



## TOLERANCES FOR CHILL CASTING

### No responsibility is taken for the correctness of this information

Dimensional deviations at raw formed parts made of light metal alloys produced by chill casting mainly depend on:

- the dimensional exactness of the chill defined by the class of accuracy;
- the position of the chill parting line, of cores and sliders defined by the division of dimensions into bound to the mold and not bound to the mold;
- the nominal dimensions.

### Allowable deviations for linear dimensions

(length, width, height, distance from center to center, diameter, curves)

Class of accuracy	Function of mold	Nominal Dimension Range													
		up to 18	over 18 up to 30	over 30 up to 50	over 50 up to 80	over 80 up to 120	over 120 up to 180	over 180 up to 250	over 250 up to 315	over 315 up to 400	over 400 up to 500	over 500 up to 630	over 630 up to 800	over 800 up to 1000	over 1000 up to 1250
GTA 15/5	mold related	± 0,45	± 0,5	± 0,6	± 0,75	± 0,85	± 1	± 1,2	± 1,3	± 1,4	± 1,6	± 1,7	± 2	± 2,3	± 2,6
	not mold related	± 0,55	± 0,65	± 0,8	± 0,95	± 1,1	± 1,3	± 1,5	± 1,6	± 1,8	± 2	± 2,2	± 2,5	± 2,8	± 3,3

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## Allowable deviations for thickness dimensions without tolerance indication (wall thickness, bars, ribs)

Class of accuracy	Function of mold	Nominal Dimension Range		
		up to 6	over 6 up to 10	over 10 up to 18
GTA 15/5	mold related	± 0,6	± 1,2	± 1,8
	not mold related	± 0,8	± 1,5	± 2,2

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Dimensions bound to the mold are dimensions in the same part of the mold.  
 Dimensions not bound to the mold are dimensions formed by the interaction of movable mold parts such as wall thickness and bottom thickness dimensions or dimensions influenced by inserts or sliders.



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