



Precision
Products, Inc.

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NO-BAKE SAND MOLD CASTING TOLERANCES

NORMAL

DIMENSION TOLERANCE

<u>Inches</u>	<u>MM</u>	<u>Inches</u>	<u>MM</u>
Up to 2	Up to 50	± .020	± .50
Up to 3	Up to 75	± .023	± .58
Up to 4	Up to 100	± .026	± .66
Up to 5	Up to 125	± .029	± .74
Up to 6	Up to 150	± .032	± .81
Up to 7	Up to 175	± .035	± .89
Up to 8	Up to 200	± .038	± .97
Up to 9	Up to 225	± .041	± 1.04
Up to 10	Up to 250	± .044	± 1.12
Maximum Variation		± .0625	± 1.59

Note: The normal rule for tolerances on dimensions which go to or across any parting line or core set is an additional .020".

Normal draft angles used in the No-Bake Sand Mold Process can vary from a minimum 2 degrees.