



EAGLE
ALUMINUM CAST PRODUCTS, INC.

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Eagle Aluminum's Dimensional Tolerance Standards

The following are the normal tolerances that can be applied to as cast parts produced from each available process. Any deviation from these guidelines will be considered on a case by case basis. Specific part geometry may require or allow an increase or decrease in tolerance from this standard. Subsequent operations (e.g. grinding, machining, etc.) may improve tolerance on specific dimensions.

PERMANENT MOLD

Tolerances

1 st inch	+/- .015"
Additional inch	+/- .002"
Across Parting Line	Additional +/- .010" for 0in²-10in² Additional +/- .015" for 10in²-50in² Additional +/- .020" for 50in²-100in²
Draft	2 – 4 degrees
As-Cast RMS Finish	125/175
Min. Wall Thickness	.100"

GREEN SAND

Tolerances

1 – 6 inches	+/- .030-.060
Each inch over 6 inches	Additional .003"
Across Parting Line	Additional .030"
Draft	1 - 5 degrees
As-Cast RMS Finish	150/350
Min. Wall Thickness	.250"

Note: Angles can range from sharp to .060" on radii / fillets. It depends on design of casting.