

Cast Inspection Guide

* Visual Requirements unless otherwise specified, the following visual requirements apply to all castings

* No cracks are allowed

* Allowable Rounded Discontinuities:

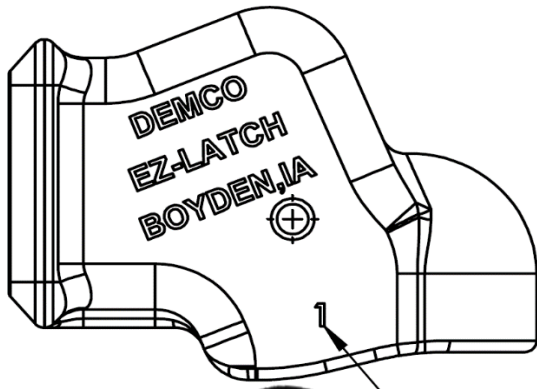
Max Dia	Max Depth	Max Qty/Area
1/8"	1/8"	4 per 3" Dia Circle

* Allowable Linear Discontinuities

Max Width	Max Depth	Max Qty/Area
1/16"	1/8"	4 per 3" Dia Circle

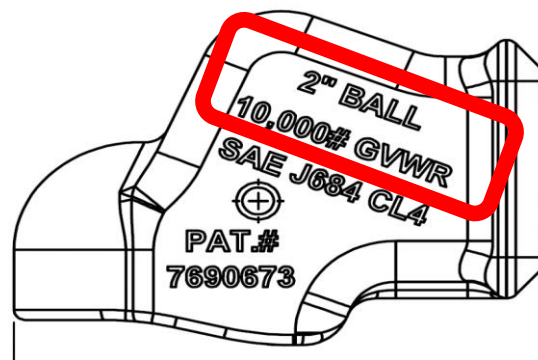
* Unless otherwise specified, surface finish shall conform to the ranges of the GAR C-9 comparator for the process used.

Casting Process	Surface Finish μ m RMS	
Die	20	120
Investment	60	200
Shell Mold	120	300
Centrifugal – Permanent Mold	20	300
Permanent Mold	200	420
Normal Non-Ferrous Sand	300	560
Normal Ferrous Green Sand	560	900



All lettering must be visible and meet the criteria for fair

Text in red box must meet the criteria for good



Good
 All letters very visible



Fair
 All letter visible with slight deformation in the characters



Poor
 Missing letters and sever deformation
Rejection



All cluster porosity is to be
Rejected



Critical area to be 100% inspected -
 Any crack
Rejected