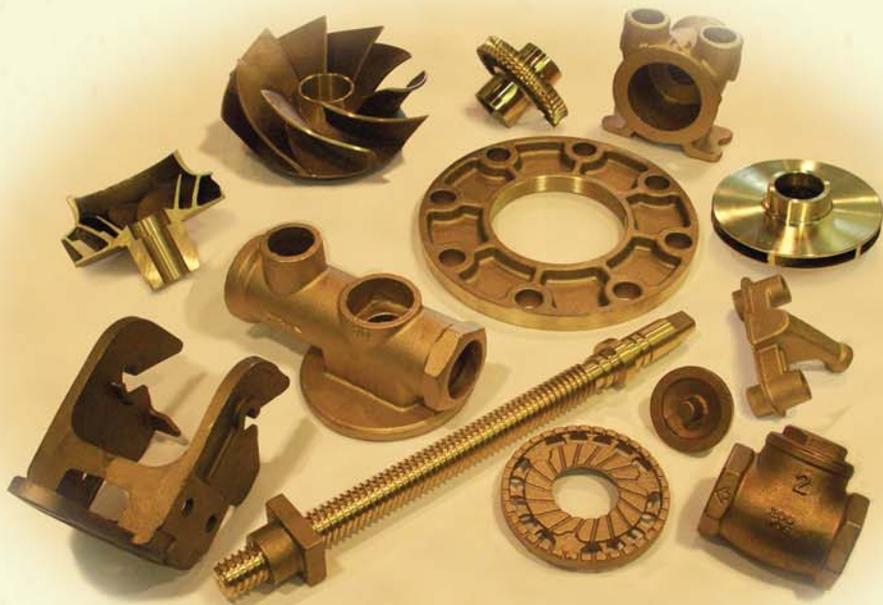


**CASTING
SOLUTIONS
INC.**

**Solidifying your casting
needs since 1969**

Why CASTING SOLUTIONS?

- A staff with 80+ years matching projects to the correct casting process.
- Process comparison budgetary quotes in 48 hours.
- Once the correct process has been chosen, Casting Solutions manages your project from design review through "life of part".



Manufacturers'

REPRESENTATIVE that understands your casting needs

EXPERIENCE that works for you from concept through "life of part"

PROCESS verification. The right casting process every time



Do you know which casting process fits this part and why? **We do!**

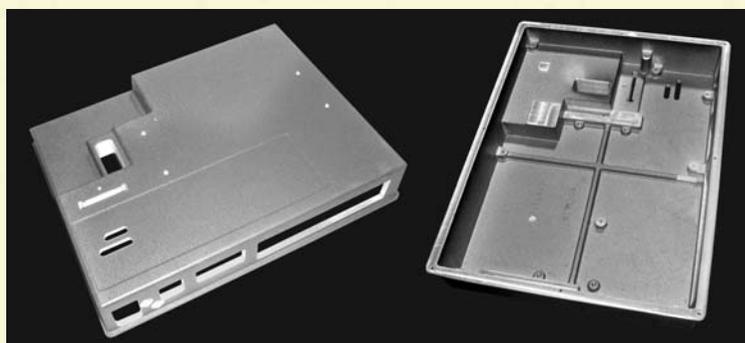
Put Casting Solutions' knowledge to work for you – **contact us now.**

Regards,

Ross Giese

President of Casting Solutions, Inc.





MATERIALS

- Aluminum
- Zinc
- Magnesium
- Stainless Steels
- Gray and Ductile Iron
- Brass
- Bronze
- Steels

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GUIDELINES FOR STANDARD DIMENSIONAL FEATURES (For reference only)

SOLUTION	average tolerance	nominal draft	corner radii and fillets	nominal wall thickness	standard machine stock	surface finish or RMS
Aluminum Permanent Mold	±.020	3 degree	0.06	0.187	0.06	200
Aluminum Sand Cast	±.030	2 degree	0.1	0.18	0.06	250
Aluminum Die Cast	±.006	1.5 degrees	0.06	0.09	0.02	40
Zinc Die Cast	±.005	1.5 degree	0.03	0.05	0.01	32
Brass Sand Cast	±.030	2 degree	0.03	0.09	0.09	180
Magnesium Thixomolding	±.003	0 to 3 degree	0.02	0.03	0.02	30
Investment Casting	±.006	0 degree	.020 -.030	0.1	0.02	125
Powdered Metal	±.005	0 degree	0.015	0.065	0.01	125
Metal Injection Molding	±.003	1-3 degree	0.005	0.05	0.015	32-45

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