



TECHNICAL INSTRUCTIONS: FOUNDRY
TOLERANCES ON UNTOLERANCED DIMENSIONS OF
WOODEN PATTERN EQUIPMENT

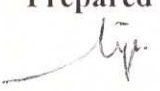

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1.0 SCOPE:

- 1.1 This TIF specifies the permissible dimensional variation on wooden patterns and core boxes etc.
- 1.2 This TIF is made based on specification IS: 1513-1980.

Nominal size (mm)	Variation (mm)
Up to & including 50	± 0.5
Over 50 including 150	± 0.6
Over 150 including 300	± 0.8
Over 300 including 500	± 1.0
Over 500 including 800	± 1.2
Over 800 including 1200	± 1.5
Over 1200 including 1800	± 1.8
Over 1800 including 2500	± 2.1
Over 2500 including 4000	± 2.4
Over 4000	± 2.7

- 2.0 This TIF also covers for Templates, Sweep patterns & Templates, Skeleton Patterns, Follow Pieces and other equipment.
- 3.0 Wherever customer specifies tolerances other than the above for patterns, customers tolerances holds good with reference to the above.

Nature of revisions:	Issued By:		FOUNDRIES AND PATTERN SHOP
	Prepared	Approved	Date
1). Re- issued in new format.		 MD. NAZEER AHMED	20/11/2009

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