



StandardTolerance_table Prototype cast metal die-cast

Process	Aluminum Die Casting	Investment Casting	Plaster Mold
Size Range	Ounces to 50 lbs	Up to 250 lbs	Ounces to 50 lbs
Tolerances	±.002" to 1"	± .005" to 1"	±.005" to 2"
Tolerances inches/inch thereafter	±.002"	±.005"	±.001"
Parting Line Shift	±.005" up to 10 sq-in	N/A	±.010"
Min. Section Thickness (premium)	.060"	.050"	.060"
Min. Section Thickness (average)	.110"	.080"	.080"
Min. Draft Required	0.5 to 3 degrees	Zero	1 to 3 degrees
Surface Finish (RMS)	32 to 125	60 to 90	63 to 125
Metals	Aluminum 360 380 413 Zinc ZA-8 ZA-12 ZA-27 Magnesium- AZ91D	All Castable Alloys	Aluminum Zinc Magnesium Brass

Note that the values represent normal production practice at the most economical level. Greater accuracy should only be specified where required to avoid additional prices. Disclaimer: All tolerance specifications

reflect the approximate range of a process's capabilities and should be viewed only as a guide. Actual capabilities are dependent upon manufacturing, equipment, material, and part requirements.