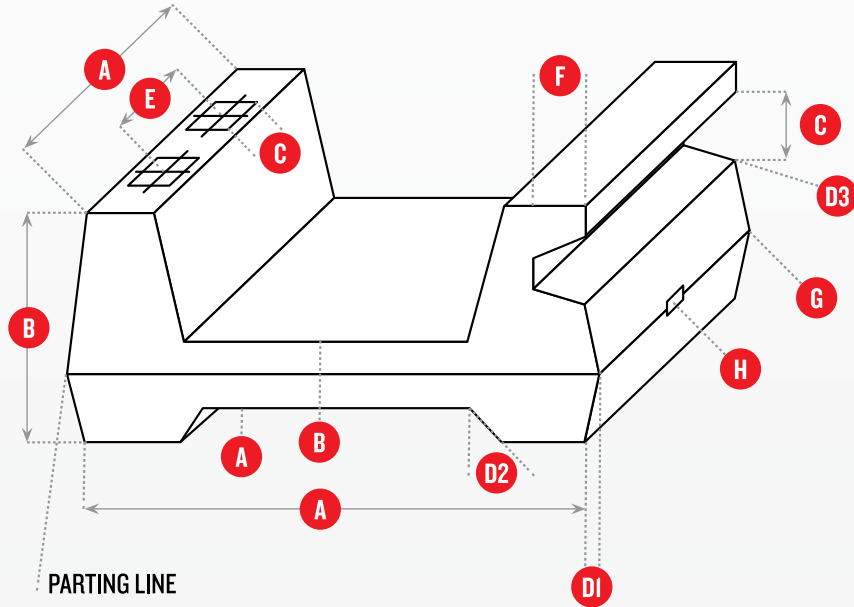




CASTING TOLERANCES

➤ FOR TIGHTER DIMENSIONAL REQUIREMENTS, CONTACT OUR PRODUCT ENGINEERING DEPARTMENT



A. LINEAR DIMENSIONS (INCHES)

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

B. DIMENSIONS ACROSS PARTING

0 - 100 sq in	add ± .015"
100 plus sq in	add ± .045"

C. CORE DIMENSIONS

0" - 6"	± .018"
6" - 12"	± .025"
12" plus	± .040" ± .001 in/in

D. MIN DRAFT ANGLES

0" - 1"	5°
1" - 3"	2° - 3°
3" plus	1° - 2°

E. DIMENSIONS BETWEEN 2 CORES

0" - 6"	± .045"
6" - 12"	± .060"
12" plus	± .060" ± .002 in/in

F. DIMENSION BETWEEN CORE & MOLD

Refer to chart E

G. PARTING LINE FINIS

± .060" Commercial quality
otherwise up charge

H. GATE & RISER CONNECTION

± .060" Commercial quality
otherwise up charge

I. PATTERN MISMATCH

0" - 16"	± .031"
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