

10632 Alondra Blvd., Norwalk, California, USA

www.aerotecalloys.com

INVESTMENT CASTING LINEAR TOLERANCE

DIMENSION	NORMAL	PREMIUM
UP TO 1"	± .010	± .005
UP TO 2"	± .013	± .010
UP TO 3"	± .016	± .013
UP TO 4"	± .019	± .015
UP TO 5"	± .022	± .017
UP TO 6"	± .025	± .020
UP TO 7"	± .028	± .022
UP TO 8"	± .031	± .024
UP TO 9"	± .034	± .026
UP TO 10"	± .037	± .030

ALLOW ±.005 PER INCH FOR DIMENSIONS GRATER THAN 10"

As a general rule normal linear tolerances on investment castings are as follows: Up to 1" ± .010, for each additional inch up to ten inches ± .003 per inch. For dimensions greater than ten inches allow ± .005 per inch. Secondary operations such as straightening and sizing will produce closer dimensional tolerancing. *It should also be understood that in applications such as gas turbines, defense and aerospace oriented products, very much closer (PREMIUM) tolerances are routinely achieved.*