

Linear Dimensional Casting Tolerance Grades (DCTG)

Nominal Dimension related to the Moulded part, mm		Pattern	Pattern Core Complex	Sand Printed	DCTG5	DCTG6	DCTG7	DCTG8	DCTG9	DCTG10	DCTG11	DCTG12	DCTG13
-	≤ 10				0.36	0.52	0.74	1.00	1.50	2.00	2.80	4.20	-
> 10	≤ 16				0.38	0.54	0.78	1.10	1.60	2.20	3.00	4.40	-
> 16	≤ 25				0.42	0.58	0.82	1.20	1.70	2.40	3.20	4.60	6.00
> 25	≤ 40				0.46	0.64	0.90	1.30	1.80	2.60	3.60	5.00	7.00
> 40	≤ 63				0.50	0.70	1.00	1.40	2.00	2.80	4.00	5.60	8.00
> 63	≤ 100				0.56	0.78	1.10	1.60	2.20	3.20	4.40	6.00	9.00
> 100	≤ 160				0.62	0.88	1.20	1.80	2.50	3.60	5.00	7.00	10.00
> 160	≤ 250				0.70	1.00	1.40	2.00	2.80	4.00	5.60	8.00	11.00
> 250	≤ 400				0.78	1.10	1.60	2.20	3.20	4.40	6.20	9.00	12.00
> 400	≤ 630				0.90	1.20	1.80	2.60	3.60	5.00	7.00	10.00	14.00
> 630	≤ 1000				1.00	1.40	2.00	2.80	4.00	6.00	8.00	11.00	16.00
> 1000	≤ 1600				-	1.60	2.20	3.20	4.60	7.00	9.00	13.00	18.00

DCTG 9 – 12 Sand Casting, Hand Moulding

DCTG 7 – 9 Sand Casting and Sand Printed Moulding

DCTG 6 – 8 Permanent mould casting. Gravity and Low Pressure Die casting

DCTG 5 – 7 Pressure Die casting: Use of tight tolerance grade (DCTG 5) to be agreed by case. Note 4

Note 1: The tolerance grades indicated are those which can normally be held for castings produced for long series and if production factors influencing the dimensional accuracy of the casting have been fully developed.

Note 2: For complex castings, one grade coarser is recommended

Note 3: For wall thickness, one grade coarser applies

Note 4: Differs, from original standard text.