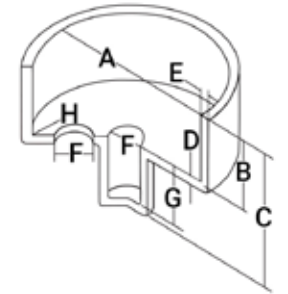
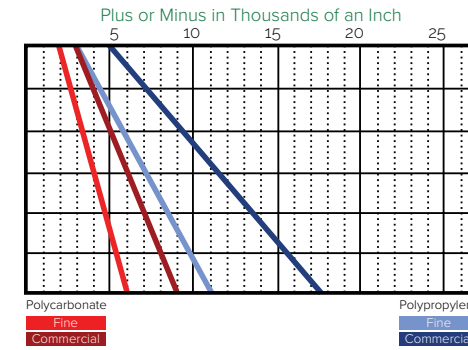
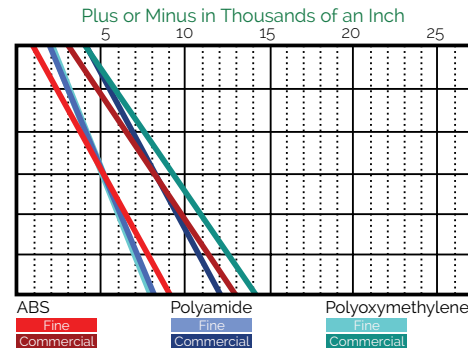


Decatur Mold Tolerances Chart

Note: The Commercial values below represent common production tolerances at the most economical level. The Fine values represent closer tolerances that can be held, but at a greater cost. Manufacturer should be consulted for any addition of fillers, which will compromise physical properties and alter dimensional stability.

Drawing Code	
A = Diameter (See note #1)	
B = Depth (See note #3)	
C = Height (See note #3)	

Dimensions (Inches)	
_____	0.000 _____
_____	0.500 _____
_____	1.000 _____
_____	2.000 _____
_____	3.000 _____
_____	4.000 _____
_____	5.000 _____
_____	6.000 _____
6.000 to 12.000- for each additional inch add (inches)	



		ABS	Polyamide (Nylon)	Polyoxymethylene (Acetal)	Polycarbonate	Polypropylene
D = Bottom Wall	(See note #3)	Commercial± 0.004 Fine+ 0.002	Commercial± 0.004 Fine+ 0.003	Commercial± 0.004 Fine+ 0.002	Commercial± 0.004 Fine+ 0.002	Commercial± 0.006 Fine+ 0.003
E = Side Wall	(See note #4)	Commercial± 0.003 Fine± 0.002	Commercial± 0.005 Fine± 0.003	Commercial± 0.004 Fine± 0.002	Commercial± 0.005 Fine± 0.003	Commercial± 0.006 Fine± 0.003
F = Hole Size Diameter (See note #1)	0.000 to 0.125	Commercial± 0.002 Fine± 0.001	Commercial± 0.002 Fine± 0.001	Commercial± 0.002 Fine± 0.001	Commercial± 0.002 Fine± 0.001	Commercial± 0.003 Fine± 0.002
	0.126 to 0.250	Commercial± 0.003 Fine± 0.002	Commercial± 0.003 Fine± 0.002	Commercial± 0.003 Fine± 0.002	Commercial± 0.002 Fine± 0.002	Commercial± 0.004 Fine± 0.003
	0.251 to 0.500	Commercial± 0.003 Fine± 0.002	Commercial± 0.003 Fine± 0.002	Commercial± 0.004 Fine± 0.002	Commercial± 0.003 Fine± 0.002	Commercial± 0.005 Fine± 0.004
	0.501 & over	Commercial± 0.004 Fine± 0.002	Commercial± 0.005 Fine± 0.003	Commercial± 0.005 Fine± 0.003	Commercial± 0.003 Fine± 0.002	Commercial± 0.008 Fine± 0.006
G = Hole Size Depth (See note #5)	0.000 to 0.250	Commercial± 0.003 Fine± 0.002	Commercial± 0.004 Fine± 0.002	Commercial± 0.004 Fine± 0.002	Commercial± 0.002 Fine± 0.002	Commercial± 0.005 Fine± 0.003
	0.251 to 0.500	Commercial± 0.004 Fine± 0.002	Commercial± 0.004 Fine± 0.003	Commercial± 0.005 Fine± 0.003	Commercial± 0.003 Fine± 0.002	Commercial± 0.006 Fine± 0.004
	0.501 to 1.000	Commercial± 0.005 Fine± 0.003	Commercial± 0.005 Fine± 0.004	Commercial± 0.006 Fine± 0.004	Commercial± 0.004 Fine± 0.003	Commercial± 0.009 Fine± 0.006
H = Corners, Ribs, Fillets	(See note #6)	Commercial± 0.027 Fine± 0.017	Commercial± 0.021 Fine± 0.013	Commercial± 0.025 Fine± 0.013	Commercial± 0.020 Fine± 0.015	Commercial± 0.029 Fine± 0.016
Flatness (See note #4)	0.000 to 3.000	Commercial± 0.015 Fine± 0.010	Commercial± 0.010 Fine± 0.004	Commercial± 0.011 Fine± 0.005	Commercial± 0.005 Fine± 0.003	Commercial± 0.022 Fine± 0.014
	3.001 to 6.000	Commercial± 0.030 Fine± 0.020	Commercial± 0.015 Fine± 0.007	Commercial± 0.018 Fine± 0.008	Commercial± 0.007 Fine± 0.004	Commercial± 0.036 Fine± 0.021
Thread Size (Class)	Internal	Commercial± 1 Fine± 2	Commercial± 1 Fine± 2	Commercial± 1 Fine± 2	Commercial± 1B Fine± 2B	Commercial± 1 Fine± 2
	External	Commercial± 1 Fine± 2	Commercial± 1 Fine± 2	Commercial± 1 Fine± 2	Commercial± 1A Fine± 2A	Commercial± 1 Fine± 2
Concentricity	(See note #4) (F.I.M)	Commercial± 0.009 Fine± 0.005	Commercial± 0.005 Fine± 0.003	Commercial± 0.010 Fine± 0.006	Commercial± 0.005 Fine± 0.006	Commercial± 0.015 Fine± 0.012
Draft Allowance Per Side	(See note #5)	Commercial± 2.0° Fine± 1.0°	Commercial± 1.5° Fine± 0.5°	Commercial± 1.25° Fine± 0.5°	Commercial± 1.5° Fine± 0.5°	Commercial± 1.5° Fine± 0.5°
Surface Finish	(See note #7)					
Color Stability	(See note #7)					

Decatur Mold Tolerances Chart

Note: The Commercial values below represent common production tolerances at the most economical level. The Fine values represent closer tolerances that can be held, but at a greater cost. Manufacturer should be consulted for any addition of fillers, which will compromise physical properties and alter dimensional stability.

Reference Notes:

1. These tolerances do not include allowance for aging characteristics of material.
2. Tolerances are based on 0.125 inch wall section.
3. Parting line must be taken into consideration.
4. Part design should maintain a wall thickness as nearly constant as possible. Complete uniformity in this dimension is sometimes impossible to achieve. Walls of non-uniform thickness should be gradually blended from thick to thin.
5. Care must be taken that the ratio of the depth of a cored hole to its diameter does not reach a point that will result in excessive pin damage.
6. These values should be increased whenever compatible with desired design and good molding techniques.
7. Customer-Molder understanding is necessary prior to tooling.