

尺寸公差 DIMENSION TOLERANCE

线性公差 Linear Tolerance (参照德国熔模铸造公差标准 VDG Merkblad P690)

基本尺寸 (mm) Nominal dimension		长 宽 高 (mm) Length, width, height						中心距 (mm) Centre line distances	
		D1		D2		D3		D1	D2
> From	≤ To	公差 Tolerance	公差带 Field	公差 Tolerance	公差带 Field	公差 Tolerance	公差带 Field	公差 Tolerance	公差 Tolerance
0	6	±0.10	0.20	±0.08	0.16	±0.06	0.12	±0.25	±0.16
6	10	±0.12	0.24	±0.10	0.20				
10	14	±0.15	0.30	±0.12	0.24				
14	18	±0.20	0.40	±0.14	0.28	±0.09	0.18	±0.32	±0.20
18	24	±0.25	0.50	±0.17	0.34				
24	30	±0.30	0.60	±0.20	0.40	±0.14	0.27	±0.50	±0.30
30	40	±0.37	0.74	±0.25	0.50	±0.17	0.33		
40	50	±0.44	0.88	±0.30	0.60	±0.20	0.39	±0.71	±0.45
50	65	±0.52	1.04	±0.38	0.76	±0.23	0.46		
65	80	±0.60	1.20	±0.46	0.92	±0.27	0.53	±0.90	±0.60
80	100	±0.68	1.38	±0.53	1.06	±0.30	0.60		
100	120	±0.76	1.52	±0.60	1.20	±0.33	0.66	±1.15	±0.85
120	140	±0.84	1.68	±0.65	1.30	±0.36	0.71		
140	160	±0.92	1.84	±0.72	1.44	±0.38	0.76	±1.80	±1.00
160	180	±1.02	2.04	±0.80	1.60	±0.42	0.81		
180	200	±1.12	2.24	±0.88	1.76	±0.43	0.86	±2.20	±1.25
200	225	±1.28	2.56	±0.95	1.90	±0.47	0.93		
225	250	±1.44	2.88	±1.05	2.10	±0.51	1.02	±2.60	±1.60
250	280	±1.64	3.28	±1.15	2.30	±0.56	1.12		
280	315	±1.84	3.68	±1.25	2.50	±0.63	1.26	±2.60	±1.60
315	355	±2.10	4.20	±1.40	2.60	±0.71	1.42		
355	400	±2.40	4.80	±1.60	3.20	±0.80	1.60		

D1: 为通常使用的一般尺寸公差
D2: 适用于有公差要求的重要尺寸
D3: 需要采取矫正等特殊措施才能达到, 限于少数有特殊要求的尺寸。

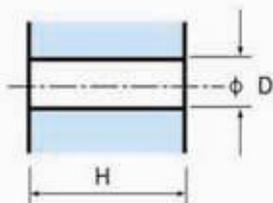
D1: General dimension tolerances
D2: Applicable to important dimensions requiring close tolerances
D3: Premium tolerances require additional operations at extra cost, only applied to a few special dimensions.

角度公差: $\pm 0.5^\circ \sim \pm 1^\circ$
直线度: 每 25mm 误差 0.127mm

Angle Tolerance: $\pm 0.5^\circ$ to $\pm 1^\circ$
Straightness: 0.005" per inch

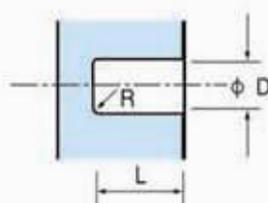
铸造能力范围 OUR CASTING CAPABILITY

1) 铸孔深度 Depth of casting hole



通孔 Through Hole

$D \leq 7 \text{ mm} : H \leq 2D$
 $D > 7 \text{ mm} : H \leq 3D$
 $D > 13 \text{ mm} : H \leq 4D$
 $D_{\min} = 2 \text{ mm}$



盲孔 Blind Hole

$D \leq 7 \text{ mm} : L \leq 1D$
 $D > 7 \text{ mm} : L \leq 1.5D$
 $D > 13 \text{ mm} : L \leq 2D$
 $D_{\min} = 2 \text{ mm}$

用陶瓷型芯可铸出更深的孔, 但会额外增加费用, 只适宜于大批量生产。

The scope can be enlarged by the use of pre-formed ceramic cores at additional cost, only economical for large quantities.

2) 最小壁厚 Minimum wall thickness : 2 mm

(小范围 1mm, 1mm for small area)

3) 铸造圆角 Radius of Rounds and fillets :

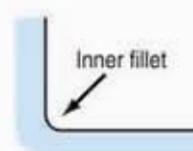
4) 表面粗糙度 Surface Roughness : Ra3.2

5) 铸件重量 Casting Weight : 5 g-10 kg

6) 年生产能力 Annual output : 500 tons.



$R \geq 0.3 \text{ mm}$



$R \geq 0.5 \text{ mm}$