



# PREMIUM INVESTMENT CASTING TOLERANCES

Obtainable Under Special Conditions

- General Coordinate Tolerance:

Inches		Millimeters	
Dimension	Tolerance	Dimension	Tolerance
Up to 0.500	±.004"	Up to 12.0	± 0.10mm
0.500 to 1.000"	±.006"	12.0 to 25.0	± 0.15mm
1.000 to 1.500"	±.008"	25.0 to 37.0	± 0.20mm
1.500 to 2.000"	±.010"	37.0 to 50.0	± 0.25mm
2.000 to 2.500"	±.012"	50.0 to 62.0	± 0.30mm
2.500 to 3.500"	±.014"	62.0 to 87.0	± 0.35mm
3.500 to 5.000"	±.017"	87.0 to 125.0	± 0.40mm
5.000 to 7.500"	±.020"	125.0 to 190.0	± 0.50mm
7.500 to 10.000"	±.022"	190.0 to 250.0	± 0.57mm
10.000 to 12.500"	±.025"	250.0 to 312.0	± 0.60mm
12.500 to 15.000	±.028"	312.0 to 375.0	± 0.70mm
Each additional inch add ± .001"		Each additional 25mm add ± .025mm	

- Surface finish to be minimum RMS  $125\sqrt{\quad}$  or better.
- Unless otherwise specified:
  - Fillet radii to be: .060" MIN. Recommended
  - Corner radii to be: .060" MAX.
  - Angular tolerance: +/- 0.5 degree
- Machining stock 0.040" minimum, if required.
- Minimum wall thickness .030" +/- .010" can be achieved.