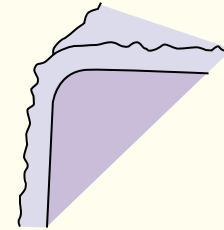


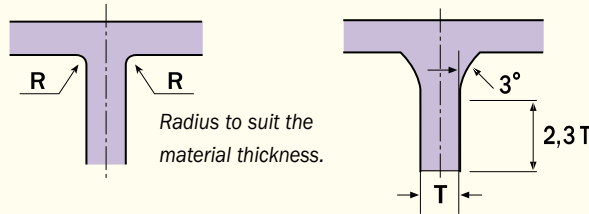
Some General Rules

1. Use rounded corners and fillets for improved casting quality and reduced rejection. Blind holes and unnecessary strict tolerances should be avoided.

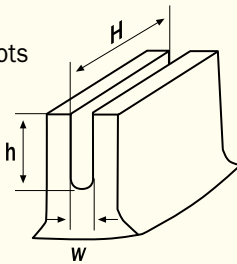


Sharp corners should be avoided at all costs as these will lead to casting defects.

2. Generous internal and external radius, as well as uniform sections ensure improved castability.



3. Dimensioning of slots

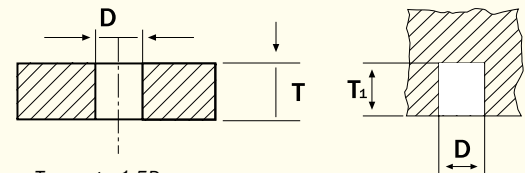


(mm)

W	≥2.5	4	6	8	10	16	20	24
H,h	≤5	8	20	32	46	80	120	150

4. Dimensioning of holes

D	Tmax	Ti max
3.5	5.10	5
>5-10	>10-30	>5-15
>10-20	>30-60	>15-25
>20-40	>60-120	>25-50
>40-60	>120-200	>50-80
>60-100	>200-300	>80-100
>100	>300-350	>100-120



$T = \text{up to } 1.5D$

$D = \text{at least } 3 \text{ mm dia}$