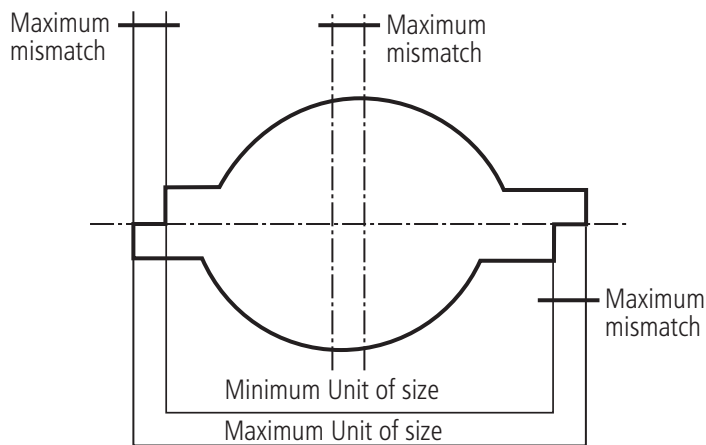


CASTING TOLERANCES

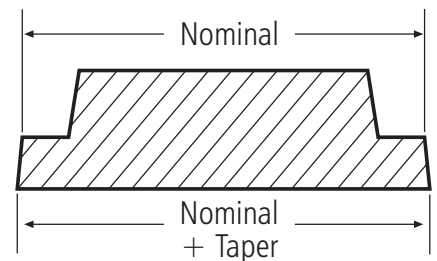
Castings tolerances are dependent on both the materials cast and the method of production used. General Tolerances for metal alloy castings are specified by the International Standards Organization, in their Standard ISO 8062 for SG (and Malleable) Iron castings, made in machine produced sand moulds. The appropriate grades are Casting Tolerance (CT) 8 to 12. The capability of our green sand plants enables us to offer castings conforming to Grade CT8. Castings produced in Hand or Airset moulds will conform to grade CT9. These 2 grades are detailed in the table below:

Raw Casting Basic (mm)		Total Tolerance (mm)	
Over <i>Uber</i> Plus de	Up to and including <i>bis jusqu'a et y compris</i>	CT8	CT9
	10	1.0	1.5
10	16	1.1	1.6
16	25	1.2	1.7
25	40	1.3	1.8
40	63	1.4	2.0
63	100	1.6	2.2
100	160	1.8	2.5
160	250	2.0	2.8
250	400	2.2	3.2
400	630	2.6	3.6
Mismatch (not to be added to values above)		0.7	1.0

* Closer Tolerances may be offered in specific instances.



Unless otherwise specified mismatch shall lie within the tolerance shown.



Unless otherwise specified the taper shall be added to the nominal dimension. It is not part of the tolerance.

CASTING TOLERANCES