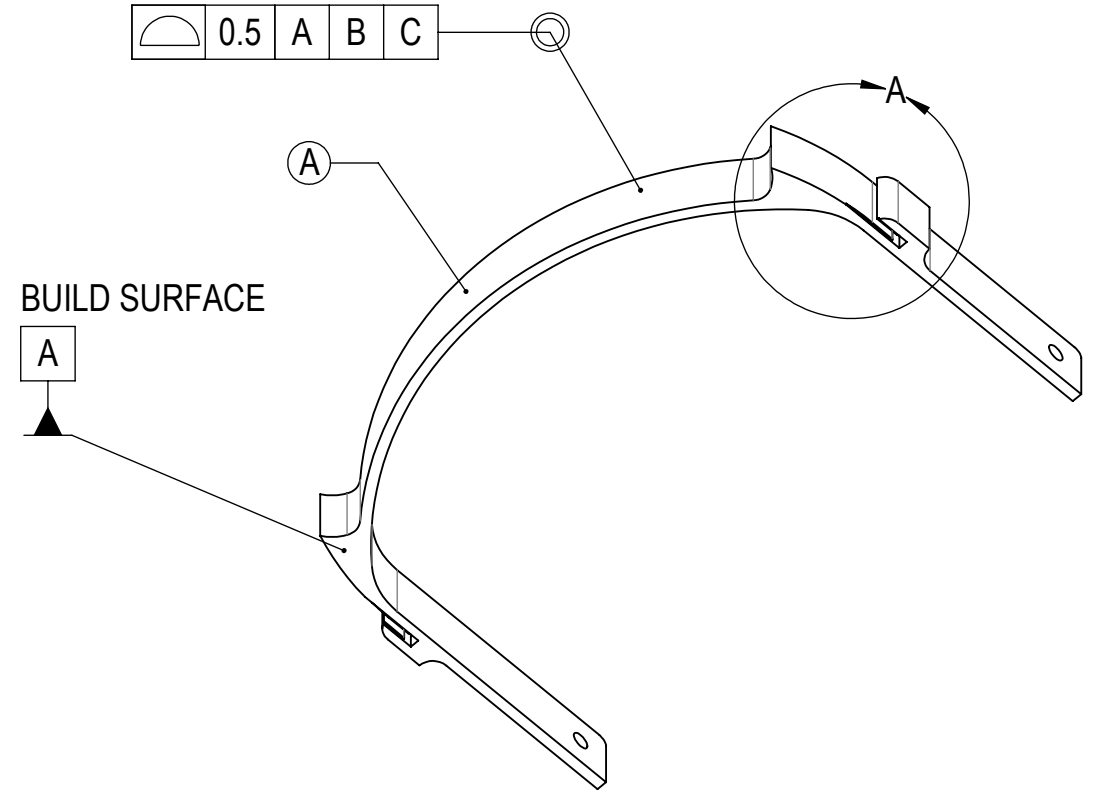
MODEL WITH ARTIFICIAL SUPPORTS

PROPRIETARY

ALIMENTÉ PAR POWERED BY
CGEC CEED

UNIVERSITY OF OTTAWA

UNLESS OTHERWISE SPECIFIED:			
DIMS ARE IN MILLIMETERS TOLERANCE ON ANGLES 0.5° 0 PLACE ± 0.5 mm 1 PLACE ± 0.25 mm 2 PLACE ± 0.13 mm		NAME	DATE
	DRAWN	S.TREMBLAY	2020-04-16
	CHECKED	J.BOUDREAU	2020-03-30
	ENG APPR.		
BREAK ALL SHARP EDGES 0.25 - 0.50mm	MFG APPR.		
INTERPRET THIS DRAWING IN ACCORDANCE WITH: ASME Y14.5-2009	Q.A.		
MATERIAL PLA	COMMENTS:		
FINISH NATURAL			
DO NOT SCALE DRAWING			

TITLE:

HEAD BAND
FACE MASK
HOSPITAL PPE

SIZE	DWG. NO.	REV
B	CEED-DET-1001-01	A
SCALE: 1:2	WEIGHT: (30 g)	SHEET 1 OF 2

ULTIMAKER 2+ TESTED SETTINGS

PARAMETER	VALUES			UNITS
NOZZLE	0.8	0.6	0.4	mm
LAYER HEIGHT	0.3	0.27	0.25	mm
INITIAL LAYER HEIGHT	0.25	0.25	0.2	mm
INFILL PERCENTAGE	0	0	0	%
WALL THICKNESS	1.6	1.2	1.2	mm
OPTIMIZE WALL PRINTING ORDER	Enabled	Enabled	Enabled	-
RETRACTION	Enabled	Enabled	Enabled	-
PRINT SPEED	75	75	75	mm/s
INNER WALL SPEED	70	70	70	mm/s
OUTER WALL SPEED	70	70	70	mm/s
TRAVEL SPEED	120	120	120	mm/s
INITIAL LAYER SPEED	55	55	55	mm/s
SUPPORTS	None	None	None	-

UNLESS OTHERWISE SPECIFIED:
DIMS ARE IN MILLIMETERS
TOLERANCE ON ANGLES 0.5°
0 PLACE ± 0.5 mm
1 PLACE ± 0.25 mm
2 PLACE ± 0.13 mm
BREAK ALL SHARP EDGES 0.25 - 0.50mm

INTERPRET THIS DRAWING IN ACCORDANCE WITH: ASME Y14.5-2009

MATERIAL
PLA

FINISH
NATURAL

DO NOT SCALE DRAWING

	NAME	DATE
DRAWN	S.TREMBLAY	2020-04-16
CHECKED		
ENG APPR.		
MFG APPR.		
Q.A.		

COMMENTS:

TITLE:

HEAD BAND

FACE MASK

HOSPITAL PPE

SIZE	DWG. NO.	REV
B	CEED-DET-1001-01	A

SCALE: 1:2 | WEIGHT: (30 g) | SHEET 2 OF 2