



Metallurgische Erzeugnisse

Ihr Beschaffungs-Dienstleister

### GENERAL CASTING TOLERANCE

Zeichnungsmasse				Toleranz-Level ( CT )																							
von		bis		3		4		5		6		7		8		9		10		11		12		13			
mm	Inch	mm	Inch	mm	Inch	mm	Inch	mm	Inch	mm	Inch	mm	Inch	mm	Inch	mm	Inch	mm	Inch	mm	Inch	mm	Inch	mm	Inch		
—	—	10	.394	$\pm 0.09$	.004	$\pm 0.13$	.005	$\pm 0.18$	.007	$\pm 0.26$	.010	$\pm 0.37$	.015	$\pm 0.5$	.020	$\pm 0.75$	.030	$\pm 1.0$	.039	$\pm 1.4$	.055	$\pm 2.1$	.083	—	—		
10	.394	16	.630	$\pm 0.1$	.004	$\pm 0.14$	.006	$\pm 0.19$	.007	$\pm 0.27$	.011	$\pm 0.39$	.015	$\pm 0.55$	.021	$\pm 0.8$	.031	$\pm 1.1$	.043	$\pm 1.5$	.060	$\pm 2.2$	.087	—	—		
16	.630	25	.984	$\pm 0.11$	.004	$\pm 0.15$	.006	$\pm 0.21$	.008	$\pm 0.29$	.011	$\pm 0.41$	.016	$\pm 0.6$	.024	$\pm 0.85$	.033	$\pm 1.2$	.047	$\pm 1.6$	.063	$\pm 2.3$	.091	$\pm 3$	.118		
25	.984	40	1.574	$\pm 0.12$	.005	$\pm 0.16$	.006	$\pm 0.23$	.009	$\pm 0.32$	.013	$\pm 0.45$	.018	$\pm 0.65$	.026	$\pm 0.9$	.035	$\pm 1.3$	.051	$\pm 1.8$	.071	$\pm 2.5$	.100	$\pm 3.5$	.138		
40	1.574	63	2.480	$\pm 0.13$	.005	$\pm 0.18$	.007	$\pm 0.25$	.010	$\pm 0.35$	.014	$\pm 0.5$	.020	$\pm 0.7$	.025	$\pm 1.0$	.039	$\pm 1.4$	.055	$\pm 2.0$	.079	$\pm 2.8$	.110	$\pm 4$	.157		
63	2.480	100	3.937	$\pm 0.14$	.006	$\pm 0.20$	.008	$\pm 0.28$	.011	$\pm 0.39$	.015	$\pm 0.55$	.021	$\pm 0.8$	.031	$\pm 1.1$	.043	$\pm 1.6$	.063	$\pm 2.2$	.087	$\pm 3$	.118	$\pm 4.5$	.177		
100	3.937	160	6.300	$\pm 0.15$	.006	$\pm 0.22$	.009	$\pm 0.31$	.012	$\pm 0.44$	.017	$\pm 0.6$	.024	$\pm 0.9$	.035	$\pm 1.25$	.049	$\pm 1.8$	.071	$\pm 2.5$	.100	$\pm 3.5$	.138	$\pm 5$	.197		
160	6.300	250	9.843	$\pm 0.17$	.007	$\pm 0.25$	.010	$\pm 0.35$	.014	$\pm 0.5$	.020	$\pm 0.7$	.028	$\pm 1.0$	.039	$\pm 1.4$	.055	$\pm 2.0$	.079	$\pm 2.8$	.110	$\pm 4$	.157	$\pm 5.5$	.216		
250	9.843	400	15.748	$\pm 0.20$	.008	$\pm 0.28$	.011	$\pm 0.39$	.015	$\pm 0.55$	.021	$\pm 0.8$	.031	$\pm 1.1$	.043	$\pm 1.6$	.063	$\pm 2.2$	.087	$\pm 3.1$	.122	$\pm 4.5$	.177	$\pm 6$	.236		
400	15.748	630	24.803	—	—	$\pm 0.32$	.013	$\pm 0.45$	.018	$\pm 0.6$	.024	$\pm 0.9$	.035	$\pm 1.3$	.051	$\pm 1.8$	.071	$\pm 2.5$	.100	$\pm 3.5$	.138	$\pm 5$	.197	$\pm 7$	.276		
630	24.803	1000	39.370	—	—	—	—	$\pm 0.5$	.020	$\pm 0.7$	.028	$\pm 1.0$	.039	$\pm 1.4$	.055	$\pm 2.0$	.079	$\pm 3.0$	.118	$\pm 4.0$	.157	$\pm 5.5$	.216	$\pm 8$	.315		
1000	39.370	1600	62.992	—	—	—	—	—	—	$\pm 0.8$	.031	$\pm 1.1$	.043	$\pm 1.6$	.063	$\pm 2.3$	.091	$\pm 3.5$	.138	$\pm 4.5$	.177	$\pm 6.5$	.256	$\pm 9$	.354		
1600	62.992	2500	98.425	—	—	—	—	—	—	—	—	$\pm 1.3$	.051	$\pm 1.9$	.075	$\pm 2.7$	.106	$\pm 4.0$	.157	$\pm 5$	.197	$\pm 7.5$	.295	$\pm 10.5$	.413		
2500	98.425	4000	157.48	—	—	—	—	—	—	—	—	—	—	$\pm 2.2$	.087	$\pm 3.1$	.122	$\pm 4.5$	.177	$\pm 6$	.236	$\pm 8.5$	.335	$\pm 12$	.472		
4000	157.48	6300	248.03	—	—	—	—	—	—	—	—	—	—	—	—	$\pm 3.5$	.138	$\pm 5.0$	.197	$\pm 7$	.276	$\pm 10$	.394	$\pm 14$	.551		
6300	248.03	10000	393.70	—	—	—	—	—	—	—	—	—	—	—	—	—	—	$\pm 5.5$	.216	$\pm 8$	.315	$\pm 11.5$	.453	$\pm 16$	.630		



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### GENERAL CASTING TOLERANCE LEVEL (CT)

Casting Process	Cast Steel	Gray Cast Iron	Nodular Iron	Malleable Iron	Copper Alloy	Zinc Alloy
Hand molding	11-13	11-13	11-13	11-13	10-12	9-11
Machine molding	8-10	8-10	8-10	8-10	8-10	7-9
Metal mold		7-9	7-9	7-9	7-9	6-8
Low-pressure die casting		7-9	7-9	7-9	7-9	6-8
Die casting					6-8	5-7
Investment casting	5-7	5-7	5-7		4-6	4-6