



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		Nominal Dimension Range											
		≤ 10	>10 ≤16	>16 ≤25	>25 ≤40	>40 ≤63	>63 ≤100	>100 ≤160	>160 ≤250	>250 ≤400	>400 ≤630	>630 ≤1000	>1000 ≤1250
GTA 15/5	DCTG8	± 0,5	± 0,55	± 0,6	± 0,65	± 0,7	± 0,8	± 0,9	± 1,0	± 1,1	± 1,3	± 1,4	± 1,6

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

Class of accuracy		Nominal Dimension Range		
		≤ 10	>10 ≤16	>16 ≤18
GTA 15/5	DCTG9	± 0,75	± 0,8	± 0,85

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