

Machining Allowances

Maximum dimension up to ... mm	Required machining allowance (mm) according to degree (RMAG)			
	E	F	G	H
40	0.4	0.5	0.5	0.7
63	0.4	0.5	0.7	1.0
100	0.7	1.0	1.4	2.0
160	1.1	1.5	2.2	3.0
250	1.4	2.0	2.8	4.0
400	1.8	2.5	3.5	5.0
630	2.2	3.0	4.0	6.0
1,000	2.5	3.5	5.0	7.0
1,600	2.8	4.0	5.5	8.0
2,500	3.2	4.5	6.0	9.0
4,000	3.5	5.0	7.0	10.0
6,300	4.0	5.5	8.0	11.0
10,000	4.5	6.0	9.0	12.0
		hand-formed		
	machine-formed			



- Casting tolerances must likewise be respected for machining allowances and additionally apply
- Recommended values apply for sand casting

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