

## Comparison Table of Common Casting Process Properties

			Sand	Gravity	Pressure
Tolerances on Critical Dimensions			± 1mm ± 0.39mm ± 1mm	± 0.4mm ± 0.02mm ± 0.25mm	± 0.1mm ± 0.016mm ± 0.12mm
Minimum Taper			2° 2°	1° 1°	1° 0.5°
Minimum Wall Thickness			3mm 5mm	3mm 4mm	1mm 2mm
Minimum Size of Cored Hole			15mm	3mm	2mm
Ability to use Sand Cores			Yes	Yes	No
Surface Finish			Poor 6.5-12.5 μ	Fair 4-10 μ	Good 1.5 μ
Alloys commonly used in this form	Aluminium	LM5 LM6 LM9 LM16 LM24 LM25 LM27 LM31	• • • • • •	• • • • • • •	• •  •   •
	Zinc	ZA3 ZA8 ZA12 ZA27	• • • •	• • • • •	•
	Copper	LG2 PB2	• • •	•	
Typical Production Quantities per annum			1-500	250-50000	2000-500000
Typical Tool Life			5,000	100,000	500,000