

GENERAL DESIGN DATA SHEET

	Sand Casting Process	V-Process Casting	Investment Casting Process	Graphite Permanent Mold Process	Steel Die Permanent Mold Process	Die Casting Process	Plaster Mold Process
Size Range	Ounces to Tons	Up to 150 lbs.	Up to 250 lbs.	Up to 6 lbs.	Up to 100 lbs.	Ounces to 50 lbs.	Ounces to 50 lbs.
Tolerances	+/- 1/32 to 6"	+/- .010" to 1"	+/- .005" to 3"	+/- .005" to 1"	+/- .015" to 1"	+/- .002" to 1"	+/- .005" to 2"
Tolerance inches / inch thereafter	+/- .003"	+/- .002"	+/- .003"	+/- .002"	+/- .002"	+/- .002"	+/- .002"
Parting Line Shift	+/- .020" to .060"	+/- .020"	N/A	+/- .005"	+/- .010" to .030"	+/- .005"	+/- .010"
Min. Section Thickness	.125"	.090" premium .125" average	.060" premium .080" average	.090" premium .120" average	.125" premium .187" average	.030" premium .060" average	.060" premium .080" average
Min. Draft Required	2 to 5 degrees	Zero	Zero	1 to 3 degrees	2 to 4 degrees	1 to 3 degrees	1 to 3 degrees
Surface Finish	250 to 500 RMS	125 to 150 RMS	60 to 90 RMS	63 to 90 RMS	150 to 300 RMS	32 to 63 RMS	63 to 125 RMS
Average Tooling Cost	\$1K to \$4K	\$3K to \$6K	\$2K to \$9K	\$3K to \$8K	\$5K to \$15K	\$5K to \$100K	\$3K to \$9K
Average Tooling Lead-time	2 to 6 weeks	2 to 4 weeks	6 to 8 weeks	2 to 4 weeks	8 to 20 weeks	12 to 16 weeks	2 to 6 weeks
Typical Order Quantity	All	All	All	All	500 +	5,000 +	1 to 250 pcs.
Metals	Most all Castable Alloys	Aluminum 319 356 535	All Castable Alloys	Aluminum 356 319 ZA-12 ZA-27	Aluminum Bronze Iron Lead	Aluminum 360 380 413 Zinc Zamac 3 Zamac 5 ZA-8 ZA-12 ZA-27 Magnesium	Aluminum Zinc Magnesium Brass

For more information or a competitive quote please contact:

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Note: The above information is meant to be a basic guideline for comparison purposes only.