

## Pentz Cast Solutions

### Dimension Tolerance Tables

#### Basic Linear Tolerances for Each Mold Half

Tolerance Range	Green Sand Process		Permanent Mold Process	
	Typical Industry	Pentz	Typical Industry	Pentz
0"-6"	.06"	.03"	.06"	.03"
Additional over 6"	+.004"/in	+.002"/in	+.005"/in	+.003"/in

#### Additional Tolerances for Dimensions Across Parting Lines

Projected Area	Green Sand Process		Permanent Mold Process	
	Typical Industry	Pentz	Typical Industry	Pentz
0"-10"	.04"	.02"	.02"	.02"
11"-50"	.06"	.03"	.03"	.02"
51"-100"	.08"	.04"	.04"	.03"
Above 100"	Contact Pentz Design Engineer			

#### Typical Machine Finish Allowances

Projected Area	Green Sand Process	Permanent Mold Process
0"-6"	.060"	.045"
7"-12"	.090"	.060"
13"-18"	.120"	.075"
18"-24"	.180"	.090"
Over 24"	Contact Pentz Design Engineer	