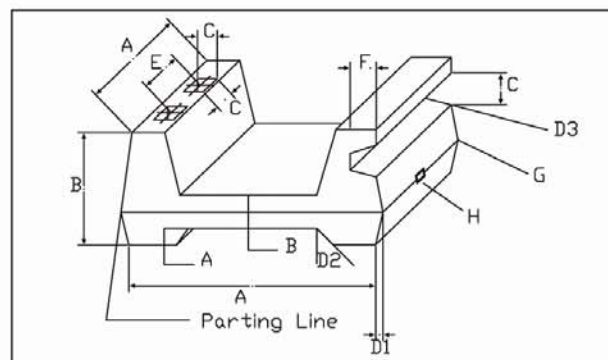




CASTING TOLERANCES

For Tighter Dimensional requirements, contact our product engineering department



A. Linear Dimensions (inches)

0" - 3" $\pm .030"$
 3" - 6" $\pm .040"$
 6" - 9" $\pm .050"$
 9" - 12" $\pm .060"$
 12" plus $\pm .060" \pm .002$ in/in

B. Dimensions Across Parting

0 - 100 sq in add $\pm .015"$
 100 plus sq in add $\pm .045"$

C. Core Dimensions

0" - 6" $\pm .018"$
 6" - 12" $\pm .025"$
 12" plus $\pm .040" \pm .001$ in/in

D. Min Draft Angles

0" - 1" 5°
 1" - 3" $2^\circ - 3^\circ$
 3" plus $1^\circ - 2^\circ$

E. Dimensions Between 2 Cores

0" - 6" $\pm .045"$
 6" - 12" $\pm .060"$
 12" plus $\pm .060" \pm .002$ in/in

F. Dimension Between Core & Mold

Refer to chart E

G. Parting Line Fins

$\pm .060"$ Commercial quality
 otherwise up charge

H. Gate & Riser Connection

$\pm .060"$ Commercial quality
 otherwise up charge

I. Pattern Mismatch

0" - 16" $\pm .031"$