

Technical Data for Design Reference

线性公差 (mm) Linear Tolerance

尺寸范围Dimensions	一般公差Normal	特别公差Premium
0-10	±0.12	±0.1
10-15	±0.20	±0.13
15-20	±0.25	±0.15
20-30	±0.30	±0.20
30-50	±0.40	±0.25
50-75	±0.50	±0.35
75-100	±0.65	±0.45
100-125	±0.8	±0.60
125-150	±1.0	±0.70
150-175	±1.2	±0.80
175-200	±1.5	±0.90
200-250	±1.8	±1.1
> 250	±0.8%	±0.5%

可铸出孔槽的极限尺寸 Limit Dimensions for Cast Holes and Slots

项目Items	孔槽范围 (mm)Hole Dia.	孔深/孔径L/D
	Ø 2 --- Ø 3	L/D ≤ 2
	Ø 4 --- Ø 7	L/D ≤ 5
	≥ Ø 8	L/D ≤ 10
	Ø 2 --- Ø 3	L/D ≤ 1
	Ø 4 --- Ø 7	L/D ≤ 2.5
	≥ Ø 8	L/D ≤ 3.5

利用水溶型芯和陶瓷型芯，我们可以铸出更深和更复杂的孔和槽。
Deeper and more complicated holes and slots can be casted by using soluble wax and ceramic cores.

角度公差 Angle Tolerance

角度形式 Angle Type			
一般公差Normal	±1°	±2°	±2°
特殊公差Premium	±0.5°	±1°	±1°

铸件结构应避免急剧变化，尽可能避免尖角，圆角应达到R 0.3以上。
Avoid the quick changes of casting structure, use fillet radius on internal angle when possible, which is no less than R 0.3.

平面度、直线度、圆度公差 Tolerance for Flatness, Straightness and Roundness

铸件尺寸 (mm) Dimensions	一般公差 Normal	特殊公差 Premium
0-25	0.2	0.1
25-50	0.4	0.2
50-100	0.6	0.3
100-150	0.8	0.4

平面度、直线度、圆度公差 Tolerance for Flatness, Straightness and Roundness

项目 Item	范围 Size	最优 Premium
轮廓尺寸 (mm) Outline Dimension	1000*620*380	<100
重量 (kg) Weight	0.001-80	0.1-1.5
最小壁厚 Min. Wall Thickness	0.5	5-10

表面粗糙度 (Ra/μm) Surface Roughness

铸造状态 Rough Castings	重量 (Weight) > 5kg, 主要壁厚 > 12mm Main Wall Thickness	3.2 - 6.3	<p>我公司有能力对铸件表面作如下精整处理：对于碳钢和低合金钢，可作发黑、镀锌、镀铬、镀镍处理；对于不锈钢，可作研磨、手工拉丝抛光及镜面抛光、电抛光、钝化处理；所有钢种可作喷砂（玻璃砂、钢玉砂、石英砂）处理。</p> <p>The surface finish for the castings we can provide with are as the follows: Blacking, Zinc plating, Chrome Plating, and Nickel Plating for the carbon steel and the low alloy steel castings; Tumbling, handcraft dull polishing, mirror polishing, electrolytic polishing and Passivation treatment for the stainless steel castings and sandblasting, including glass bead blasting, corundum-sand blasting and quartz-sand blasting for all the steel castings.</p>
	重量 (Weight) < 5kg, 主要壁厚 < 12mm Main Wall Thickness	1.6 - 3.2	
精整状态 Finished Castings		0.8 - 1.6	