

TechnicaDatafor DesignReference设计参考数据

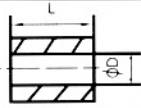
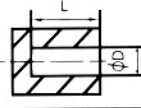
1. 线性公差(mm)

Linear Tolerance

尺寸范围 Dimensions	一般公差 Normal	特别公差 Premium
0-10	± 0.12	± 0.1
10-15	± 0.20	± 0.13
15-20	± 0.25	± 0.15
20-30	± 0.30	± 0.20
30-50	± 0.4	± 0.25
50-75	± 0.5	± 0.35
75-100	± 0.65	± 0.45
100-125	± 0.8	± 0.6
125-150	± 1	± 0.7
150-175	± 1.2	± 0.8
175-200	± 1.5	± 0.9
200-250	± 1.8	± 1.1
>250	± 0.8%	± 0.5%

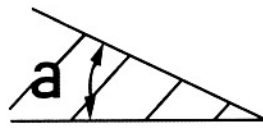
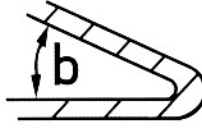
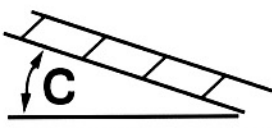
2. 可铸出孔槽的极限尺寸

Limit Dimension for Cast Holes and Slots

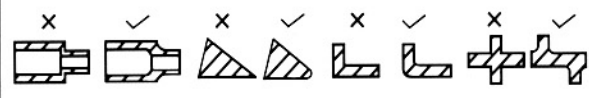
项目 Items	孔径范围 (mm) Hole Dia.	孔深/孔径 L/D
	φ 2- φ 3	L / D ≤ 2
	φ 4- φ 7	L / D ≤ 5
	≥ φ 8	L / D ≤ 10
	φ 2- φ 3	L / D ≤ 1
	φ 4- φ 7	L / D ≤ 2.5
	≥ φ 8	L / D ≤ 3.5

利用水溶型芯和陶瓷型芯，我们可以铸出更深和更复杂的孔和槽。
Deeper and more complicated holes and slots can be casted by using soluble wax cores and ceramic cores.

3. 角度公差 Angle Tolerance

角度形式 Angle Type			
一般公差 Normal	± 1°	± 2°	± 2°
特殊公差 Premium	± 0.5°	± 1°	± 1°

铸件结构应避免急剧变化，尽可能避免尖角，圆角应达到 R0.3 以上
Avoid the quick changes of casting structure, use fillet radius on internal angle when possible, which is no less than R0.3.



4. 平面度、直线度、圆度公差

Tolerance for Flatness, Straightness and Roundness

铸件尺寸 (mm) Dimension	一般公差 Normal	特殊公差 Premium
0-25	0.2	0.1
25-50	0.4	0.2
50-100	0.6	0.3
100-150	0.8	0.4

5. 大小和重量范围

Size and Weight Range

项目 Items	范围 Size	最优 Premium
轮廓尺寸(mm) Outline Dimension	1000 × 620 × 380	<100
重量(Kg) Weight	0.001 - 80	0.1-1.5
最小壁厚(mm) Min. Wall Thickness	0.5	5-10

6. 表面粗糙度 (Ra/μm) Surface Roughness

铸造状态 Rough Castings	重量(Weight) >5kg, 主要壁厚 >12mm Main Wall Thickness	3.2 - 6.3	<p>我公司有能力对铸件表面作如下精整处理，对于碳钢和低合金钢，可以作发黑、镀锌、镀铬、镀镍处理；对于不锈钢，可作研磨、手工拉丝抛光及镜面抛光、电抛光、钝化处理；所有钢种可作喷砂（玻璃砂、钢玉砂、石英砂）处理。</p> <p>The surface finish for the castings we can provide with are as the following: Blacking, zinc plating, chrome plating and nickel plating for the carbon steel and the low alloy steel castings; Tumbling, hand dull polishing, mirror polishing, electrolytic polishing and passivation treatment for the stainless steel castings and sandblasting, including glass bead blasting, corundum-sand blasting and quartz-sand blasting for all the steel castings.</p>
	重量(Weight) <5kg 主要壁厚 <12mm Main Wall Thickness	1.6 - 3.2	
精整状态 Finished Castings		0.8 - 1.6	