

Length Tolerances

Nominal dimension of the molded part up to ... mm	Length dimension tolerances according to the degree of tolerance (DCTG)						
	7	8	9	10	11	12	13
10	0.74	1.00	1.50	2.00	2.80	4.20	-
16	0.78	1.10	1.60	2.20	3.00	4.40	-
25	0.82	1.20	1.70	2.40	3.20	4.60	6.00
40	0.90	1.30	1.80	2.60	3.60	5.00	7.00
63	1.00	1.40	2.00	2.80	4.00	5.60	8.00
100	1.10	1.60	2.20	3.20	4.40	6.00	9.00
160	1.20	1.80	2.50	3.60	5.00	7.00	10.00
250	1.40	2.00	2.80	4.00	5.60	8.00	11.00
400	1.60	2.20	3.20	4.40	6.20	9.00	12.00
630	1.80	2.60	3.60	5.00	7.00	10.00	14.00
1,000	2.00	2.80	4.00	6.00	8.00	11.00	16.00
1,600	2.20	3.20	4.60	7.00	9.00	13.00	18.00
2,500	2.60	3.80	5.40	8.00	10.00	15.00	21.00
4,000	-	4.40	6.20	9.00	12.00	17.00	24.00
6,300	-	-	7.00	10.00	14.00	20.00	28.00
10,000	-	-	-	11.00	16.00	23.00	32.00
				Individual units, small batches, hand-formed			
				Series production, hand-formed			
	Series production, machine-formed						



- The next higher degree applies to wall thicknesses
- One degree of tolerance greater is recommended for complicated castings
- Recommended values apply for light metal sand casting
- The next higher degree of tolerance for series production is recommended for copper alloys; the next higher values is recommended for individual production

Tables based on Technical Guidelines for "Sand and Gravity Die Casting from Aluminum" of the BDG (German Foundry Industry Association), February 2010, based on DIN EN ISO 8062-3