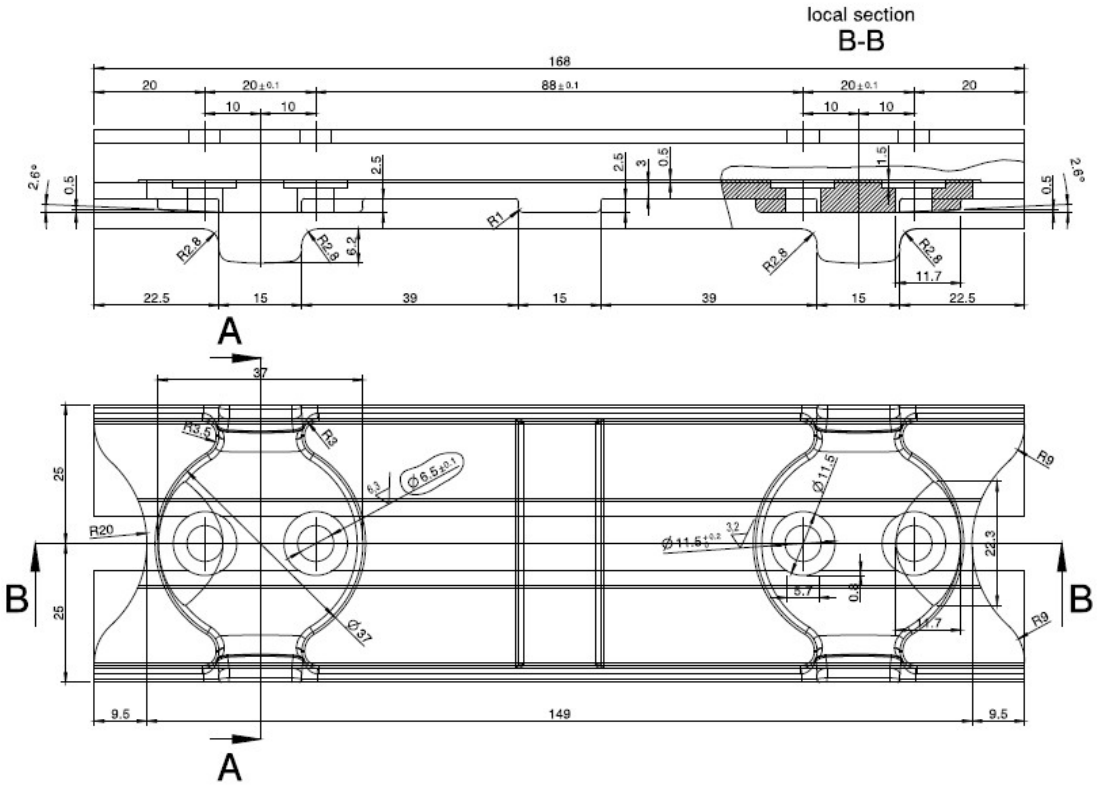
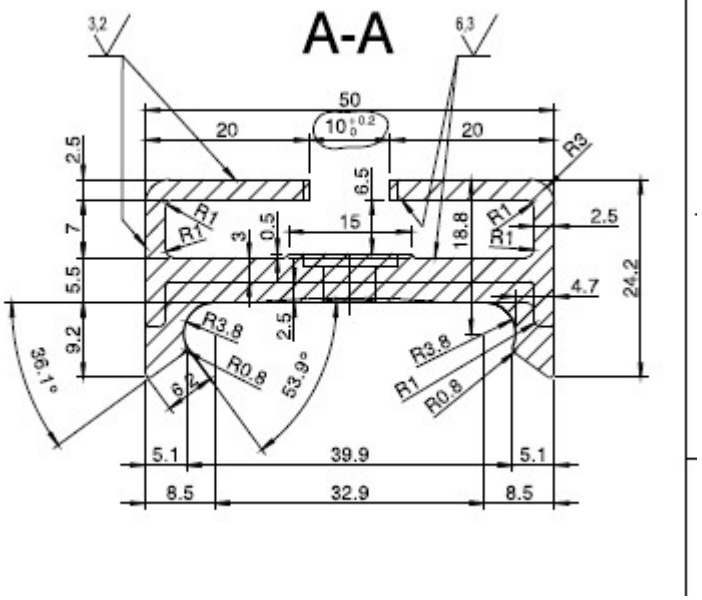

local section
B-B
168
20
20 ±0.1
88 ±0.1
10
10
2.6°
0.5
2.5
3
1.5
R1
R2.8
6.2
11.7
22.5
15
39
A
37
R3.5
R3
Ø6.5 ±0.1
6.2
R20
B
25
Ø37
Ø11.5
Ø11.6 +0.2 +0.1
3.2
24.3
6.7
0.8
R9
9.5
149


A-A
3.2
6.3
50
20
10 +0.2 0
R3
2.5
6.5
7
R1
0.5
15
18.8
5.5
4.7
24.2
9.2
R3.8
R0.8
53.9°
36.1°
6.2
5.1
39.9
8.5
32.9

INVESTMENT CASTINGS: Alloys based on iron, nickel, cobalt and cooper

P 690 (VDG - Reference sheet)

D1 - applies for all untoleranced dimension

~~D2 - applies for all dimensions to be toleranced~~

~~D3 - can only met for certain dimensionsand must be agreed with the castings manufacturer~~

~~N9 - surface roughness = 6.3 µm~~

Linear Tolerances (= Length tolerances) [mm]

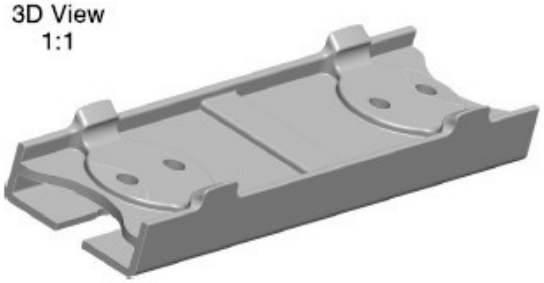
Accuracy-grade	bis 6	6 bis 10	10 bis 18	18 bis 30	30 bis 50	50 bis 80	80 bis 120	120 bis 180	180 bis 250	250 bis 315	315 bis 400
D 1	±0.15	±0.18	±0.22	±0.26	±0.4	±0.45	±0.55	±0.8	±1.2	±1.3	±1.8
~~D 2~~	~~±0.12~~	~~±0.14~~	~~±0.17~~	~~±0.2~~	~~±0.31~~	~~±0.37~~	~~±0.44~~	~~±0.65~~	~~±0.85~~	~~±1.1~~	~~±1.4~~
~~D 3~~	~~±0.1~~	~~±0.11~~	~~±0.14~~	~~±0.17~~	~~±0.25~~	~~±0.3~~	~~±0.35~~	~~±0.5~~	~~±0.75~~	~~±0.8~~	

Next tolerances: Planar + Roundness, Symmetric, Wall thickness, Rounds, etc.see P690

- STRAIN FREE
- FREE FROM CRACKS
- SURFACE QUALITY - outside: Ra ≤ 3.2µm
  - inside: Ra ≤ 6.3µm
- ACID CLEANING
- MATERIAL ACCORDING TO EN 10088

Pcs.	Description	Material	Position number	Weight
230000	casting 24 x 50 ... 168	1.4462	U_TP-103-01	0.475

3D View
1:1





Rev	Description	Date	Name	Appr.
N	Tolerance	09.12.11	she	zko
M	Wall thickness	16.09.11	mto	zko
L2	Tolerance	20.09.11	mto	zko
L	Wall thickness, Radius	14.09.11	mto	zko
K	Surface quality	18.08.11	mto	zko
...				

Illustration: C - Channel 24 x 50...168

Drawn by: she Chd.: zko Date: 25.03.2011

Project-No.: 9239 Scale: 2:1 Drw-No.: U_TP-103-01