

Linear Dimensional Casting Tolerance Grades (DCTG)



For long-series or mass production for raw castings according to ISO 8062-3:2007

| Nominal dimension related to the moulded part, mm | | DCTG 5 | DCTG 6 | DCTG 7 | DCTG 8 | DCTG 9 | DCTG 10 | DCTG 11 | DCTG 12 | DCTG 13 |
|---|--------|--------|--------|--------|--------|--------|---------|---------|---------|---------|
| - | ≤ 10 | 0.36 | 0.52 | 0.74 | 1.00 | 1.50 | 2.00 | 2.80 | 4.20 | - |
| > 10 | ≤ 16 | 0.38 | 0.54 | 0.78 | 1.10 | 1.60 | 2.20 | 3.00 | 4.40 | - |
| > 16 | ≤ 25 | 0.42 | 0.58 | 0.82 | 1.20 | 1.70 | 2.40 | 3.20 | 4.60 | 6.00 |
| > 25 | ≤ 40 | 0.46 | 0.64 | 0.90 | 1.30 | 1.80 | 2.60 | 3.60 | 5.00 | 7.00 |
| > 40 | ≤ 63 | 0.50 | 0.70 | 1.00 | 1.40 | 2.00 | 2.80 | 4.00 | 5.60 | 8.00 |
| > 63 | ≤ 100 | 0.56 | 0.78 | 1.10 | 1.60 | 2.20 | 3.20 | 4.40 | 6.00 | 9.00 |
| > 100 | ≤ 160 | 0.62 | 0.88 | 1.20 | 1.80 | 2.50 | 3.60 | 5.00 | 7.00 | 10.00 |
| > 160 | ≤ 250 | 0.70 | 1.00 | 1.40 | 2.00 | 2.80 | 4.00 | 5.60 | 8.00 | 11.00 |
| > 250 | ≤ 400 | 0.78 | 1.10 | 1.60 | 2.20 | 3.20 | 4.40 | 6.20 | 9.00 | 12.00 |
| > 400 | ≤ 630 | 0.90 | 1.20 | 1.80 | 2.60 | 3.60 | 5.00 | 7.00 | 10.00 | 14.00 |
| > 630 | ≤ 1000 | 1.00 | 1.40 | 2.00 | 2.80 | 4.00 | 6.00 | 8.00 | 11.00 | 16.00 |
| > 1000 | ≤ 1600 | - | 1.60 | 2.20 | 3.20 | 4.60 | 7.00 | 9.00 | 13.00 | 18.00 |

By the standard recommended linear tolerance grades for different casting methods for light metals.

DCTG 9-12 Sand casting, hand molding

DCTG 7-9 Sand casting, machine molding and shell molding

DCTG 6-8 Permanent mold casting. Gravity and Low pressure die casting

DCTG 5-7 Pressure die casting: Use of tight tolerance grade (DCTG 5) to be agreed by case. Note 4.

Note 1 The tolerance grades indicated are those which can normally be held for castings produced in long series and if production factors influencing the dimensional accuracy of the casting have been fully developed

Note 2 For complex castings, one grade coarser is recommended

Note 3 For wall thickness, one grade coarser applies

Note 4 Differs from original standards text