






LINEAR DIMENSIONS TOLERANCES			
Dim. Range (mm)	Tolerances grade		
	D1	D2	D3
	Generic	Medium	Special (specific cases)
0 - 6	±0.10	±0.08	±0.06
6 - 10	±0.12	±0.10	±0.06
10 - 14	±0.15	±0.12	±0.09
14 - 18	±0.20	±0.14	±0.09
18 - 24	±0.25	±0.17	±0.12
24 - 30	±0.30	±0.20	±0.14
30 - 40	±0.37	±0.25	±0.17
40 - 50	±0.44	±0.30	±0.20
50 - 65	±0.52	±0.38	±0.23
65 - 80	±0.60	±0.46	±0.27
80 - 100	±0.68	±0.53	±0.30
100 - 120	±0.76	±0.60	±0.33
120 - 140	±0.84	±0.65	±0.36
140 - 160	±0.92	±0.72	±0.38
160 - 180	±1.02	±0.80	±0.42
180 - 200	±1.12	±0.88	±0.43
200 - 225	±1.28	±0.95	±0.47
225 - 250	±1.44	±1.05	±0.51
250 - 280	±1.64	±1.15	±0.56
280 - 315	±1.84	±1.25	±0.63
315 - 355	±2.10	±1.40	±0.71
355 - 400	±2.40	±1.55	±0.80
400 - 450	±2.70	±1.70	±0.90
450 - 500	±3.00	±1.85	±1.00

GEOMETRIC TOLERANCES (flatness, parallelism, straightness)			
length (mm)	Tolerance grade		
	D1	D2	D3
0- 25	0.15 mm	0.10 mm	0.10 mm
25 - 50	0.25 mm	0.20 mm	0.15 mm
over 50	0.60 % of length	0.40 % of length	0.30 % of length

OTHER GEOMETRIC TOLERANCES	
Type	dimension (mm)
Circularity 	0,10 every 10mm
Cylindricity 	0,10 every 10mm
Angles 	±30'
Concentricity 	0.10 every 10mm
Runout 	0.10 every 10mm

Reference normative: DG P-690.

The values have been adjusted on the base of our experience in the investment casting manufacturing.