



Casting Tolerances (English)	
0 - 4 in.	+/- 0.030"
4 - 6 in.	+/- 0.045"
6 - 12 in.	+/- 0.060"
12 - 18 in.	+/- 0.090"
18 - 24 in.	+/- 0.120"
> 24 in.	+/- 0.150"
Angular	+/- 1 Degrees
Shift < 6 in.	0.031"
Shift > 6 in.	0.062"
Draft Angle	3 Degrees Minimum

Casting Tolerances (Metric)	
0 - 102 mm	+/- 0.8 mm
102 - 152 mm	+/- 1.2 mm
152 - 305 mm	+/- 1.5 mm
305 - 457 mm	+/- 2.3 mm
457 - 610 mm	+/- 3.2 mm
over 610 mm	+/- 3.8 mm
Angular	+/- 1 Degrees
Shift < 152.4 mm	0.8 mm
Shift > 152.4 mm	1.6 mm
Draft Angle	3 Degrees Minimum

Finishing Tolerances (English)	
Gate & Riser Contacts	+0.060" , -0.030"
Core & Parting Line Flash	+0.060" , -0"
Surface Finish	400 - 600 RMS

Finishing Tolerances (Metric)	
Gate & Riser Contacts	+0.8 mm , -0.8 mm
Core & Parting Line Flash	+1.5 mm , 0 mm
Surface Finish	400 - 600 RMS

Machining Tolerances (English) (Unless Otherwise Specified)	
.XXX (3 PL)	+/- 0.005"
.XX (2 PL)	+/- 0.015"
.X (1 PL)	+/- 0.030"
Fractional Dimensions	+/- 1/32"
Angular Dimensions	+/- 5 Degrees
Cast to Machining Dims.	+/- 1/32"
Machined Chamfers	+/- 10 Degrees
Machined Stock per Surface	+/- 0.090"

Machining Tolerances (Metric) (Unless Otherwise Specified)	
.XXX (3 PL)	+/- 0.13 mm
.XX (2 PL)	+/- 0.38 mm
.X (1 PL)	+/- 0.76 mm
Fractional Dimensions	+/- 0.80 mm
Angular Dimensions	+/- 5 Degrees
Cast to Machining Dims.	+/- 0.80 mm
Machined Chamfers	+/- 10 Degrees
Machined Stock per Surface	2.30 mm