

PROCESS GUIDE	INVESTMENT CASTINGS	METAL INJECTION MOLDING (MIM)	SAND CASTINGS	V PROCESS CASTINGS	DIE CASTINGS	GRAPHITE PERMANENT MOLD CASTINGS	SHELL CASTINGS
Materials	Aluminum, Steel & SS	broad range	Any	Aluminum	Zinc and Aluminum	Zinc/Aluminum	Steel & SS
Size Range	1 oz to 100 lbs	<golf ball	>1/2 lb	>1/2 lb	<10"x10"	<8" cube	<250 lbs
*Surface Finish (RMS)	125-150	<100	350	150	<100	<100	200-300
*Linear Tolerance (per inch) general information	+/- .005/inch	+/- .003/inch	+/- .045/inch	+/- .010/first inch +/- .002/thereafter	+/- .003/inch	+/- .005/inch	+/- .030/first 6" very part dependent
**Design Flexibility (1-10)	9	9	6	6	9	6	6
**Tooling Cost (1-10)	7	9	3	5	9	2	6

* tolerance and surface finish numbers are very general, just to give an idea, they are several variables that factor into both

** Design flexibility (geometry related) and tooling cost 1 is low and 10 is high

All information on this chart is general in nature as capabilities are very part dependent.