



# Cast Iron Machining Allowance Requirement.

SHAPE	METRIC (MM)	
	SIZE	STOCK ALLOWANCE
ROUND	18-45	2.40
	46-65	3.20
	66-100	5.00
	101-200	7.00
	201-280	11.00
	281-350	14.00
	351-420	17.00
	421-490	23.00
	491-600	32.00
SQUARE	30X30-50X50	3.50X3.50
	51X51-100X100	6.00X6.00
	101X101-200X200	9.00X9.00
	201X201-280-280	11.00X11.00
	281X281-350X350	14.00X14.00
	351X351-425X425	17.00X17.00
RECTANGLE	30X40-60X70	3.50X4.00
	61X71-90X100	4.00X5.00
	91X101-120X130	5.00X6.00
	121X131-150X160	6.00X7.00
	151X161-180X190	7.00X8.00
	181X191-210X220	8.00X9.00
	211X221-240X250	9.00X10.00
	241X251-270X280	10.00X11.00
	271X281-300X310	11.00X12.00
	301X311-330X340	12.00X13.00
	331X341-360X370	13.00X14.00
	361X371-390X400	14.00X15.00
	391X401-420X430	15.00X16.00
421X431-450X460	25.00X28.00	
SEMI-ROUND	R40-R85	2.50
	R86-R120	3.00
	R121-R160	4.00
	R161-R180	5.00