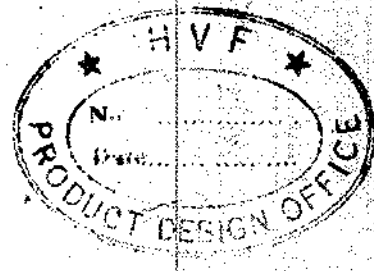


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USSR STATE STANDARD

METAL AND ALLOY CASTINGS

DIMENSIONS AND MASS TOLERANCES AND MACHINING

ALLOWANCES

GOST 26645 - 85

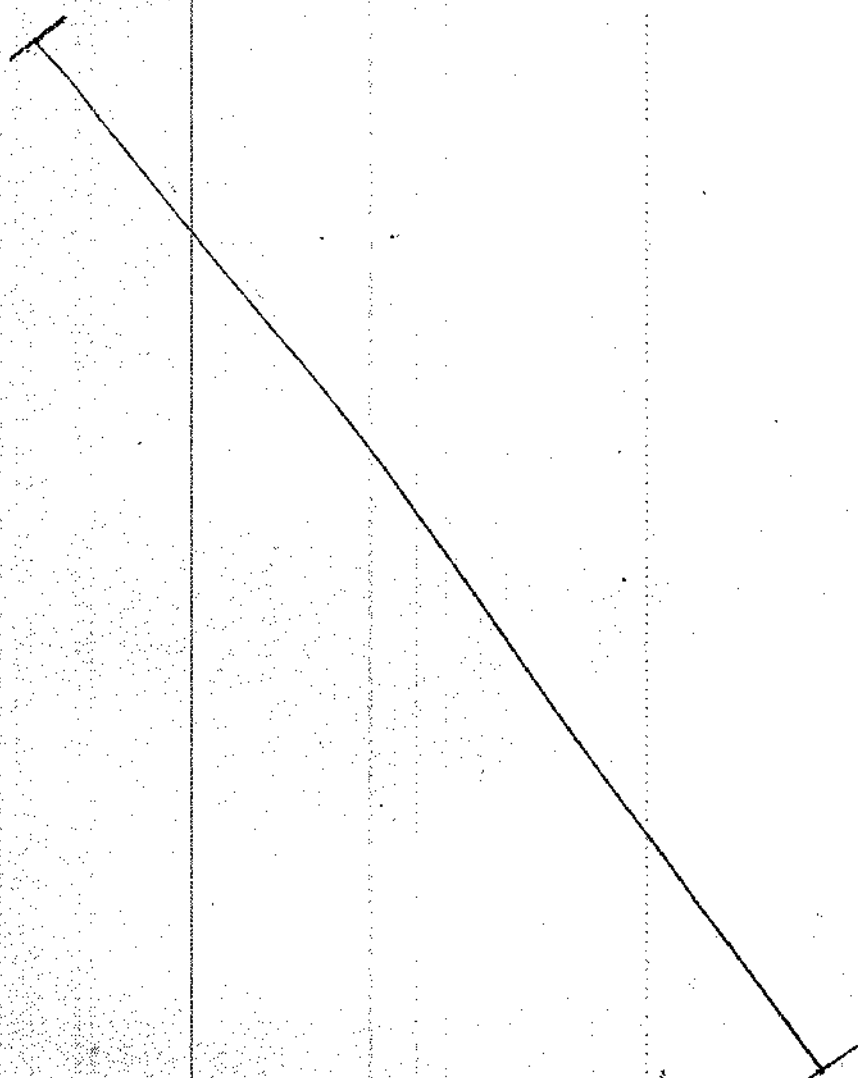
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| MANUEL | | |
| Date | Compiled by | SPECIFICATION No. GOST 26645 - 85 |
| 25-11-92 | P.N. RAMANATHAN D.K. SHARAN | |
| | | Approved by |
| | Page No. 1 of 71 | <i>[Signature]</i> 28/1/92 |

1.8. Terms, used in the present standard and their definitions are given in Appendix 9.

2. TOLERANCES OF DIMENSIONS, SHAPES, LOCATION
AND IRREGULARITIES OF CASTING SURFACES

2.1. Tolerances of linear dimensions of castings changable and unchangable by machining, should correspond to those specified in Table 1.



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TABLE-1

Interval of nominal dimensions, mm.

Tolerances for dimensions of castings, mm, max, for accuracy class.

| | 1 | 2 | 3r | 3 | 4 | 5r | 5 | 6 | 7r | 7 | 8 | 9r | 9 | 10 | 11r | 11 | 12 | 13r | 13 | 14 | 15 | 16 | |
|------------|------|------|------|------|------|------|------|------|------|------|------|-----|-----|------|------|------|------|------|------|------|----|----|-----|
| from above | 0.06 | 0.08 | 0.10 | 0.12 | 0.16 | 0.20 | 0.24 | 0.32 | 0.40 | 0.50 | 0.64 | 0.8 | 1.0 | 1.2 | 1.6 | 2.0 | — | — | — | — | — | — | — |
| 4 | 0.07 | 0.09 | 0.11 | 0.14 | 0.18 | 0.22 | 0.28 | 0.36 | 0.44 | 0.56 | 0.70 | 0.9 | 1.1 | 1.4 | 1.8 | 2.2 | 2.8 | — | — | — | — | — | — |
| 6 | 0.08 | 0.10 | 0.12 | 0.16 | 0.20 | 0.24 | 0.32 | 0.40 | 0.50 | 0.64 | 0.80 | 1.0 | 1.2 | 1.6 | 2.0 | 2.4 | 3.2 | 4.0 | 5.0 | — | — | — | — |
| 10 | 0.09 | 0.11 | 0.14 | 0.18 | 0.22 | 0.28 | 0.36 | 0.44 | 0.56 | 0.70 | 0.90 | 1.1 | 1.4 | 1.8 | 2.2 | 2.8 | 3.6 | 4.4 | 5.6 | 7.0 | 8 | 10 | 12 |
| 16 | 0.10 | 0.12 | 0.16 | 0.20 | 0.24 | 0.32 | 0.40 | 0.50 | 0.64 | 0.80 | 1.00 | 1.2 | 1.6 | 2.0 | 2.4 | 3.2 | 4.0 | 5.0 | 6.4 | 8 | 10 | 12 | 16 |
| 25 | 0.11 | 0.14 | 0.18 | 0.22 | 0.28 | 0.36 | 0.44 | 0.56 | 0.70 | 0.90 | 1.10 | 1.4 | 1.8 | 2.2 | 2.8 | 3.6 | 4.4 | 5.6 | 7.0 | 9 | 11 | 14 | 18 |
| 40 | 0.12 | 0.16 | 0.20 | 0.24 | 0.32 | 0.40 | 0.50 | 0.64 | 0.80 | 1.00 | 1.20 | 1.6 | 2.0 | 2.4 | 3.2 | 4.0 | 5.0 | 6.4 | 8.0 | 10 | 12 | 16 | 20 |
| 63 | 0.14 | 0.18 | 0.22 | 0.28 | 0.36 | 0.44 | 0.56 | 0.70 | 0.90 | 1.10 | 1.40 | 1.8 | 2.2 | 2.8 | 3.6 | 4.4 | 5.6 | 7.0 | 9.0 | 11 | 14 | 18 | 24 |
| 100 | 0.16 | 0.20 | 0.24 | 0.32 | 0.40 | 0.50 | 0.64 | 0.80 | 1.00 | 1.20 | 1.60 | 2.0 | 2.4 | 3.2 | 4.0 | 5.0 | 6.4 | 8.0 | 10.0 | 12.0 | 16 | 20 | 28 |
| 160 | — | — | 0.28 | 0.36 | 0.44 | 0.56 | 0.70 | 0.90 | 1.10 | 1.40 | 1.80 | 2.2 | 2.8 | 3.6 | 4.4 | 5.6 | 7.0 | 9.0 | 11.0 | 14.0 | 18 | 24 | 32 |
| 250 | — | — | 0.32 | 0.40 | 0.50 | 0.64 | 0.80 | 1.00 | 1.20 | 1.60 | 2.00 | 2.4 | 3.2 | 4.0 | 5.0 | 6.4 | 8.0 | 10.0 | 12.0 | 16.0 | 20 | 24 | 32 |
| 400 | — | — | — | — | 0.56 | 0.70 | 0.90 | 1.10 | 1.40 | 1.80 | 2.20 | 2.8 | 3.6 | 4.4 | 5.6 | 7.0 | 9.0 | 11.0 | 14.0 | 18.0 | 24 | 32 | 40 |
| 630 | — | — | — | — | — | 0.80 | 1.00 | 1.20 | 1.60 | 2.00 | 2.40 | 3.2 | 4.0 | 5.0 | 6.4 | 8.0 | 10.0 | 12.0 | 16.0 | 20.0 | 24 | 32 | 40 |
| 1000 | — | — | — | — | — | — | — | — | 2.00 | 2.40 | 3.20 | 4.0 | 5.0 | 6.4 | 8.0 | 10.0 | 12.0 | 16.0 | 20.0 | 24 | 32 | 40 | 50 |
| 1600 | — | — | — | — | — | — | — | — | — | 3.20 | 3.60 | 4.4 | 5.6 | 7.0 | 9.0 | 11.0 | 14.0 | 18.0 | 22.0 | 28 | 36 | 44 | 56 |
| 2500 | — | — | — | — | — | — | — | — | — | — | — | 5.0 | 6.4 | 8.0 | 10.0 | 12.0 | 16.0 | 20.0 | 24.0 | 32 | 40 | 50 | 64 |
| 4000 | — | — | — | — | — | — | — | — | — | — | — | — | 8.0 | 10.0 | 12.0 | 16.0 | 20.0 | 24.0 | 32.0 | 40 | 50 | 64 | 80 |
| 6300 | — | — | — | — | — | — | — | — | — | — | — | — | — | 12.0 | 16.0 | 20 | 24 | 32 | 40 | 50 | 64 | 80 | 100 |
| 10000 | — | — | — | — | — | — | — | — | — | — | — | — | — | — | — | — | — | — | — | — | — | — | — |

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TABLE-2

Nominal dimension of section of casting being standardized, mm,

Tolerance of mould and location of casting elements, mm, max, for degrees of warpage for the casting elements.

from

| above | upto | 1 | 2 | 3 | 4 | 5 | 6 | 7 | 8 | 9 | 10 | 11 |
|---------|---------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Ca. 125 | > 160 | 0.12 | 0.16 | 0.20 | 0.24 | 0.32 | 0.40 | 0.50 | 0.64 | 0.80 | 1.00 | 1.20 |
| > 160 | > 200 | 0.16 | 0.20 | 0.24 | 0.32 | 0.40 | 0.50 | 0.64 | 0.80 | 1.00 | 1.20 | 1.50 |
| > 200 | > 250 | 0.20 | 0.24 | 0.32 | 0.40 | 0.50 | 0.64 | 0.80 | 1.00 | 1.20 | 1.50 | 2.00 |
| > 250 | > 315 | 0.24 | 0.32 | 0.40 | 0.50 | 0.64 | 0.80 | 1.00 | 1.20 | 1.60 | 2.00 | 2.40 |
| > 315 | > 400 | 0.32 | 0.40 | 0.50 | 0.64 | 0.80 | 1.00 | 1.20 | 1.60 | 2.00 | 2.40 | 3.00 |
| > 400 | > 500 | 0.40 | 0.50 | 0.64 | 0.80 | 1.00 | 1.20 | 1.60 | 2.00 | 2.40 | 3.00 | 4.00 |
| > 500 | > 630 | 0.50 | 0.64 | 0.80 | 1.00 | 1.20 | 1.60 | 2.00 | 2.40 | 3.00 | 4.00 | 5.00 |
| > 630 | > 800 | 0.64 | 0.80 | 1.00 | 1.20 | 1.60 | 2.00 | 2.40 | 3.00 | 4.00 | 5.00 | 6.40 |
| > 800 | > 1000 | 0.80 | 1.00 | 1.20 | 1.50 | 2.00 | 2.40 | 3.00 | 4.00 | 5.00 | 6.40 | 8.00 |
| > 1000 | > 1200 | 1.00 | 1.20 | 1.50 | 2.00 | 2.40 | 3.00 | 4.00 | 5.00 | 6.40 | 8.00 | 10.00 |
| > 1200 | > 1600 | 1.20 | 1.60 | 2.00 | 2.40 | 3.00 | 4.00 | 5.00 | 6.40 | 8.00 | 10.00 | 12.00 |
| > 1600 | > 2000 | 1.60 | 2.00 | 2.40 | 3.00 | 4.00 | 5.00 | 6.40 | 8.00 | 10.00 | 12.00 | 16.00 |
| > 2000 | > 2500 | 2.00 | 2.40 | 3.00 | 4.00 | 5.00 | 6.40 | 8.00 | 10.00 | 12.00 | 16.00 | 20.00 |
| > 2500 | > 3150 | 2.40 | 3.00 | 4.00 | 5.00 | 6.40 | 8.00 | 10.00 | 12.00 | 16.00 | 20.00 | 24.00 |
| > 3150 | > 4000 | 3.00 | 4.00 | 5.00 | 6.40 | 8.00 | 10.00 | 12.00 | 16.00 | 20.00 | 24.00 | 30.00 |
| > 4000 | > 5000 | 4.00 | 5.00 | 6.40 | 8.00 | 10.00 | 12.00 | 16.00 | 20.00 | 24.00 | 30.00 | 40.00 |
| > 5000 | > 6300 | 5.00 | 6.40 | 8.00 | 10.00 | 12.00 | 16.00 | 20.00 | 24.00 | 30.00 | 40.00 | 50.00 |
| > 6300 | > 8000 | 6.40 | 8.00 | 10.00 | 12.00 | 16.00 | 20.00 | 24.00 | 30.00 | 40.00 | 50.00 | 64.00 |
| > 8000 | > 10000 | 8.00 | 10.00 | 12.00 | 16.00 | 20.00 | 24.00 | 30.00 | 40.00 | 50.00 | 64.00 | 80.00 |
| > 10000 | | 10.00 | 12.00 | 16.00 | 20.00 | 24.00 | 30.00 | 40.00 | 50.00 | 64.00 | 80.00 | — |

Note: - For the nominal dimension of the being standardized section, for determining the tolerances, shape and location should be taken as the maximum from the dimensions of the being standardized section for the element of casting, for which deviation of shape and location of surface are specified.

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TABLE-3

Tolerance for unevenness of surfaces of casting, mm, max, for degrees of accuracy for surfaces of casting.

| | | | | | | | | | | | | | | | | | | | | | |
|------|------|------|------|------|------|------|------|------|------|------|------|------|-----|-----|-----|-----|-----|-----|-----|-----|-----|
| 1 | 2 | 3 | 4 | 5 | 6 | 7 | 8 | 9 | 10 | 11 | 12 | 13 | 14 | 15 | 16 | 17 | 18 | 19 | 20 | 21 | 22 |
| 0.05 | 0.08 | 0.09 | 0.10 | 0.12 | 0.16 | 0.20 | 0.24 | 0.32 | 0.40 | 0.50 | 0.64 | 0.80 | 1.0 | 1.2 | 1.6 | 2.0 | 2.4 | 3.2 | 4.0 | 5.0 | 6.4 |

3. TOLERANCES FOR THE MASS OF CASTINGS

- 3.1. Tolerances for the mass of castings should correspond to those specified in Table 4.
- 3.2. Symmetrical location of tolerance zone for mass relative to the rated mass is specified.

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TABLE-4

| Rated mass of casting, kg. | Tolerance for the mass of casting, %, max. For the accuracy classes for the mass of casting. | | | | | | | | | | | | | | | | | | | | | | |
|----------------------------|--|-----|-----|-----|-----|-----|-----|-----|-----|------|------|------|------|------|------|------|------|------|------|------|------|------|------|
| | 1 | 2 | 3r | 3 | 4 | 5r | 5 | 6 | 7r | 7 | 8 | 9r | 9 | 10 | 11r | 11 | 12 | 13r | 13 | 14 | 15r | 15 | 16 |
| from above to | 0.1 | 1.6 | 2.0 | 2.4 | 3.2 | 4.0 | 5.0 | 6.4 | 8.0 | 10.0 | 12.0 | 16.0 | 20.0 | 24.0 | 32.0 | — | — | — | — | — | — | — | — |
| above | 0.1 | 1.2 | 1.6 | 2.0 | 2.4 | 3.2 | 4.0 | 5.0 | 6.4 | 8.0 | 10.0 | 12.0 | 16.0 | 20.0 | 24.0 | 32.0 | — | — | — | — | — | — | — |
| 0.1 > 0.4 | 1.0 | 1.0 | 1.2 | 1.6 | 2.0 | 2.4 | 3.2 | 4.0 | 5.0 | 6.4 | 8.0 | 10.0 | 12.0 | 16.0 | 20.0 | 24.0 | 32.0 | — | — | — | — | — | — |
| 0.4 > 1.0 | — | — | 1.0 | 1.2 | 1.6 | 2.0 | 2.4 | 3.2 | 4.0 | 5.0 | 6.4 | 8.0 | 10.0 | 12.0 | 16.0 | 20.0 | 24.0 | 32.0 | — | — | — | — | — |
| 1.0 > 4.0 | — | — | — | 1.0 | 1.2 | 1.6 | 2.0 | 2.4 | 3.2 | 4.0 | 5.0 | 6.4 | 8.0 | 10.0 | 12.0 | 16.0 | 20.0 | 24.0 | 32.0 | — | — | — | — |
| 4.0 > 10.0 | — | — | — | — | 1.0 | 1.2 | 1.6 | 2.0 | 2.4 | 3.2 | 4.0 | 5.0 | 6.4 | 8.0 | 10.0 | 12.0 | 16.0 | 20.0 | 24.0 | 32.0 | — | — | — |
| 10.0 > 40.0 | — | — | — | — | — | 1.0 | 1.2 | 1.6 | 2.0 | 2.4 | 3.2 | 4.0 | 5.0 | 6.4 | 8.0 | 10.0 | 12.0 | 16.0 | 20.0 | 24.0 | 32.0 | — | — |
| 40.0 > 100.0 | — | — | — | — | — | — | 1.0 | 1.2 | 1.6 | 2.0 | 2.4 | 3.2 | 4.0 | 5.0 | 6.4 | 8.0 | 10.0 | 12.0 | 16.0 | 20.0 | 24.0 | 32.0 | — |
| 100.0 > 400.0 | — | — | — | — | — | — | — | 1.0 | 1.2 | 1.6 | 2.0 | 2.4 | 3.2 | 4.0 | 5.0 | 6.4 | 8.0 | 10.0 | 12.0 | 16.0 | 20.0 | 24.0 | 32.0 |
| 400.0 > 1000.0 | — | — | — | — | — | — | — | — | 1.0 | 1.2 | 1.6 | 2.0 | 2.4 | 3.2 | 4.0 | 5.0 | 6.4 | 8.0 | 10.0 | 12.0 | 16.0 | 20.0 | 24.0 |
| 1000.0 > 4000.0 | — | — | — | — | — | — | — | — | — | 1.0 | 1.2 | 1.6 | 2.0 | 2.4 | 3.2 | 4.0 | 5.0 | 6.4 | 8.0 | 10.0 | 12.0 | 16.0 | 20.0 |
| 4000.0 > 10000.0 | — | — | — | — | — | — | — | — | — | — | 1.0 | 1.2 | 1.6 | 2.0 | 2.4 | 3.2 | 4.0 | 5.0 | 6.4 | 8.0 | 10.0 | 12.0 | 16.0 |
| 10000.0 > 40000.0 | — | — | — | — | — | — | — | — | — | — | — | 1.0 | 1.2 | 1.6 | 2.0 | 2.4 | 3.2 | 4.0 | 5.0 | 6.4 | 8.0 | 10.0 | 12.0 |
| 40000.0 > 100000.0 | — | — | — | — | — | — | — | — | — | — | — | — | 1.0 | 1.2 | 1.6 | 2.0 | 2.4 | 3.2 | 4.0 | 5.0 | 6.4 | 8.0 | 10.0 |
| 100000.0 | — | — | — | — | — | — | — | — | — | — | — | — | — | 1.0 | 1.2 | 1.6 | 2.0 | 2.4 | 3.2 | 4.0 | 5.0 | 6.4 | 8.0 |

Note: Tolerances for the mass of castings are given in percentage from the rated mass of of castings.

TABLE-5

| Series of allowance for casting. | 1 | 2 | 3 | 4 | 5 | 6 | 7 | 8 | 9 | 10 | 11 | 12 | 13 | 14 | 15 | 16 | 17 | 18 |
|--|-----|-----|-----|-----|-----|-----|-----|-----|-----|-----|-----|-----|-----|-----|-----|-----|-----|------|
| Minimum casting allowance for the side, mm, max. | 0.1 | 0.2 | 0.3 | 0.4 | 0.5 | 0.6 | 0.8 | 1.0 | 1.2 | 1.6 | 2.0 | 2.5 | 3.0 | 4.0 | 5.0 | 6.0 | 8.0 | 10.0 |

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4.4. For the unstandardized requirements for accuracy of shape and location of machined surfaces of casting, common allowances are specified as per points 4.2, 4.2.1, 4.2.2 as per the tolerances of dimensions of casting from the surface being machined to the locating point of machining.

4.5. Values of total allowance for each gap of common tolerance, given in different lines of Table 6 and corresponding rough, semi-finished, finished and thin machining are selected depending upon the ratio between the required accuracy for the machined surface of the component and the initial accuracy for the surface of casting, given in Table 7, for errors of dimensions and in Table 8 for errors of shape and location of surfaces of component and casting; value of allowance, corresponding to the relatively more accurate machining is taken finally.

4.6. Total allowances for castings, machined at the mean level of accuracy for machining are given in Table 6.

Based on the technical level of machining technology, increased or decreased values of allowances should be designated as per Table 15, Appendix 7.

TABLE-6

| Common tolerance for the element of surface, mm | Type of finish machining | Common allowance for the side, mm, max. for the series of allowance for the casting. | | | | | | | | | | | | | | |
|---|----------------------------------|--|-----|-----|-----|-----|-----|-----|-----|-----|-----|-----|-----|-----|-----|-----|
| | | 1 | 2 | 3 | 4 | 5 | 6 | 7 | 8 | 9 | 10 | | | | | |
| upto 0.10 | Черновая обработка "Thin" | Rough | 0.2 | 0.3 | 0.4 | 0.5 | 0.6 | 0.7 | 0.8 | 0.9 | 1.0 | 1.1 | 1.2 | 1.3 | 1.4 | 1.5 |
| | | Finished | 0.2 | 0.3 | 0.4 | 0.5 | 0.6 | 0.7 | 0.8 | 0.9 | 1.0 | 1.1 | 1.2 | 1.3 | 1.4 | 1.5 |
| from above 0.10 to 0.11 | Получистовая обработка "Thin" | Rough | 0.2 | 0.3 | 0.4 | 0.5 | 0.6 | 0.7 | 0.8 | 0.9 | 1.0 | 1.1 | 1.2 | 1.3 | 1.4 | 1.5 |
| | | Finished | 0.2 | 0.3 | 0.4 | 0.5 | 0.6 | 0.7 | 0.8 | 0.9 | 1.0 | 1.1 | 1.2 | 1.3 | 1.4 | 1.5 |
| from above 0.11 to 0.12 | Чистовая обработка "Thin" | Rough | 0.2 | 0.3 | 0.4 | 0.5 | 0.6 | 0.7 | 0.8 | 0.9 | 1.0 | 1.1 | 1.2 | 1.3 | 1.4 | 1.5 |
| | | Finished | 0.2 | 0.3 | 0.4 | 0.5 | 0.6 | 0.7 | 0.8 | 0.9 | 1.0 | 1.1 | 1.2 | 1.3 | 1.4 | 1.5 |
| from above 0.12 to 0.14 | Чистовая обработка "Thin" | Rough | 0.2 | 0.3 | 0.4 | 0.5 | 0.6 | 0.7 | 0.8 | 0.9 | 1.0 | 1.1 | 1.2 | 1.3 | 1.4 | 1.5 |
| | | Finished | 0.2 | 0.3 | 0.4 | 0.5 | 0.6 | 0.7 | 0.8 | 0.9 | 1.0 | 1.1 | 1.2 | 1.3 | 1.4 | 1.5 |
| from above 0.14 to 0.16 | Чистовая обработка "Thin" | Rough | 0.2 | 0.3 | 0.4 | 0.5 | 0.6 | 0.7 | 0.8 | 0.9 | 1.0 | 1.1 | 1.2 | 1.3 | 1.4 | 1.5 |
| | | Finished | 0.2 | 0.3 | 0.4 | 0.5 | 0.6 | 0.7 | 0.8 | 0.9 | 1.0 | 1.1 | 1.2 | 1.3 | 1.4 | 1.5 |
| from above 0.16 to 0.18 | Чистовая обработка "Thin" | Rough | 0.2 | 0.3 | 0.4 | 0.5 | 0.6 | 0.7 | 0.8 | 0.9 | 1.0 | 1.1 | 1.2 | 1.3 | 1.4 | 1.5 |
| | | Finished | 0.2 | 0.3 | 0.4 | 0.5 | 0.6 | 0.7 | 0.8 | 0.9 | 1.0 | 1.1 | 1.2 | 1.3 | 1.4 | 1.5 |
| from above 0.18 to 0.20 | Чистовая обработка "Thin" | Rough | 0.2 | 0.3 | 0.4 | 0.5 | 0.6 | 0.7 | 0.8 | 0.9 | 1.0 | 1.1 | 1.2 | 1.3 | 1.4 | 1.5 |
| | | Finished | 0.2 | 0.3 | 0.4 | 0.5 | 0.6 | 0.7 | 0.8 | 0.9 | 1.0 | 1.1 | 1.2 | 1.3 | 1.4 | 1.5 |

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Contd. Table G

| SHEET No. OF DOCUMENT | SIGNATURE | DATE | Common tolerance for the element of surface, mm. | Type of finish machining. | Common allowance for the side, mm, max. for the series of allowance for the casting. | | | | | | | | | | | | | | | | |
|-----------------------|-----------|------|--|--|--|-----|-----|-----|-----|-----|-----|-----|-----|-----|-----|-----|-----|-----|-----|-----|-----|
| | | | | | 10 | 11 | 12 | 13 | 14 | 15 | 16 | 17 | 18 | | | | | | | | |
| 4985-26645-85 | | | upto До 0,10 | Черновая Rough Чистовая finish Тонкая Thin | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | | | |
| | | | from above upto 0,10 до 0,11 | Semi Черновая Rough Получистовая finished Чистовая finished Тонкая Thin | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | |
| | | | from above upto 0,11 до 0,12 | semi Черновая Rough Получистовая finished Чистовая finished Тонкая Thin | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
| | | | from above upto 0,12 до 0,14 | semi Черновая Rough Получистовая finished Чистовая finished Тонкая Thin | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
| | | | from above upto 0,14 до 0,16 | semi Черновая Rough Получистовая finished Чистовая finished Тонкая Thin | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
| | | | from above upto 0,16 до 0,18 | semi Черновая Rough Получистовая finished Чистовая finished Тонкая Thin | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
| | | | from above upto 0,18 до 0,20 | semi Черновая Rough Получистовая finished Чистовая finished Тонкая Thin | 1,8 | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
| | | | | | | | | 1,9 | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
| | | | | | | | | 2,1 | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
| | | | | | | | | 2,1 | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |

16 SHEET

Contd. table - 6

| ALT | SHEET No. OF DOCUMENT | DATE | Common tolerance for the element of surface, mm. | Type of finish machining | Common allowance for the side, mm, max. for the series of allowance for the casting. | | | | | | | | | | | | | |
|--------------|-----------------------|------|--|-------------------------------|--|-----|-----|-----|-----|-----|-----|-----|-----|-----|-----|--|--|--|
| | | | | | 1 | 2 | 3 | 4 | 5 | 6 | 7 | 8 | 9 | | | | | |
| 408-26645-85 | | | from above | upto semi Ca. 0.20 до 0.22 | Черновая Rough | 0.3 | 0.4 | 0.4 | 0.5 | 0.6 | 0.6 | 0.8 | 0.9 | 1.1 | 1.4 | | | |
| | | | | | Получистовая finished | 0.3 | 0.4 | 0.5 | 0.6 | 0.7 | 0.8 | 1.1 | 1.4 | 1.6 | | | | |
| | | | | | Чистовая finished | 0.4 | 0.5 | 0.6 | 0.7 | 0.8 | 0.9 | 1.1 | 1.4 | 1.6 | | | | |
| | | | from above | upto semi Ca. 0.22 до 0.24 | Черновая Rough | 0.3 | 0.4 | 0.5 | 0.6 | 0.7 | 0.8 | 1.0 | 1.1 | 1.4 | | | | |
| | | | | | Получистовая finished | 0.4 | 0.4 | 0.6 | 0.6 | 0.8 | 0.8 | 1.1 | 1.4 | 1.6 | | | | |
| | | | | | Чистовая finished | 0.4 | 0.5 | 0.6 | 0.7 | 0.8 | 0.9 | 1.1 | 1.4 | 1.6 | | | | |
| | | | from above | upto semi Ca. 0.24 до 0.28 | Черновая Rough | 0.3 | 0.4 | 0.5 | 0.6 | 0.7 | 0.8 | 1.0 | 1.2 | 1.4 | | | | |
| | | | | | Получистовая finished | 0.4 | 0.5 | 0.6 | 0.7 | 0.8 | 0.9 | 1.1 | 1.4 | 1.6 | | | | |
| | | | | | Чистовая finished | 0.5 | 0.5 | 0.7 | 0.8 | 0.9 | 1.0 | 1.2 | 1.5 | 1.7 | | | | |
| | | | from above | upto semi Ca. 0.28 до 0.32 | Черновая Rough | 0.3 | 0.4 | 0.5 | 0.6 | 0.7 | 0.8 | 1.0 | 1.2 | 1.4 | | | | |
| | | | | | Получистовая finished | 0.4 | 0.5 | 0.6 | 0.7 | 0.8 | 0.9 | 1.0 | 1.2 | 1.5 | | | | |
| | | | | | Чистовая finished | 0.5 | 0.6 | 0.7 | 0.8 | 0.9 | 1.0 | 1.2 | 1.5 | 1.7 | | | | |
| | | | from above | upto semi Ca. 0.32 до 0.36 | Черновая Rough | 0.3 | 0.5 | 0.5 | 0.7 | 0.8 | 0.9 | 1.1 | 1.3 | 1.5 | | | | |
| | | | | | Получистовая finished | 0.5 | 0.6 | 0.7 | 0.8 | 0.9 | 1.0 | 1.2 | 1.5 | 1.7 | | | | |
| | | | | | Чистовая finished | 0.5 | 0.7 | 0.8 | 0.9 | 1.0 | 1.1 | 1.3 | 1.6 | 1.8 | | | | |
| | | | from above | upto semi Ca. 0.36 до 0.40 | Черновая Rough | 0.4 | 0.5 | 0.6 | 0.7 | 0.8 | 0.9 | 1.1 | 1.3 | 1.5 | | | | |
| | | | | | Получистовая finished | 0.5 | 0.6 | 0.7 | 0.8 | 0.9 | 1.0 | 1.2 | 1.5 | 1.7 | | | | |
| | | | | | Чистовая finished | 0.6 | 0.7 | 0.8 | 0.9 | 1.0 | 1.1 | 1.3 | 1.6 | 1.8 | | | | |
| | | | from above | upto semi Ca. 0.40 до 0.44 | Черновая Rough | 0.4 | 0.5 | 0.6 | 0.7 | 0.8 | 0.9 | 1.1 | 1.3 | 1.5 | | | | |
| | | | | | Получистовая finished | 0.6 | 0.7 | 0.8 | 0.9 | 1.0 | 1.1 | 1.3 | 1.6 | 1.8 | | | | |
| | | | | | Чистовая finished | 0.6 | 0.7 | 0.9 | 1.0 | 1.1 | 1.2 | 1.4 | 1.7 | 1.9 | | | | |
| | | | | | | | | | | | | | | | | | | |

Contd. ... table-6.

| SHEET No. OF DOCUMENT | DATE | Common tolerance for the element of surface, mm | Type of finish machining | Common allowance for the side, mm, max. for the series of allowance for the casting. | | | | | | | | | | | | | | |
|-----------------------|-------------------|---|--------------------------|--|-----|-----|-----|----|----|----|----|----|---|---|---|---|---|---|
| | | | | 10 | 11 | 12 | 13 | 14 | 15 | 16 | 17 | 18 | | | | | | |
| Cast 26645-85 | from above | upto 0,20 до 0,22 semi | Черновая Rough | 1,8 | — | — | — | — | — | — | — | — | — | — | — | — | — | |
| | | | Получистовая finished | 2,0 | — | — | — | — | — | — | — | — | — | — | — | — | — | — |
| | | | Чистовая finished | 2,1 | — | — | — | — | — | — | — | — | — | — | — | — | — | — |
| | from above | Св. 0,22 до 0,24 semi | Черновая Rough | 1,8 | 2,2 | 2,6 | — | — | — | — | — | — | — | — | — | — | — | — |
| | | | Получистовая finished | 1,9 | 2,4 | 3,0 | — | — | — | — | — | — | — | — | — | — | — | — |
| | | | Чистовая finished | 2,1 | 2,5 | 3,1 | — | — | — | — | — | — | — | — | — | — | — | — |
| | from above | upto 0,24 до 0,28 semi | Черновая Rough | 1,8 | 2,2 | 2,7 | — | — | — | — | — | — | — | — | — | — | — | — |
| | | | Получистовая finished | 2,0 | 2,4 | 3,0 | — | — | — | — | — | — | — | — | — | — | — | — |
| | | | Чистовая finished | 2,1 | 2,5 | 3,2 | — | — | — | — | — | — | — | — | — | — | — | — |
| | from above | Св. 0,28 до 0,32 | Черновая Rough | 1,8 | 2,2 | 2,7 | 3,3 | — | — | — | — | — | — | — | — | — | — | — |
| | | | Получистовая finished | 2,1 | 2,4 | 3,1 | 3,5 | — | — | — | — | — | — | — | — | — | — | — |
| | | | Чистовая finished | 2,2 | 2,6 | 3,1 | 3,6 | — | — | — | — | — | — | — | — | — | — | — |
| from above | upto 0,32 до 0,36 | Черновая Rough | 1,9 | 2,3 | 2,7 | 3,3 | — | — | — | — | — | — | — | — | — | — | — | |
| | | Получистовая finished | 2,1 | 2,5 | 3,1 | 3,6 | — | — | — | — | — | — | — | — | — | — | — | |
| | | Чистовая finished | 2,3 | 2,7 | 3,3 | 3,8 | — | — | — | — | — | — | — | — | — | — | — | |
| from above | Св. 0,36 до 0,40 | Черновая Rough | 1,9 | 2,3 | 2,8 | 3,3 | 4,3 | — | — | — | — | — | — | — | — | — | — | |
| | | Получистовая finished | 2,1 | 2,5 | 3,2 | 3,7 | 4,8 | — | — | — | — | — | — | — | — | — | — | |
| | | Чистовая finished | 2,3 | 2,7 | 3,3 | 3,8 | 5,0 | — | — | — | — | — | — | — | — | — | — | |
| from above | upto 0,40 до 0,44 | Черновая Rough | 1,9 | 2,3 | 2,8 | 3,4 | 4,3 | — | — | — | — | — | — | — | — | — | — | |
| | | Получистовая finished | 2,2 | 2,6 | 3,1 | 3,6 | 4,8 | — | — | — | — | — | — | — | — | — | — | |
| | | Чистовая finished | 2,4 | 2,7 | 3,4 | 3,9 | 5,0 | — | — | — | — | — | — | — | — | — | — | |
| from above | Св. 0,40 до 0,44 | Черновая Rough | 2,4 | 2,8 | 3,4 | 4,0 | 5,1 | — | — | — | — | — | — | — | — | — | — | |
| | | Получистовая finished | 1,9 | 2,3 | 2,8 | 3,3 | 4,3 | — | — | — | — | — | — | — | — | — | — | |
| | | Чистовая finished | 2,2 | 2,6 | 3,1 | 3,6 | 4,8 | — | — | — | — | — | — | — | — | — | — | |
| from above | upto 0,40 до 0,44 | Черновая Rough | 2,4 | 2,8 | 3,4 | 4,0 | 5,1 | — | — | — | — | — | — | — | — | — | — | |
| | | Получистовая finished | 1,9 | 2,3 | 2,8 | 3,3 | 4,3 | — | — | — | — | — | — | — | — | — | — | |
| | | Чистовая finished | 2,2 | 2,6 | 3,1 | 3,6 | 4,8 | — | — | — | — | — | — | — | — | — | — | |

Contd. table - 6

| APP SHEET No. OF DOCUMENT | SIGNATURE | DATE | Common tolerance for the element of surface, mm | Type of finish machining | Common allowance for the side, mm, max, for the series of allowance for the casting. | | | | | | | | | |
|---------------------------------------|-------------------------------|-----------------------|---|-------------------------------|--|-----|-----|-----|-----|-----|-----|-----|-----|-----|
| | | | | | 1 | 2 | 3 | 4 | 5 | 6 | 7 | 8 | 9 | |
| | | | | | | | | | | | | | | |
| APP SHEET No. OF DOCUMENT 26645-85 | | | from above | upto semi Cs. 0,44 до 0,50 | Черновая Rough | 0,6 | 0,5 | 0,7 | 0,8 | 0,9 | 1,0 | 1,2 | 1,4 | 1,6 |
| | | | | | Получистовая finished | 0,6 | 0,7 | 0,8 | 0,9 | 1,0 | 1,1 | 1,3 | 1,6 | 1,8 |
| | | | Чистовая finished | 0,7 | 0,8 | 0,9 | 1,0 | 1,1 | 1,2 | 1,4 | 1,7 | 1,9 | | |
| | | | Тонкая Thin | 0,8 | 0,9 | 1,0 | 1,1 | 1,2 | 1,3 | 1,5 | 1,8 | 2,0 | | |
| | | | from above | upto semi Cs. 0,50 до 0,56 | Черновая Rough | 0,5 | 0,6 | 0,7 | 0,8 | 0,9 | 1,0 | 1,2 | 1,4 | 1,6 |
| | | | | | Получистовая finished | 0,7 | 0,8 | 0,9 | 1,0 | 1,1 | 1,2 | 1,4 | 1,7 | 1,9 |
| | | | Чистовая finished | 0,8 | 0,9 | 1,0 | 1,1 | 1,2 | 1,3 | 1,5 | 1,8 | 2,0 | | |
| | | | Тонкая Thin | 0,9 | 1,0 | 1,1 | 1,2 | 1,3 | 1,4 | 1,6 | 1,9 | 2,1 | | |
| | | | from above | upto semi Cs. 0,56 до 0,64 | Черновая Rough | 0,5 | 0,7 | 0,8 | 0,9 | 1,0 | 1,1 | 1,3 | 1,5 | 1,7 |
| | | | | | Получистовая finished | 0,8 | 0,9 | 1,0 | 1,1 | 1,2 | 1,3 | 1,5 | 1,8 | 2,0 |
| | | | Чистовая finished | 0,9 | 1,0 | 1,1 | 1,2 | 1,3 | 1,4 | 1,6 | 1,9 | 2,1 | | |
| | | | Тонкая Thin | 1,0 | 1,1 | 1,2 | 1,3 | 1,4 | 1,5 | 1,7 | 2,0 | 2,2 | | |
| | | | from above | upto semi Cs. 0,64 до 0,70 | Черновая Rough | 0,6 | 0,7 | 0,8 | 0,9 | 1,0 | 1,1 | 1,3 | 1,5 | 1,7 |
| | | | | | Получистовая finished | 0,8 | 0,9 | 1,1 | 1,2 | 1,3 | 1,4 | 1,6 | 1,9 | 2,1 |
| | | | Чистовая finished | 0,9 | 1,1 | 1,1 | 1,3 | 1,4 | 1,4 | 1,6 | 1,9 | 2,2 | | |
| | | | Тонкая Thin | 1,1 | 1,1 | 1,3 | 1,4 | 1,4 | 1,6 | 1,8 | 2,1 | 2,3 | | |
| | | | from above | upto semi Cs. 0,70 до 0,80 | Черновая Rough | 0,6 | 0,8 | 0,8 | 0,9 | 1,1 | 1,1 | 1,4 | 1,5 | 1,8 |
| | | | | | Получистовая finished | 0,9 | 1,1 | 1,2 | 1,3 | 1,4 | 1,5 | 1,7 | 2,0 | 2,1 |
| | | | Чистовая finished | 1,1 | 1,2 | 1,3 | 1,4 | 1,5 | 1,6 | 1,8 | 2,1 | 2,3 | | |
| | | | Тонкая Thin | 1,2 | 1,3 | 1,4 | 1,5 | 1,6 | 1,7 | 1,9 | 2,2 | 2,4 | | |
| | | | from above | upto semi Cs. 0,80 до 0,90 | Черновая Rough | 0,7 | 0,8 | 0,9 | 1,0 | 1,1 | 1,2 | 1,4 | 1,5 | 1,8 |
| | | | | | Получистовая finished | 1,1 | 1,2 | 1,3 | 1,4 | 1,5 | 1,6 | 1,8 | 2,1 | 2,3 |
| | | | Чистовая finished | 1,2 | 1,3 | 1,4 | 1,5 | 1,6 | 1,7 | 1,9 | 2,2 | 2,4 | | |
| | | | Тонкая Thin | 1,4 | 1,4 | 1,6 | 1,6 | 1,8 | 1,9 | 2,1 | 2,4 | 2,6 | | |
| from above | upto semi Cs. 0,90 до 1,00 | Черновая Rough | 0,8 | 0,9 | 1,0 | 1,1 | 1,2 | 1,3 | 1,5 | 1,7 | 1,9 | | | |
| | | Получистовая finished | 1,2 | 1,3 | 1,4 | 1,5 | 1,6 | 1,7 | 1,9 | 2,1 | 2,4 | | | |
| Чистовая finished | 1,3 | 1,4 | 1,5 | 1,6 | 1,7 | 1,8 | 2,0 | 2,3 | 2,5 | | | | | |
| Тонкая Thin | 1,5 | 1,6 | 1,7 | 1,8 | 1,9 | 2,0 | 2,2 | 2,5 | 2,7 | | | | | |

Contd. table - 6.

| All SHEET No. OF DOCUMENT | SIGNATURE | DATE | Common tolerance for the element of surface, mm | Type of finish machining | Common allowance for the side, mm, max, for the series of allowance for the casting. | | | | | | | | | | | | | |
|---------------------------|-----------|------------------|---|--------------------------|--|-----------------------|-----|-----|-----|-----|------|------|-----|-----|---|--|--|--|
| | | | | | 10 | 11 | 12 | 13 | 14 | 15 | 16 | 17 | 18 | | | | | |
| 4881 26645-85 | | | from above | upto semi | Св. 0,44 до 0,50 | Черновая Rough | 2,0 | 2,4 | 2,8 | 3,4 | 4,4 | 5,3 | — | — | — | | | |
| | | | | | | Получистовая finished | 2,2 | 2,6 | 3,3 | 3,8 | 4,8 | 5,8 | — | — | — | | | |
| | | | | | | Чистовая finished | 2,4 | 2,8 | 3,5 | 3,9 | 5,2 | 6,2 | — | — | — | | | |
| | | | from above | upto semi | Св. 0,50 до 0,56 | Черновая Rough | 2,0 | 2,4 | 2,9 | 3,4 | 4,4 | 5,5 | — | — | — | | | |
| | | | | | | Получистовая finished | 2,3 | 2,7 | 3,3 | 3,8 | 4,9 | 6,8 | — | — | — | | | |
| | | | | | | Чистовая finished | 2,5 | 2,9 | 3,4 | 4,0 | 5,1 | 6,1 | — | — | — | | | |
| | | | from above | upto semi | Св. 0,56 до 0,64 | Черновая Rough | 2,1 | 2,4 | 2,9 | 3,5 | 4,4 | 5,5 | 6,6 | — | — | | | |
| | | | | | | Получистовая finished | 2,4 | 2,8 | 3,4 | 3,9 | 5,0 | 6,0 | 7,1 | — | — | | | |
| | | | | | | Чистовая finished | 2,6 | 3,0 | 3,6 | 4,1 | 5,3 | 6,3 | 7,3 | — | — | | | |
| | | | from above | upto semi | Св. 0,64 до 0,70 | Черновая Rough | 2,1 | 2,5 | 3,0 | 3,4 | 4,5 | 5,4 | 6,5 | 8,5 | — | | | |
| | | | | | | Получистовая finished | 2,4 | 2,8 | 3,5 | 3,9 | 5,0 | 6,0 | 7,1 | 9,3 | — | | | |
| | | | | | | Чистовая finished | 2,6 | 3,1 | 3,6 | 4,1 | 5,3 | 6,3 | 7,5 | 9,8 | — | | | |
| from above | upto semi | Св. 0,70 до 0,80 | Черновая Rough | 2,2 | 2,6 | 3,1 | 3,6 | 4,6 | 5,6 | 6,5 | 8,5 | — | | | | | | |
| | | | Получистовая finished | 2,5 | 2,9 | 3,6 | 4,0 | 5,2 | 6,2 | 7,3 | 9,3 | — | | | | | | |
| | | | Чистовая finished | 2,8 | 3,1 | 3,8 | 4,3 | 5,4 | 6,5 | 7,5 | 9,8 | — | | | | | | |
| from above | upto semi | Св. 0,80 до 0,90 | Черновая Rough | 2,2 | 2,6 | 3,2 | 3,7 | 4,6 | 5,6 | 6,7 | 8,5 | 10,5 | | | | | | |
| | | | Получистовая finished | 2,7 | 3,1 | 3,7 | 4,1 | 5,3 | 6,3 | 7,3 | 9,5 | 11,5 | | | | | | |
| | | | Чистовая finished | 2,9 | 3,4 | 3,9 | 4,4 | 5,5 | 6,7 | 7,8 | 9,8 | 12,0 | | | | | | |
| from above | upto semi | Св. 0,90 до 1,00 | Черновая Rough | 2,3 | 2,7 | 3,1 | 3,6 | 4,8 | 5,6 | 6,7 | 8,8 | 10,5 | | | | | | |
| | | | Получистовая finished | 2,7 | 3,2 | 3,8 | 4,3 | 5,3 | 6,3 | 7,5 | 9,5 | 11,5 | | | | | | |
| | | | Чистовая finished | 3,0 | 3,5 | 4,0 | 4,5 | 5,8 | 6,7 | 7,8 | 10,0 | 12,0 | | | | | | |
| | | | | | | | | | | | | | | | | | | |

Contd. table-6.

| NO. SHEET No. OF DOCUMENT | SHEET No. | Common tolerance for the element of surface, mm | Type of finish machining | Common allowance for the side, mm, max, for the series of allowance for the casting. | | | | | | | | | |
|---|-----------------------|---|--------------------------|--|-----|-----|-----|-----|-----|-----|-----|-----|--|
| | | | | 1 | 2 | 3 | 4 | 5 | 6 | 7 | 8 | 9 | |
| 9087 26645-85 | 21 | from above upto semi Ca. 1.00 до 1.40 | Черновая Rough | 0.8 | 0.9 | 1.1 | 1.2 | 1.3 | 1.4 | 1.6 | 1.8 | 2.0 | |
| | | | Получистовая finished | 1.1 | 1.3 | 1.4 | 1.4 | 1.6 | 1.6 | 1.9 | 2.2 | 2.4 | |
| | | | Чистовая finished | 1.4 | 1.4 | 1.6 | 1.6 | 1.8 | 1.9 | 2.1 | 2.4 | 2.6 | |
| | | from above upto semi Ca. 1.10 до 1.20 | Тонкая Thin | 1.8 | 1.7 | 1.8 | 1.9 | 2.0 | 2.1 | 2.3 | 2.5 | 2.7 | |
| | | | Черновая Rough | 0.9 | 1.0 | 1.1 | 1.2 | 1.3 | 1.4 | 1.6 | 1.8 | 2.0 | |
| | | | Получистовая finished | 1.2 | 1.4 | 1.5 | 1.6 | 1.7 | 1.8 | 2.0 | 2.3 | 2.5 | |
| | | from above upto semi Ca. 1.20 до 1.40 | Чистовая finished | 1.5 | 1.6 | 1.7 | 1.8 | 1.9 | 2.0 | 2.2 | 2.5 | 2.7 | |
| | | | Тонкая Thin | 1.7 | 1.8 | 1.9 | 2.0 | 2.1 | 2.1 | 2.4 | 2.7 | 2.8 | |
| | | | Черновая Rough | 1.1 | 1.2 | 1.3 | 1.4 | 1.5 | 1.6 | 1.8 | 2.0 | 2.1 | |
| | | from above upto semi Ca. 1.40 до 1.60 | Получистовая finished | 1.5 | 1.6 | 1.7 | 1.8 | 1.9 | 2.0 | 2.2 | 2.5 | 2.7 | |
| | | | Чистовая finished | 1.8 | 1.9 | 1.9 | 2.1 | 2.2 | 2.3 | 2.5 | 2.8 | 3.0 | |
| | | | Тонкая Thin | 1.9 | 2.0 | 2.1 | 2.2 | 2.3 | 2.4 | 2.6 | 2.9 | 3.2 | |
| from above upto semi Ca. 1.60 до 1.80 | Черновая Rough | 1.2 | 1.3 | 1.4 | 1.5 | 1.6 | 1.7 | 1.9 | 2.1 | 2.3 | | | |
| | Получистовая finished | 1.7 | 1.8 | 1.9 | 2.0 | 2.1 | 2.2 | 2.4 | 2.7 | 2.9 | | | |
| | Чистовая finished | 1.9 | 2.1 | 2.2 | 2.3 | 2.4 | 2.5 | 2.6 | 3.0 | 3.1 | | | |
| from above upto semi Ca. 1.80 до 2.00 | Тонкая Thin | 2.2 | 2.3 | 2.4 | 2.5 | 2.6 | 2.7 | 2.9 | 3.1 | 3.4 | | | |
| | Черновая Rough | 1.3 | 1.4 | 1.5 | 1.6 | 1.7 | 1.8 | 2.0 | 2.2 | 2.4 | | | |
| | Получистовая finished | 1.9 | 2.1 | 2.2 | 2.3 | 2.4 | 2.5 | 2.6 | 3.0 | 3.1 | | | |
| from above upto semi Ca. 2.00 до 2.20 | Чистовая finished | 2.3 | 2.4 | 2.5 | 2.6 | 2.7 | 2.8 | 3.0 | 3.4 | 3.6 | | | |
| | Тонкая Thin | 2.6 | 2.7 | 2.8 | 2.9 | 3.0 | 3.1 | 3.3 | 3.6 | 3.8 | | | |
| | Черновая Rough | 1.5 | 1.6 | 1.7 | 1.8 | 1.9 | 2.0 | 2.2 | 2.4 | 2.6 | | | |
| | Получистовая finished | 2.1 | 2.3 | 2.4 | 2.4 | 2.5 | 2.7 | 2.8 | 3.2 | 3.4 | | | |
| | Чистовая finished | 2.6 | 2.6 | 2.7 | 2.8 | 2.9 | 3.0 | 3.3 | 3.6 | 3.8 | | | |
| | Тонкая Thin | 2.9 | 3.0 | 3.1 | 3.1 | 3.3 | 3.4 | 3.6 | 3.9 | 4.1 | | | |

Contd... table 6.

SHEET 22

Common tolerance for the element of surface, mm

Type of finish machining

Common allowance for the side, mm, max. for the series of allowance for the casting.

| | 10 | 11 | 12 | 13 | 14 | 15 | 16 | 17 | 18 | |
|---|-----------------------|-----|-----|-----|-----|-----|-----|-----|------|------|
| from above upto semi Ca. 1,00 до 1,10 | Черновая Rough | 2,4 | 2,7 | 3,3 | 3,8 | 4,8 | 5,8 | 6,7 | 8,8 | 10,5 |
| | Получистовая finished | 2,8 | 3,1 | 3,8 | 4,3 | 5,3 | 6,3 | 7,5 | 9,5 | 11,5 |
| | Чистовая finished | 3,1 | 3,4 | 4,1 | 4,6 | 5,8 | 6,7 | 7,8 | 10,0 | 12,5 |
| | Тонкая Thin | 3,3 | 3,7 | 4,4 | 4,9 | 6,0 | 7,1 | 8,3 | 10,5 | 12,5 |
| from above upto semi Ca. 1,10 до 1,20 | Черновая Rough | 2,4 | 2,8 | 3,4 | 3,8 | 4,8 | 5,8 | 6,9 | 8,8 | 11,0 |
| | Получистовая finished | 2,9 | 3,4 | 3,9 | 4,4 | 5,4 | 6,5 | 7,5 | 9,8 | 12,0 |
| | Чистовая finished | 3,1 | 3,6 | 4,3 | 4,8 | 5,8 | 6,9 | 8,0 | 10,0 | 12,5 |
| | Тонкая Thin | 3,4 | 3,8 | 4,4 | 4,9 | 6,2 | 7,1 | 8,3 | 10,5 | 12,5 |
| from above upto semi Ca. 1,20 до 1,40 | Черновая Rough | 2,5 | 2,9 | 3,5 | 3,9 | 4,9 | 6,0 | 6,9 | 9,0 | 11,0 |
| | Получистовая finished | 3,1 | 3,4 | 4,1 | 4,5 | 5,6 | 6,7 | 7,8 | 9,8 | 12,0 |
| | Чистовая finished | 3,4 | 3,9 | 4,5 | 5,0 | 6,1 | 7,1 | 8,3 | 10,5 | 12,5 |
| | Тонкая Thin | 3,7 | 4,0 | 4,8 | 5,1 | 6,5 | 7,5 | 8,5 | 11,0 | 13,0 |
| from above upto semi Ca. 1,40 до 1,60 | Черновая Rough | 2,7 | 3,1 | 3,6 | 4,0 | 5,0 | 6,0 | 7,1 | 9,0 | 11,0 |
| | Получистовая finished | 3,3 | 3,6 | 4,3 | 4,8 | 5,8 | 6,9 | 8,0 | 10,0 | 12,0 |
| | Чистовая finished | 3,6 | 4,1 | 4,6 | 5,1 | 6,3 | 7,3 | 8,5 | 10,5 | 13,0 |
| | Тонкая Thin | 3,9 | 4,3 | 5,0 | 5,4 | 6,7 | 7,8 | 8,8 | 11,0 | 13,5 |
| from above upto semi Ca. 1,60 до 1,80 | Черновая Rough | 2,7 | 3,2 | 3,7 | 4,1 | 5,2 | 6,2 | 7,1 | 9,0 | 11,0 |
| | Получистовая finished | 3,5 | 3,8 | 4,4 | 4,9 | 6,0 | 7,1 | 8,0 | 10,0 | 12,5 |
| | Чистовая finished | 3,8 | 4,3 | 4,8 | 5,3 | 6,5 | 7,5 | 8,5 | 11,0 | 13,0 |
| | Тонкая Thin | 4,0 | 4,4 | 5,2 | 5,6 | 6,9 | 7,8 | 9,0 | 11,0 | 13,5 |
| from above upto semi Ca. 1,80 до 2,00 | Черновая Rough | 2,8 | 3,3 | 3,8 | 4,3 | 5,1 | 6,1 | 7,3 | 9,3 | 11,0 |
| | Получистовая finished | 3,6 | 4,0 | 4,6 | 5,0 | 6,1 | 7,1 | 8,3 | 10,5 | 12,5 |
| | Чистовая finished | 4,0 | 4,4 | 5,0 | 5,4 | 6,7 | 7,8 | 8,8 | 11,0 | 13,0 |
| | Тонкая Thin | 4,3 | 4,8 | 5,5 | 5,8 | 7,1 | 8,0 | 9,3 | 11,5 | 13,5 |
| from above upto semi Ca. 2,00 до 2,20 | Черновая Rough | 3,0 | 3,4 | 3,9 | 4,4 | 5,5 | 6,3 | 7,3 | 9,5 | 11,5 |
| | Получистовая finished | 3,8 | 4,1 | 4,8 | 5,3 | 6,3 | 7,3 | 8,5 | 10,5 | 12,5 |
| | Чистовая finished | 4,3 | 4,6 | 5,1 | 5,8 | 6,9 | 8,0 | 9,0 | 11,0 | 13,5 |
| | Тонкая Thin | 4,6 | 5,0 | 5,6 | 6,1 | 7,3 | 8,3 | 9,5 | 12,0 | 14,0 |

Gost. 26645-85

ALL SHEET No. OF DOCUMENT SIGNATURE DATE

Contd. Table - 6

| All SHEET No. of drawing | Common tolerance for the element of surface, mm | Type of finish machining | Common allowance for the side, mm, max. for the series of allowance for the casting. | | | | | | | | | |
|--------------------------|---|--------------------------|--|-------------|----------------|-----|-----|-----|-----|-----|-----|-----|
| | | | 1 | 2 | 3 | 4 | 5 | 6 | 7 | 8 | 9 | |
| | | | from above | upto semi | Черновая Rough | 1.6 | 1.7 | 1.8 | 1.9 | 2.0 | 2.1 | 2.3 |
| 9081 26645-85 | Св. 2,00 до 2,40 | Получистовая finished | 2.4 | 2.5 | 2.6 | 2.6 | 2.8 | 2.9 | 3.1 | 3.4 | 3.6 | |
| | | | Чистовая finished | 2.7 | 2.8 | 2.9 | 3.1 | 3.2 | 3.3 | 3.5 | 3.8 | 3.9 |
| | | | | Тонкая Thin | 3.1 | 3.1 | 3.3 | 3.4 | 3.4 | 3.6 | 3.8 | 4.1 |
| from above | upto semi | Черновая Rough | 1.8 | 1.9 | 1.9 | 2.1 | 2.2 | 2.3 | 2.5 | 2.6 | 2.9 | |
| Св. 2,40 до 2,80 | Получистовая finished | 2.6 | 2.7 | 2.8 | 2.9 | 3.0 | 3.1 | 3.3 | 3.6 | 3.8 | 3.8 | |
| | | Чистовая finished | 3.0 | 3.2 | 3.3 | 3.4 | 3.5 | 3.6 | 3.8 | 4.0 | 4.3 | |
| | | | Тонкая Thin | 3.5 | 3.6 | 3.7 | 3.8 | 3.8 | 3.9 | 4.1 | 4.4 | 4.6 |
| from above | upto semi | Черновая Rough | 1.9 | 2.1 | 2.2 | 2.3 | 2.4 | 2.5 | 2.6 | 2.9 | 3.1 | |
| Св. 2,80 до 3,20 | Получистовая finished | 3.0 | 3.1 | 3.1 | 3.3 | 3.4 | 3.4 | 3.6 | 4.0 | 4.1 | 4.1 | |
| | | Чистовая finished | 3.4 | 3.6 | 3.6 | 3.8 | 3.9 | 4.0 | 4.1 | 4.5 | 4.6 | |
| | | | Тонкая Thin | 3.8 | 3.9 | 4.0 | 4.1 | 4.3 | 4.3 | 4.5 | 4.8 | 5.0 |
| from above | upto semi | Черновая Rough | 2.2 | 2.3 | 2.4 | 2.5 | 2.6 | 2.7 | 2.9 | 3.1 | 3.3 | |
| Св. 3,20 до 3,60 | Получистовая finished | 3.3 | 3.4 | 3.4 | 3.6 | 3.6 | 3.8 | 4.0 | 4.3 | 4.5 | 4.5 | |
| | | Чистовая finished | 3.9 | 4.0 | 4.1 | 4.3 | 4.3 | 4.4 | 4.6 | 4.9 | 5.2 | |
| | | | Тонкая Thin | 4.3 | 4.4 | 4.4 | 4.5 | 4.6 | 4.8 | 4.9 | 5.3 | 5.6 |
| from above | upto semi | Черновая Rough | 2.4 | 2.5 | 2.6 | 2.7 | 2.8 | 2.9 | 3.2 | 3.4 | 3.6 | |
| Св. 3,60 до 4,00 | Получистовая finished | 3.6 | 3.8 | 3.9 | 4.0 | 4.1 | 4.3 | 4.4 | 4.4 | 4.8 | 4.9 | |
| | | Чистовая finished | 4.3 | 4.4 | 4.4 | 4.6 | 4.6 | 4.8 | 4.9 | 5.3 | 5.5 | |
| | | | Тонкая Thin | 4.8 | 4.9 | 5.0 | 5.2 | 5.1 | 5.3 | 5.4 | 5.8 | 6.0 |
| from above | upto semi | Черновая Rough | 2.5 | 2.6 | 2.7 | 2.8 | 2.9 | 3.0 | 3.3 | 3.5 | 3.7 | |
| Св. 4,00 до 4,40 | Получистовая finished | 3.8 | 3.9 | 4.0 | 4.1 | 4.3 | 4.3 | 4.5 | 4.8 | 5.0 | 5.0 | |
| | | Чистовая finished | 4.5 | 4.6 | 4.8 | 4.8 | 4.9 | 5.0 | 5.1 | 5.4 | 5.8 | |
| | | | Тонкая Thin | 4.9 | 5.0 | 5.2 | 5.3 | 5.3 | 5.5 | 5.6 | 6.0 | 6.2 |
| from above | upto semi | Черновая Rough | 2.9 | 3.0 | 3.1 | 3.1 | 3.3 | 3.4 | 3.6 | 3.8 | 4.0 | |
| Св. 4,40 до 5,00 | Получистовая finished | 4.3 | 4.4 | 4.4 | 4.5 | 4.6 | 4.8 | 4.9 | 4.9 | 5.3 | 5.5 | |
| | | Чистовая finished | 5.0 | 5.1 | 5.3 | 5.3 | 5.4 | 5.6 | 5.8 | 6.0 | 6.3 | |
| | | | Тонкая Thin | 5.6 | 5.8 | 5.8 | 6.0 | 6.0 | 6.2 | 6.3 | 6.7 | 6.9 |

Contd. Table 6

| All SHEET No. OF DOCUMENT | Common toler- ance for the element of surface, mm | Type of finish machining | Common allowance for the side, mm, max, for the series of allowance for the casting. | | | | | | | | | |
|--|--|-----------------------------|---|-----|-----|------|------|------|------|------|------|------|
| | | | 10 | 11 | 12 | 13 | 14 | 15 | 16 | 17 | 18 | |
| Cast 26645-85 | from above Св. 2,20 до 2,40 upto semi | Черновая Rough | 3,1 | 3,4 | 4,0 | 4,5 | 5,4 | 6,5 | 7,6 | 8,8 | 9,8 | 11,5 |
| | | Получистовая finished | 4,0 | 4,4 | 5,0 | 5,4 | 6,5 | 7,5 | 8,8 | 11,0 | 13,0 | |
| | | Чистовая finished | 4,4 | 4,9 | 5,5 | 6,0 | 7,1 | 8,3 | 9,3 | 11,5 | 13,5 | |
| | from above Св. 2,40 до 2,80 upto semi | Тонкая Thin | 4,8 | 5,1 | 5,8 | 6,3 | 7,5 | 8,5 | 9,8 | 12,0 | 14,0 | |
| | | Черновая Rough | 3,3 | 3,6 | 4,1 | 4,6 | 5,5 | 6,7 | 7,8 | 9,8 | 11,5 | |
| | | Получистовая finished | 4,3 | 4,6 | 5,1 | 5,6 | 6,7 | 7,8 | 9,0 | 11,0 | 13,0 | |
| | from above Св. 2,80 до 3,20 upto semi | Чистовая finished | 4,8 | 5,2 | 5,8 | 6,1 | 7,5 | 8,5 | 9,5 | 11,5 | 14,0 | |
| | | Тонкая Thin | 5,2 | 5,4 | 6,1 | 6,7 | 8,0 | 9,0 | 10,0 | 12,5 | 14,5 | |
| | | Черновая Rough | 3,4 | 3,9 | 4,4 | 4,9 | 5,8 | 6,9 | 7,8 | 9,8 | 12,0 | |
| | from above Св. 3,20 до 3,60 upto semi | Получистовая finished | 4,6 | 5,0 | 5,6 | 6,0 | 7,1 | 8,3 | 9,3 | 11,5 | 13,5 | |
| | | Чистовая finished | 5,1 | 5,6 | 6,1 | 6,7 | 7,8 | 8,8 | 9,8 | 12,0 | 14,5 | |
| | | Тонкая Thin | 5,4 | 5,8 | 6,5 | 7,1 | 8,3 | 9,3 | 10,5 | 12,5 | 15,0 | |
| | from above Св. 3,60 до 4,00 upto semi | Черновая Rough | 3,6 | 4,1 | 4,8 | 5,2 | 6,2 | 7,1 | 8,0 | 10,0 | 12,0 | |
| | | Получистовая finished | 4,9 | 5,3 | 5,8 | 6,3 | 7,5 | 8,5 | 9,5 | 11,5 | 14,0 | |
| | | Чистовая finished | 5,6 | 6,0 | 6,5 | 7,1 | 8,3 | 9,3 | 10,5 | 12,5 | 15,0 | |
| | from above Св. 4,00 до 4,40 upto semi | Тонкая Thin | 6,0 | 6,3 | 7,1 | 7,5 | 8,8 | 9,8 | 11,0 | 13,0 | 15,5 | |
| | | Черновая Rough | 3,9 | 4,3 | 4,8 | 5,3 | 6,3 | 7,3 | 8,3 | 10,5 | 12,5 | |
| | | Получистовая finished | 5,3 | 5,8 | 6,3 | 6,7 | 8,0 | 9,0 | 9,8 | 12,0 | 14,0 | |
| from above Св. 4,40 до 5,00 upto semi | Чистовая finished | 6,0 | 6,3 | 6,9 | 7,5 | 8,8 | 9,8 | 10,5 | 13,0 | 15,0 | | |
| | Тонкая Thin | 6,5 | 6,9 | 7,5 | 8,0 | 9,3 | 10,5 | 11,5 | 13,5 | 16,0 | | |
| | Черновая Rough | 4,0 | 4,4 | 4,9 | 5,5 | 6,5 | 7,5 | 8,5 | 10,5 | 12,5 | | |
| from above | Получистовая finished | 5,5 | 5,8 | 6,3 | 6,9 | 8,0 | 9,0 | 10,0 | 12,0 | 14,5 | | |
| | Чистовая finished | 6,1 | 6,7 | 7,3 | 7,8 | 9,0 | 9,8 | 11,0 | 13,0 | 15,5 | | |
| | Тонкая Thin | 6,7 | 7,1 | 7,8 | 8,3 | 9,5 | 10,5 | 11,5 | 14,0 | 16,0 | | |
| from above | Черновая Rough | 4,4 | 4,8 | 5,3 | 5,8 | 6,7 | 7,8 | 8,8 | 11,0 | 13,0 | | |
| | Получистовая finished | 5,8 | 6,3 | 6,9 | 7,3 | 8,5 | 9,5 | 10,5 | 12,5 | 14,5 | | |
| | Чистовая finished | 6,7 | 7,1 | 7,8 | 8,3 | 9,5 | 10,5 | 11,5 | 14,0 | 16,0 | | |
| from above | Тонкая Thin | 7,3 | 7,8 | 8,5 | 9,0 | 10,0 | 11,0 | 12,0 | 14,5 | 16,5 | | |

Contd. Table-6

| No. of sheets | SHEET No. of document | DATE | Common tolerance for the element of surface, mm. | Type of finish machining | Common allowance for the side, mm, max, for the series of allowance for the casting. | | | | | | | | | |
|---------------|-----------------------|-----------------------|--|--------------------------|--|---|------|------|------|------|------|------|------|------|
| | | | | | 1 | 2 | 3 | 4 | 5 | 6 | 7 | 8 | 9 | |
| 4851-26645-85 | | | from above | upto semi | Черновая Rough | — | 3.3 | 3.4 | 3.4 | 3.6 | 3.6 | 3.9 | 4.1 | 4.3 |
| | | | | | Получистовая finished | — | 4.9 | 5.0 | 5.2 | 5.1 | 5.3 | 5.4 | 5.8 | 6.0 |
| | | | | | Чистовая finished | — | 5.8 | 5.8 | 6.0 | 6.0 | 6.2 | 6.3 | 6.7 | 6.9 |
| | | | | | Тонкая Thin | — | 6.3 | 6.5 | 6.5 | 6.7 | 6.7 | 6.9 | 7.3 | 7.5 |
| | | | from above | upto semi | Черновая Rough | — | 3.8 | 3.9 | 4.0 | 4.1 | 4.3 | 4.4 | 4.6 | 4.8 |
| | | | | | Получистовая finished | — | 5.1 | 5.3 | 5.3 | 5.4 | 5.6 | 5.8 | 6.0 | 6.3 |
| | | | | | Чистовая finished | — | 6.1 | 6.3 | 6.3 | 6.5 | 6.5 | 6.7 | 7.1 | 7.3 |
| | | | | | Тонкая Thin | — | 6.9 | 7.1 | 7.1 | 7.3 | 7.3 | 7.5 | 7.8 | 8.0 |
| | | | from above | upto semi | Черновая Rough | — | — | 4.3 | 4.3 | 4.4 | 4.5 | 4.8 | 4.9 | 5.2 |
| | | | | | Получистовая finished | — | — | 5.8 | 6.0 | 6.0 | 6.2 | 6.3 | 6.7 | 6.9 |
| | | | | | Чистовая finished | — | — | 6.9 | 7.1 | 7.1 | 7.3 | 7.5 | 7.8 | 8.0 |
| | | | | | Тонкая Thin | — | — | 7.8 | 7.8 | 7.8 | 8.0 | 8.3 | 8.5 | 8.8 |
| | | | from above | upto semi | Черновая Rough | — | — | 4.8 | 4.8 | 4.9 | 5.0 | 5.1 | 5.5 | 5.6 |
| | | | | | Получистовая finished | — | — | 6.5 | 6.5 | 6.7 | 6.7 | 6.9 | 7.3 | 7.5 |
| | | | | | Чистовая finished | — | — | 8.0 | 8.0 | 8.0 | 8.3 | 8.5 | 8.8 | 9.0 |
| | | | | | Тонкая Thin | — | — | 8.5 | 8.8 | 8.8 | 8.8 | 9.0 | 9.3 | 9.5 |
| | | | from above | upto semi | Черновая Rough | — | — | — | 5.3 | 5.4 | 5.6 | 5.8 | 6.0 | 6.1 |
| | | | | | Получистовая finished | — | — | — | 7.3 | 7.5 | 7.5 | 7.8 | 8.0 | 8.3 |
| | | | | | Чистовая finished | — | — | — | 9.0 | 9.0 | 9.3 | 9.3 | 9.8 | 9.8 |
| | | | | | Тонкая Thin | — | — | — | 9.8 | 9.8 | 9.8 | 10.0 | 10.5 | 10.5 |
| | | | from above | upto semi | Черновая Rough | — | — | — | 6.0 | 6.0 | 6.2 | 6.3 | 6.5 | 6.7 |
| | | | | | Получистовая finished | — | — | — | 8.3 | 8.3 | 8.5 | 8.5 | 9.0 | 9.0 |
| | | | | | Чистовая finished | — | — | — | 9.8 | 9.8 | 9.8 | 10.0 | 10.5 | 10.5 |
| | | | | | Тонкая Thin | — | — | — | 11.0 | 11.0 | 11.0 | 11.5 | 11.5 | 12.0 |
| from above | upto semi | Черновая Rough | — | — | — | — | 6.5 | 6.5 | 6.7 | 6.9 | 7.1 | | | |
| | | Получистовая finished | — | — | — | — | 8.5 | 8.8 | 8.8 | 9.3 | 9.3 | | | |
| | | Чистовая finished | — | — | — | — | 10.0 | 10.0 | 10.5 | 10.5 | 11.0 | | | |
| | | Тонкая Thin | — | — | — | — | 11.0 | 11.5 | 11.5 | 12.0 | 12.0 | | | |

Contd. table - 6

| Alt | SHEET NO. OF BOOKLET | SIGNATURE | DATE | Common tolerance for the element of surface, mm. | Type of finish machining. | Common allowance for the side, mm, max, for the series of allowance for the casting. | | | | | | | | |
|-----|----------------------|-----------|------|--|---------------------------|--|------|------|------|------|------|------|------|------|
| | | | | | | 10 | 11 | 12 | 13 | 14 | 15 | 16 | 17 | 18 |
| | | | | from above upto semi | Черновая Rough | 4.8 | 5.2 | 5.6 | 6.2 | 7.1 | 8.0 | 9.0 | 11.0 | 13.0 |
| | | | | Ca. 5.00 до 6.00 | Получистовая finished | 6.3 | 6.7 | 7.3 | 8.0 | 9.0 | 9.8 | 11.0 | 13.0 | 15.5 |
| | | | | | Чистовая finished | 7.3 | 7.8 | 8.3 | 8.8 | 10.0 | 11.0 | 12.0 | 14.5 | 16.5 |
| | | | | | Тонкая Thin | 8.0 | 8.3 | 9.0 | 9.5 | 11.0 | 12.0 | 13.0 | 15.0 | 17.5 |
| | | | | from above upto semi | Черновая Rough | 5.1 | 5.6 | 6.2 | 6.5 | 7.5 | 8.5 | 9.5 | 11.5 | 13.5 |
| | | | | Ca. 6.00 до 6.40 | Получистовая finished | 6.7 | 7.1 | 7.8 | 8.3 | 9.3 | 10.5 | 11.5 | 13.5 | 15.5 |
| | | | | | Чистовая finished | 7.3 | 8.3 | 8.8 | 9.3 | 10.5 | 11.5 | 12.5 | 15.0 | 17.0 |
| | | | | | Тонкая Thin | 8.5 | 9.0 | 9.8 | 10.0 | 11.5 | 12.5 | 13.5 | 16.0 | 18.0 |
| | | | | from above upto semi | Черновая Rough | 5.4 | 6.0 | 6.5 | 6.9 | 8.0 | 9.0 | 9.8 | 12.0 | 14.0 |
| | | | | Ca. 6.40 до 7.00 | Получистовая finished | 7.3 | 7.5 | 8.3 | 8.8 | 9.8 | 11.0 | 12.0 | 14.0 | 16.0 |
| | | | | | Чистовая finished | 8.5 | 8.8 | 9.5 | 9.8 | 11.0 | 12.0 | 13.0 | 15.5 | 17.5 |
| | | | | | Тонкая Thin | 9.3 | 9.5 | 10.5 | 11.0 | 12.0 | 13.0 | 14.0 | 16.5 | 18.5 |
| | | | | from above upto semi | Черновая Rough | 6.0 | 6.5 | 6.9 | 7.5 | 8.5 | 9.5 | 10.5 | 12.5 | 14.5 |
| | | | | Ca. 7.00 до 8.00 | Получистовая finished | 7.8 | 8.3 | 8.8 | 9.3 | 10.5 | 11.5 | 12.5 | 14.5 | 17.0 |
| | | | | | Чистовая finished | 9.5 | 9.8 | 10.5 | 11.0 | 12.0 | 13.0 | 14.0 | 16.5 | 18.5 |
| | | | | | Тонкая Thin | 10.0 | 10.5 | 11.0 | 11.5 | 13.0 | 14.0 | 15.0 | 17.5 | 19.5 |
| | | | | from above upto semi | Черновая Rough | 8.5 | 8.9 | 7.5 | 8.0 | 9.0 | 9.8 | 11.0 | 13.0 | 15.0 |
| | | | | Ca. 8.00 до 9.00 | Получистовая finished | 10.5 | 9.0 | 9.8 | 10.0 | 11.0 | 12.0 | 13.5 | 15.5 | 17.5 |
| | | | | | Чистовая finished | 10.5 | 10.5 | 11.5 | 12.0 | 13.0 | 14.0 | 15.0 | 17.5 | 19.5 |
| | | | | | Тонкая Thin | 11.0 | 11.5 | 12.5 | 13.0 | 14.0 | 15.0 | 16.0 | 18.5 | 20.5 |
| | | | | from above upto semi | Черновая Rough | 7.1 | 7.5 | 8.0 | 8.5 | 9.5 | 10.5 | 11.5 | 13.5 | 15.5 |
| | | | | Ca. 9.00 до 10.00 | Получистовая finished | 9.5 | 9.8 | 10.5 | 11.0 | 12.0 | 13.0 | 14.0 | 16.5 | 18.5 |
| | | | | | Чистовая finished | 11.0 | 11.5 | 12.0 | 12.5 | 14.0 | 15.0 | 16.0 | 18.0 | 20.5 |
| | | | | | Тонкая Thin | 12.5 | 12.5 | 13.5 | 14.0 | 15.0 | 16.0 | 17.0 | 19.5 | 22.0 |
| | | | | from above upto semi | Черновая Rough | 7.5 | 8.0 | 8.5 | 9.0 | 9.8 | 11.0 | 12.0 | 14.0 | 16.0 |
| | | | | Ca. 10.00 до 11.00 | Получистовая finished | 9.8 | 10.0 | 10.5 | 11.0 | 12.5 | 13.5 | 14.5 | 16.5 | 18.5 |
| | | | | | Чистовая finished | 11.5 | 12.0 | 12.5 | 13.0 | 14.0 | 15.0 | 16.0 | 18.5 | 20.5 |
| | | | | | Тонкая Thin | 12.5 | 13.0 | 13.5 | 14.0 | 15.5 | 16.5 | 17.5 | 19.5 | 22.0 |

COST 26645-85

Contd... table 6

| No. | SHEET No. OF DOCUMENT | DRAWING | DATE | Common tolerance for the element of surface, mm | Type of finish machining | Common allowance for the side, mm, max, for the series of allowance for the casting. | | | | | | | | | | | |
|---------------|---------------------------------|-----------------------|------|---|---------------------------------|--|-----|-----|-----|------|------|------|------|------|------|------|------|
| | | | | | | 1 | 2 | 3 | 4 | 5 | 6 | 7 | 8 | 9 | | | |
| 4081 26645-85 | | | | from above | upto semi Св. 11 до 12,00 | Черновая Rough | --- | --- | --- | --- | 7,1 | 7,3 | 7,5 | 7,5 | 7,8 | | |
| | | | | | | Получистовая finished | --- | --- | --- | --- | 9,3 | 9,5 | 9,6 | 9,8 | 10,0 | | |
| | | | | | | Чистовая finished | --- | --- | --- | --- | 11,0 | 11,0 | 11,5 | 11,5 | 12,0 | | |
| | | | | from above | upto semi Св. 12,00 до 14,00 | Черновая Rough | --- | --- | --- | --- | --- | --- | --- | 8,5 | 8,5 | 8,8 | 9,0 |
| | | | | | | Получистовая finished | --- | --- | --- | --- | --- | --- | --- | 11,0 | 11,5 | 11,5 | 12,0 |
| | | | | | | Чистовая finished | --- | --- | --- | --- | --- | --- | --- | 12,5 | 13,0 | 13,0 | 13,5 |
| | | | | from above | upto semi Св. 14,00 до 16,00 | Черновая Rough | --- | --- | --- | --- | --- | --- | --- | 9,5 | 9,5 | 9,8 | 10,0 |
| | | | | | | Получистовая finished | --- | --- | --- | --- | --- | --- | --- | 12,0 | 12,5 | 12,5 | 13,0 |
| | | | | | | Чистовая finished | --- | --- | --- | --- | --- | --- | --- | 15,0 | 15,0 | 15,5 | 15,5 |
| | | | | from above | upto semi Св. 16,00 до 18,00 | Черновая Rough | --- | --- | --- | --- | --- | --- | --- | 10,5 | 11,0 | 11,0 | 11,0 |
| | | | | | | Получистовая finished | --- | --- | --- | --- | --- | --- | --- | 13,5 | 14,0 | 14,0 | 14,0 |
| | | | | | | Чистовая finished | --- | --- | --- | --- | --- | --- | --- | 15,5 | 16,0 | 16,0 | 16,0 |
| from above | upto semi Св. 18,00 до 20,00 | Черновая Rough | --- | --- | --- | --- | --- | --- | --- | 11,5 | 11,5 | 12,0 | 12,0 | | | | |
| | | Получистовая finished | --- | --- | --- | --- | --- | --- | --- | 14,5 | 15,0 | 15,0 | 15,0 | | | | |
| | | Чистовая finished | --- | --- | --- | --- | --- | --- | --- | 17,5 | 17,5 | 18,0 | 18,0 | | | | |
| from above | upto semi Св. 20,00 до 22,00 | Черновая Rough | --- | --- | --- | --- | --- | --- | --- | 12,0 | 12,0 | 12,5 | 12,5 | | | | |
| | | Получистовая finished | --- | --- | --- | --- | --- | --- | --- | 15,0 | 15,5 | 15,5 | 15,5 | | | | |
| | | Чистовая finished | --- | --- | --- | --- | --- | --- | --- | 18,0 | 18,0 | 18,5 | 18,5 | | | | |
| from above | upto semi Св. 22,00 до 24,00 | Черновая Rough | --- | --- | --- | --- | --- | --- | --- | 11,5 | 11,5 | 12,0 | 12,0 | | | | |
| | | Получистовая finished | --- | --- | --- | --- | --- | --- | --- | 14,5 | 15,0 | 15,0 | 15,0 | | | | |
| | | Чистовая finished | --- | --- | --- | --- | --- | --- | --- | 17,5 | 17,5 | 18,0 | 18,0 | | | | |
| from above | upto semi Св. 22,00 до 24,00 | Черновая Rough | --- | --- | --- | --- | --- | --- | --- | 14,0 | 14,0 | 14,5 | 14,5 | | | | |
| | | Получистовая finished | --- | --- | --- | --- | --- | --- | --- | 17,0 | 17,0 | 17,5 | 17,5 | | | | |
| | | Чистовая finished | --- | --- | --- | --- | --- | --- | --- | 19,5 | 19,5 | 20,0 | 20,0 | | | | |
| from above | upto semi Св. 22,00 до 24,00 | Черновая Rough | --- | --- | --- | --- | --- | --- | --- | 13,0 | 13,0 | 13,5 | 13,5 | | | | |
| | | Получистовая finished | --- | --- | --- | --- | --- | --- | --- | 16,5 | 16,5 | 16,5 | 16,5 | | | | |
| | | Чистовая finished | --- | --- | --- | --- | --- | --- | --- | 19,5 | 19,5 | 20,0 | 20,0 | | | | |
| from above | upto semi Св. 22,00 до 24,00 | Черновая Rough | --- | --- | --- | --- | --- | --- | --- | 14,0 | 14,0 | 14,5 | 14,5 | | | | |
| | | Получистовая finished | --- | --- | --- | --- | --- | --- | --- | 17,5 | 17,5 | 18,0 | 18,0 | | | | |
| | | Чистовая finished | --- | --- | --- | --- | --- | --- | --- | 21,0 | 21,0 | 21,0 | 21,0 | | | | |
| from above | upto semi Св. 22,00 до 24,00 | Черновая Rough | --- | --- | --- | --- | --- | --- | --- | 14,0 | 14,0 | 14,5 | 14,5 | | | | |
| | | Получистовая finished | --- | --- | --- | --- | --- | --- | --- | 17,5 | 17,5 | 18,0 | 18,0 | | | | |
| | | Чистовая finished | --- | --- | --- | --- | --- | --- | --- | 23,5 | 23,5 | 24,0 | 24,0 | | | | |

Contd... table - 6

| AMT SHEETS No. OF DOCUMENT SIGNATURE DATE | Common toler - ance for the element of surface, mm | Type of finish machining | Common allowance for the side, mm, max, for the series of allowance for the casting. | | | | | | | | | |
|---|---|-----------------------------|---|------------------------------|------------------------------|------------------------------|------------------------------|------------------------------|------------------------------|------------------------------|------------------------------|------------------------------|
| | | | 10 | 11 | 12 | 13 | 14 | 15 | 16 | 17 | 18 | |
| 9081 26645- 85 | from above | upto semi | Черновая Rough Получистовая finished Чистовая finished Тонкая Thin | 8,3 10,5 12,5 14,0 | 9,5 11,0 12,5 14,5 | 9,0 11,5 13,5 15,0 | 9,5 12,0 14,0 15,5 | 10,5 13,0 15,0 16,5 | 11,5 14,0 16,0 17,5 | 12,5 15,0 17,0 19,0 | 14,5 17,5 19,5 21,0 | 16,5 19,5 21,0 23,5 |
| | from above | upto semi | Черновая Rough Получистовая finished Чистовая finished Тонкая Thin | 9,5 12,0 14,0 15,5 | 9,8 12,5 14,5 16,0 | 10,5 13,0 15,0 16,5 | 11,0 13,5 15,5 17,0 | 12,0 14,0 16,0 18,5 | 13,0 15,0 17,5 19,5 | 14,0 16,5 18,5 20,5 | 16,0 18,5 21,0 23,0 | 18,0 21,0 23,0 25,0 |
| | from above | upto semi | Черновая Rough Получистовая finished Чистовая finished Тонкая Thin | 10,5 13,5 16,0 18,0 | 11,0 13,5 16,5 18,0 | 11,5 14,5 17,0 19,0 | 12,0 15,0 17,5 19,5 | 13,0 16,0 19,0 20,5 | 14,0 17,0 20,0 22,0 | 15,0 18,0 21,0 22,5 | 17,0 20,0 23,0 25,0 | 19,0 22,0 25,0 27,0 |
| | from above | upto semi | Черновая Rough Получистовая finished Чистовая finished Тонкая Thin | 11,5 14,5 16,5 19,0 | 12,0 15,0 17,0 19,5 | 12,5 15,5 17,5 20,0 | 13,0 16,0 18,0 20,5 | 14,0 17,0 19,5 22,0 | 15,0 18,0 21,0 22,5 | 16,0 19,0 21,5 24,0 | 18,0 21,0 23,5 26,0 | 20,0 23,0 26,0 28,0 |
| | from above | upto semi | Черновая Rough Получистовая finished Чистовая finished Тонкая Thin | 12,5 15,5 18,5 20,5 | 12,5 16,0 19,5 21,0 | 13,0 16,5 20,0 22,0 | 13,5 17,0 20,5 23,5 | 14,5 18,0 21,0 23,5 | 15,5 19,0 22,0 24,0 | 16,5 20,0 23,0 25,0 | 18,5 22,5 25,0 28,0 | 20,5 24,0 28,0 30,0 |
| | from above | upto semi | Черновая Rough Получистовая finished Чистовая finished Тонкая Thin | 13,5 17,0 20,0 22,0 | 14,0 17,5 21,0 22,5 | 14,5 18,0 21,5 23,5 | 15,0 18,5 22,0 24,0 | 16,0 19,5 22,5 25,0 | 17,0 20,5 24,0 26,0 | 18,0 22,0 25,0 27,0 | 20,0 24,0 27,0 29,0 | 22,0 26,0 29,0 31,5 |
| | from above | upto semi | Черновая Rough Получистовая finished Чистовая finished Тонкая Thin | 15,0 18,0 22,0 24,0 | 15,0 18,5 22,0 25,0 | 15,5 19,0 22,5 25,0 | 16,0 19,5 23,0 26,0 | 17,0 21,0 24,0 27,0 | 18,0 22,0 25,0 28,0 | 19,0 23,0 26,5 29,0 | 21,0 25,0 29,0 31,5 | 23,0 27,0 30,5 33,5 |

Contd. Table-6

| AN SHEET No. OF ORDER | DATE | SIGNATURE | Common toler- ance for the element of surface, mm. | Type of finish machining | Common allowance for the side, mm, max, for the series of allowance for the casting. | | | | | | | | | | | | | | |
|--------------------------------|------|-----------|---|---------------------------------|---|-----|-----|-----|-----|-----|-----|-----|-----|-----|-----|-----|-----|-----|------------------------------|
| | | | | | 1 | 2 | 3 | 4 | 5 | 6 | 7 | 8 | 9 | | | | | | |
| GOST 26645-85 | | | from above | upto semi Св. 24,00 до 28,00 | Черновая Rough Получистовая finished Чистовая finished Тонкая Thin | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | 16,5 20,5 23,5 26,0 |
| | | | from above | upto semi Св. 28,00 до 32,00 | Черновая Rough Получистовая finished Чистовая finished Тонкая Thin | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | 19,0 23,5 26,0 30,0 |
| | | | from above | upto semi Св. 32,00 до 36,00 | Черновая Rough Получистовая finished Чистовая finished Тонкая Thin | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
| | | | from above | upto semi Св. 36,00 до 40,00 | Черновая Rough Получистовая finished Чистовая finished Тонкая Thin | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
| | | | from above | upto semi Св. 40,00 до 44,00 | Черновая Rough Получистовая finished Чистовая finished Тонкая Thin | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
| | | | from above | upto semi Св. 44,00 до 50,00 | Черновая Rough Получистовая finished Чистовая finished Тонкая Thin | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
| | | | from above | upto semi Св. 50,00 до 56,00 | Черновая Rough Получистовая finished Чистовая finished Тонкая Thin | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |

Contd. table 6

| A/P | SHEET | No. of positions | EXPLANATION | DATE | Common tolerance for the element of surface, mm | Type of finish machining | Common allowance for the side, mm, max, for the series of allowance for the casting. | | | | | | | | | | | | |
|-----|-------|------------------|-------------|------|---|---------------------------------|--|---------------------------------------|---|---|---|---|---|---|---|---|---|---|---|
| | | | | | | | 1 | 2 | 3 | 4 | 5 | 6 | 7 | 8 | 9 | | | | |
| | | | | | from above | upto semi Св. 56,00 до 64,00 | Черновая Получистовая Чистовая Тонкая | Rough finished finished Thin | — | — | — | — | — | — | — | — | — | — | — |
| | | | | | from above | upto semi Св. 64,00 до 70,00 | Черновая Получистовая Чистовая Тонкая | Rough finished finished Thin | — | — | — | — | — | — | — | — | — | — | — |
| | | | | | from above | upto semi Св. 70,00 до 80,00 | Черновая Получистовая Чистовая Тонкая | Rough finished finished Thin | — | — | — | — | — | — | — | — | — | — | — |

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Contd. Table 6

Common allowance for the side, mm, max, for the series of allowance for the casting.

Type of finish machining

Common tolerance for the element of surface, mm

| | 10 | 11 | 12 | 13 | 14 | 15 | 16 | 17 | 18 |
|------------|----|----|------|------|------|------|------|------|------|
| from above | — | — | 39.0 | 39.0 | 40.0 | 41.0 | 42.5 | 44.0 | 46.0 |
| | — | — | 46.0 | 46.0 | 47.5 | 49.0 | 49.0 | 51.5 | 53.0 |
| | — | — | 50.0 | 50.0 | 51.5 | 53.0 | 53.0 | 56.0 | 58.0 |
| | — | — | 53.0 | 53.0 | 54.5 | 56.0 | 56.0 | 58.0 | 60.0 |
| from above | — | — | — | 42.5 | 44.0 | 45.0 | 45.0 | 47.5 | 49.0 |
| | — | — | — | 50.0 | 51.5 | 53.0 | 53.0 | 56.0 | 58.0 |
| | — | — | — | 56.0 | 58.0 | 58.0 | 58.0 | 61.5 | 63.0 |
| | — | — | — | 68.0 | 60.0 | 61.5 | 61.5 | 65.0 | 67.0 |
| from above | — | — | — | 47.5 | 47.5 | 49.0 | 50.0 | 51.5 | 54.5 |
| | — | — | — | 56.0 | 56.0 | 58.0 | 58.0 | 61.5 | 63.0 |
| | — | — | — | 61.5 | 63.0 | 63.0 | 65.0 | 67.0 | 69.0 |
| | — | — | — | 65.0 | 67.0 | 67.0 | 69.0 | 71.0 | 73.0 |

Черновая Rough
 Полуочищенная finished
 Чистовая finished
 Тонкая Thin

Черновая Rough
 Полуочищенная finished
 Чистовая finished
 Тонкая Thin

Черновая Rough
 Полуочищенная finished
 Чистовая finished
 Тонкая Thin

upto semi
 Cs. 56.00 до 64.00

upto semi
 Cs. 64.00 до 70.00

upto semi
 Cs. 70.00 до 80.00

from above

from above

from above

Note: -
 NOTE: For each gap of tolerance, total values of total allowance are given in different lines for all steps of machining; rough; rough and semi-finished; rough, semifinished and finished; rough, semi-finished, finished and thin.

| | | | | |
|-----|-------|-----------------|-----------|------|
| APP | SHEET | No. OF DOCUMENT | SIGNATURE | DATE |
|-----|-------|-----------------|-----------|------|

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Table 7

| Tolerance of dimension for casting. | Relation between the tolerances of dimension of component and casting from the datum surface of machining upto the surface being machined. | Type of finish machining |
|-------------------------------------|--|--------------------------|
| Upto 0.5 | Above 0.4 | Rough |
| | " 0.15 upto 0.4 | Semi-finished |
| | " 0.10 " 0.15 " " 0.10 | finished Thin |
| From above 0.5 upto 1.0 | Above 0.3 | Rough |
| | " 0.1 upto 0.3 | Semi-finished |
| | " 0.05 " 0.1 " " 0.05 | finished Thin |
| From above 1.0 upto 2.0 | Above 0.2 | Rough |
| | " 0.1 upto 0.2 | Semi-finished |
| | " 0.05 " 0.1 " " 0.05 | finished Thin |
| From above 2.0 upto 5.0 | Above 0.15 | Rough |
| | " 0.05 upto 0.15 | Semi-finished |
| | " 0.02 " 0.05 " " 0.02 | finished Thin |
| From above 5.0 | Above 0.10 | Rough |
| | " 0.05 upto 0.10 | Semi-finished |
| | " 0.02 " 0.05 " " 0.02 | finished Thin |

4.10. In the branch standard-technical document for separate groups of castings, simplified methods for designating the allowances for machining should be specified, provided their values of allowances, specified by the present standard, do not exceed the corresponding values of allowances specified by the present standard.

Table 8

Tolerance of dimension for casting. Relation between the tolerances of dimension of component and casting from the datum surface of machining upto the surface being machined. Type of finish machining

| | | | |
|-------------------------|-----------------------------|---------|------------------|
| upto 0.5 | Above 0.4 | | Rough |
| | " 0.10 upto 0.4 | | Semi-finished |
| | " 0.02 " 0.10 | " 0.02 | finished Thin |
| From above 0.5 upto 1.0 | Above 0.3 | | Rough |
| | " 0.10 upto 0.3 | | Semi-finished |
| | " 0.02 " 0.10 | " 0.02 | finished Thin |
| From above 1.0 upto 2.0 | Above 0.20 | | Rough |
| | " 0.05 upto 0.20 | | Semi-finished |
| | " 0.01 " 0.05 | " 0.01 | finished Thin |
| From above 2.0 upto 5.0 | Above 0.10 | | Rough |
| | " 0.02 upto 0.10 | | Semi-finished |
| | " 0.005 " 0.02 | " 0.005 | finished Thin |
| From above 5.0 | Above 0.05 | | Rough |
| | " 0.01 upto 0.05 | | Semi-finished |
| | " 0.002 " 0.01 | " 0.002 | finished Thin |

Notes:

1. For the unspecified tolerances of shape and location of the being machined surface of casting, their total value is to be taken as equal to 25% of the tolerance of the dimension from the datum surface upto the surface of casting being machined.
2. For the unspecified tolerances of shape and location of the machined surface of component their total value is to be taken as equal to 50% of the tolerance of the dimension from the datum surface upto the machined surface of the component.

Classes of dimensional accuracy of castings

Table 9

| Technological process of casting. | Maximum overall dimension of casting, mm. | Type of alloy | | | |
|---|---|--|--|---|----------------------------------|
| | | Non-ferrous, light, not being heat-treated alloys. | Not-being heat-treated, ferrous and non-ferrous high melting alloys, being heat treated non-ferrous, light alloys. | Being-heat-treated-ferrous and non-ferrous high melting alloys. | Being heat-treated steel alloys. |
| (1) | (2) | (3) | (4) | (5) | (6) |
| Pressure-die castings in metallic moulds and as per burnt-pattern casting using low heat dispersing, heat resisting materials (fused quartz, corundum and so on). | upto 100 | 3T-6 | 3-7T | 4-7 | 5T-8 |
| | from above 100 " | 250 3-7T | 4-7 | 5T-8 | 5-9T |
| | " 250 " | 630 4-7 | 5T-8 | 5-9T | 6-9 |
| Burnt-pattern casting using heat-resistant quartz materials. | upto 100 | 3-7 | 4-8 | 5T-9T | 5-9 |
| | from above 100 " | 250 4-8 | 5T-9T | 5-9 | 6-10 |
| | " 250 " | 630 5T-9T | 5-9 | 6-10 | 7T-11T |
| Precision-investment casting using heat resisting quartz materials. | upto 100 | 4-8 5T-9T | 5T-9T | 5-9 6-10 | 6-10 7T-11T |
| | from above 100 " | 250 5-9 | 5-9 | 6-10 | 7T-11T |
| | " 250 " | 630 6-10 | 7T-11T | 7-11 | 8-12 |
| | " 630 " | 1600 7T-11T | 7-11 | 8-12 | 9T-13T |
| | " 1600 " | 4000 7-11 | 8-12 | 9T-13T | 9-13 |

Cont. Table 9

| (1) | (2) | (3) | (4) | (5) | (6) |
|--|----------------------|--------|--------|--------|--------|
| Low-pressure-die-casting and without sand cores in the metal mould. | upto 100 | 5T-9T | 5-9 | 6-10 | 7T-11T |
| | from above 100 " 250 | 5-9 | 6-10 | 7T-11T | 7-11 |
| | " 250 " 630 | 6-10 | 7T-11T | 7-11 | 8-12 |
| | " 630 " 1600 | 7T-11T | 7-11 | 8-12 | 9T-13T |
| | " 1600 " 4000 | 7-11 | 8-12 | 9T-13T | 9-13 |
| Casting in low silica green sand moulds made from less damp (upto 2.8%) and high-strength compounds (more than 160kPa or 1.6 kg/cm ²), having high or uniform consolidation upto the hardness of not less than 90 units. | upto 100 | 5-10 | 6-11T | 7T-11 | 7-12 |
| | from above 100 " 250 | 6-11T | 7T-11 | 7-12 | 8-13T |
| | " 250 " 630 | 7T-11 | 7-12 | 8-13T | 9T-13 |
| | " 630 " 1600 | 7-12 | 8-13T | 9T-13 | 9-13 |
| | " 1600 " 4000 | 8-13T | 9T-13 | 9-13 | 10-14 |
| Gasfied pattern casting in sand moulds. | upto 100 | 5-10 | 6-11T | 7T-11 | 7-12 |
| | from above 100 " 250 | 6-11T | 7T-11 | 7-12 | 8-13T |
| | " 250 " 630 | 7T-11 | 7-12 | 8-13T | 9T-13 |
| | " 630 " 1500 | 7-12 | 8-13T | 9T-13 | 9-13 |
| | " 1600 " 4000 | 8-13T | 9T-13 | 9-13 | 10-14 |
| Casting in moulds, solidified in contact with the cold equipment. | upto 100 | 5-10 | 6-11T | 7T-11 | 7-12 |
| | from above 100 " 250 | 6-11T | 7T-11 | 7-12 | 8-13T |
| | " 250 " 630 | 7T-11 | 7-12 | 8-13T | 9T-13 |
| | " 630 " 1500 | 7-12 | 8-13T | 9T-13 | 9-13 |
| | " 1600 " 4000 | 8-13T | 9T-13 | 9-13 | 10-14 |
| Low-pressure-die-casting and in metal-mould with sand cores. | upto 100 | 5-10 | 6-11T | 7T-11 | 7-12 |
| | from above 100 " 250 | 6-11T | 7T-11 | 7-12 | 8-13T |
| | " 250 " 630 | 7T-11 | 7-12 | 8-13T | 9T-13 |
| | " 630 " 1500 | 7-12 | 8-13T | 9T-13 | 9-13 |
| | " 1600 " 4000 | 8-13T | 9T-13 | 9-13 | 10-14 |
| Casting in facing metal mould. | upto 100 | 5-10 | 6-11T | 7T-11 | 7-12 |
| | from above 100 " 250 | 6-11T | 7T-11 | 7-12 | 8-13T |
| | " 250 " 630 | 7T-11 | 7-12 | 8-13T | 9T-13 |
| | " 630 " 1500 | 7-12 | 8-13T | 9T-13 | 9-13 |
| | " 1600 " 4000 | 8-13T | 9T-13 | 9-13 | 10-14 |

| (1) | (2) | (3) | (4) | (5) | (6) |
|---|----------------|---------|-------|--------|--------|
| Casting in low silica green sand mould from compounds with dampness from 2.8 to 3.5% and strength from 120 to 160 kPa (from 1.2 to 1.6 kg/cm ²), with average level of consolidation upto the hardness of not less than 80 units. | upto 100 | 6-11T | 7T-11 | 7-12 | 8-13T |
| | from above 100 | " 250 | 7T-11 | 7-12 | 8-13T |
| | " 250 | " 630 | 7-12 | 8-13T | 9T-13 |
| | " 630 | " 1600 | 8-13T | 9T-13 | 9-13 |
| Centrifugal casting (inner surfaces) | " 1600 | " 4000 | 9T-13 | 9-13 | 10-14 |
| | " 4000 | " 10000 | 9-13 | 10-14 | 11T-14 |
| Casting in mould solidified in contact with the hot equipment. | upto 100 | 7T-11 | 7-12 | 8-13T | 9T-13 |
| | from above 100 | " 250 | 7-12 | 8-13T | 9T-13 |
| Casting in vacuum - film sand mould. | " 250 | " 630 | 8-13T | 9T-13 | 9-13 |
| | " 630 | " 1600 | 9T-13 | 9-13 | 10-14 |
| Casting in low silica green sand mould from compounds having dampness from 3.5 to 4.5% and strength from 60 to 120 kPa from 0.6 to 1.2 kg/cm ²) with the level of consolidation upto the hardness not less than 70 units. | upto 100 | 7T-11 | 7-12 | 8-13T | 9T-13 |
| | from above 100 | " 250 | 7-12 | 8-13T | 9T-13 |
| | " 250 | " 630 | 8-13T | 9T-13 | 9-13 |
| | " 630 | " 1600 | 9T-13 | 9-13 | 10-14 |
| Casting in shell moulds from thermoeactive compounds. | " 1600 | " 4000 | 9-13 | 10-14 | 11T-14 |
| | " 4000 | " 10000 | 10-14 | 11T-14 | 11-15 |
| Casting in moulds, solidified without contact with the equipment without heat drying. | upto 100 | 7T-11 | 7-12 | 8-13T | 9T-13 |
| | from above 100 | " 250 | 7-12 | 8-13T | 9T-13 |
| Casting in moulds from fluid type self-hardening compounds. | " 250 | " 630 | 8-13T | 9T-13 | 9-13 |
| | " 630 | " 1600 | 9T-13 | 9-13 | 10-14 |
| Casting in low-silica green sand, <i>dried and dry moulds</i> . | " 1600 | " 4000 | 9-13 | 10-14 | 11T-14 |
| | " 4000 | " 10000 | 10-14 | 11T-14 | 11-15 |

Cont. Table 9

| | 2 | 3 | 4 | 5 | 6 |
|--|----------------------|--------|--------|--------|--------|
| Casting in low-silica green sand moulds from highly damp (more than 4.5%) less strong (upto 60 kPa or 0.6 kg/cm ²) compounds with low level of consolidation upto hardness below 70 units. | upto 100 | 7-12 | 8-13T | 9T-13 | 9-13 |
| | from above 100 " 250 | 8-13T | 9T-13 | 9-13 | 10-14 |
| | " 250 " 630 | 9T-13 | 9-13 | 10-14 | 11T-14 |
| | " 630 " 1600 | 9-13 | 10-14 | 11T-14 | 11-15 |
| | " 1600 " 4000 | 10-14 | 11T-14 | 11-15 | 12-15 |
| | " 4000 " 10000 | 11T-14 | 11-15 | 12-15 | 13T-16 |
| " 10000 | 11-15 | 12-15 | 13T-16 | 13-16 | |

Notes:

1. Ranges of classes of dimensional accuracy of castings, ensured by different technological processes of casting are given in the Table. Their lower values are related to the simple castings and conditions of mass-automatized production, the higher ones - to the complex castings of individual and small - scale production - the mean ones - to the castings of mean complexity and conditions of mechanized series production.
2. In Table 9-14, alloys with temperature of fusing below 700°C (973K) are referred for non ferrous low-melting alloys, for non-ferrous high-melting alloys - alloys with fusing temperature above 700°C (973K) are referred.
3. In Table 9-14, alloys with a density upto 3.0 g/cm³ are referred for light alloys, and alloys with density above 3.0 g/cm³ are referred for hard alloys.

Accuracy degree for casting surfaces

Table 11

| Technological process of casting. | Maximum overall dimension of casting, mm. | Type of alloy | | | |
|---|---|--------------------|--|---|---------------------------------|
| | | Non-ferrous, light | Not-being chined, ferrous and ferrous alloys | Being heat-treated and non-ferrous alloys | Being heat-treated steel alloys |
| (1) | (2) | (3) | (4) | (5) | (6) |
| Pressure die-casting into metallic moulds. | upto 100 | 2-6 | 3-7 | 4-8 | 5-9 |
| | From above 100 " 250 | 3-7 | 4-8 | 5-9 | 6-10 |
| Casting into ceramic mould, burnt-pattern and precision investment casting. | upto 100 | 3-8 | 4-9 | 5-10 | 6-11 |
| | From above 100 " 250 | 4-9 | 5-10 | 6-11 | 7-12 |
| Low-pressure-die casting and without sand cores into the metal mould, centrifugal casting into metallic moulds. | upto 100 | 4-9 | 5-10 | 7-11 | 7-12 |
| | From above 100 " 250 | 5-10 | 6-11 | 7-12 | 8-13 |
| | " 250 " 630 | 4-8 | 5-9 | 6-10 | 7-11 |
| | " 250 " 630 | 5-10 | 6-11 | 7-12 | 8-13 |
| | " 250 " 630 | 6-11 | 7-12 | 8-13 | 9-14 |

| (1) | (2) | (3) | (4) | (5) | (6) | | |
|--|------------|----------|------|-------|-------|-------|-------|
| Casting in shell moulds made from thermoreactive compounds. | | upto 100 | 6-12 | 7-13 | 8-14 | 9-15 | |
| | From above | 100 " | 250 | 7-13 | 8-14 | 9-15 | 10-16 |
| Casting in facing metal mould, casting in vacuum-film-sand-mould. | " | 250 " | 630 | 8-14 | 9-15 | 10-16 | 11-17 |
| | | | | | | | |
| Casting as per being-gasified patterns in sand moulds. | | upto 100 | 7-14 | 8-15 | 9-16 | 10-17 | |
| | From above | 100 " | 250 | 8-15 | 9-16 | 10-17 | 11-18 |
| Casting in low-silica-green sand moulds from less damp (upto 2.8%) highly strong (more than 160kPa or 1.6 kg/cm ²) compounds with high and uniform consolidation upto a hardness not less than 90 units. | " | 250 " | 630 | 9-16 | 10-17 | 11-18 | 12-19 |
| | " | 630 " | 1600 | 10-17 | 11-18 | 12-19 | 13-19 |
| Casting in solidified, dry or dried moulds, painted with coatings on water base and applied by spraying or by dipping. | " | 1600 " | 4000 | 11-18 | 12-19 | 13-19 | 14-20 |
| | | | | | | | |
| Casting in metal mould with sand cores. | | | | | | | |

| (1) | (2) | (3) | (4) | (5) | (6) | | |
|---|---|------------|-----------|-------|-------|-------|-------|
| Casting in low-silica green sand moulds from compounds with dampness ranging from 2.8 to 3.5% and strength from 120 to 160 kPa (from 1.2 to 1.6 kg/cm ²) with mean level of consolidation upto the hardness not less than 80 units. | | upto 100 | 8-15 | 9-16 | 10-17 | 11-18 | |
| | From above | 100 " 250 | 9-16 | 10-17 | 11-18 | 12-19 | |
| | " | 250 " 630 | 10-17 | 11-18 | 12-19 | 13-19 | |
| | " | 630 "1600 | 11-18 | 12-19 | 13-19 | 14-20 | |
| | " | 1600" 4000 | 12-19 | 13-19 | 14-20 | 15-20 | |
| Casting in solidified dry or dried sand moulds, painted with coatings on water base, applied with a brush or with self-drying coatings, applied by spraying or by dipping. | " | 4000"10000 | 13-19 | 14-20 | 15-20 | 16-21 | |
| | Casting in low-silica, green-sand-moulds made from compounds with a dampness ranging from 3.5 to 4.5% and strength from 60 to 120 kPa (from 0.6 to 1.2 kg/cm ²) with the level of consolidation upto the hardness not less than 70 units. | | upto 100 | 9-16 | 10-17 | 11-18 | 12-19 |
| | | From above | 100 " 250 | 10-17 | 10-17 | 11-18 | 12-19 |
| | | " | 250 " 630 | 11-18 | 12-19 | 13-19 | 14-20 |
| | | " | 630 "1600 | 12-19 | 13-19 | 14-20 | 15-20 |
| " | | 1600" 4000 | 13-19 | 14-20 | 15-20 | 16-21 | |
| Casting in solidified dry or dried sand moulds, painted with self-drying or self-solidifying coatings, applied with a brush. | " | 4000"10000 | 14-20 | 15-20 | 16-21 | 17-21 | |
| | From | Upto 100 | 9-16 | 10-17 | 11-18 | 12-19 | |
| | above | 100 " 250 | 10-17 | 10-17 | 11-18 | 12-19 | |
| | " | 250 " 630 | 11-18 | 12-19 | 13-19 | 14-20 | |
| | " | 630 "1600 | 12-19 | 13-19 | 14-20 | 15-20 | |
| " | 1600 "4000 | 13-19 | 14-20 | 15-20 | 16-21 | | |
| " | 4000"10000 | 14-20 | 15-20 | 16-21 | 17-21 | | |

| (1) | (2) | (3) | (4) | (5) | (6) | |
|---|------------------|-------|-------|-------|-------|-------|
| Casting in low-silica green sand moulds made from highly damp (above 4.5%) and less strong (upto 69 kPa or 0.6 kg/cm ²) compounds with low level of consolidation upto the hardness below 70 units. | upto 100 | 10-17 | 11-18 | 12-19 | 13-19 | |
| | from above 100 " | 250 | 11-18 | 12-19 | 13-19 | 14-20 |
| | " 250 " | 630 | 12-19 | 13-19 | 14-20 | 15-20 |
| | " 630 " | 1600 | 13-19 | 14-20 | 15-20 | 16-21 |
| | " 1600 " | 4000 | 14-20 | 15-20 | 16-21 | 17-21 |
| | " 4000 " | 10000 | 15-20 | 16-21 | 17-21 | 18-22 |
| | 10000 | 16-21 | 17-21 | 18-22 | 19-22 | |

Casting in solidified, dry or dried unpainted sand moulds.

Casting in moulds made from fluid self-solidifying compounds.

NOTE: Ranges of degrees of accuracy for the surface of castings, maintained by different technological processes of casting are given in the Table. Lower ones among the values are referred for simple castings and for the conditions of mass-automatized production, the higher values- are applicable for the complex castings of individual and small-scale production, the middle ones - are applicable for castings of mean complexity and for the conditions of mechanized batch production.

Surface finish of castings.

Compliance between the surface finish and accuracy degrees for the surfaces of castings is given in Table 12.

Table 12.

| Surface finish | Value of surface finish for the accuracy degrees of casting surface. | | | | | | | | | | |
|---|--|-----|-----|-----|-----|-----|-----|------|------|------|------|
| | 1 | 2 | 3 | 4 | 5 | 6 | 7 | 8 | 9 | 10 | 11 |
| Arithmetic mean deviation of the profile Ra, micron, not exceeding. | 2.0 | 2.5 | 3.2 | 4.0 | 5.0 | 6.3 | 8.0 | 10.0 | 12.5 | 16.0 | 20.0 |
| Height of unevenness of profile Rz, micron, not exceeding. | - | - | - | - | - | - | - | - | - | - | - |

Contd... Table 12

Value of surface finish for the accuracy degrees of casting surface.

| Surface finish | 12 | 13 | 14 | 15 | 16 | 17 | 18 | 19 | 20 | 21 | 22 |
|---|------|---------------------------------|------|------|------|------|-------|----|----|----|----|
| Arithmetic mean deviation of the profile Ra, micron, not exceeding. | 25.0 | 25.0 ^{32.0} | 40.0 | 50.0 | 63.0 | 80.0 | 109.0 | - | - | - | - |

Height of unevenness of profile Rz, micron, not exceeding.

| | | | | | | | | | | | |
|--|---|---|---|---|---|---|---|-----|-----|-----|------|
| Height of unevenness of profile Rz, micron, not exceeding. | - | - | - | - | - | - | - | 500 | 630 | 800 | 1000 |
|--|---|---|---|---|---|---|---|-----|-----|-----|------|

| | | | |
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Special Appendix 5
Accuracy class for the mass of castings
Table 13

| Alt | SHEET | No. OF DOCUMENT | SIGNATURE | DATE |
|--|-------|-----------------|-----------|------|
| <p style="text-align: center;">Type of alloy</p> <p>Technological process of casting. Nominal mass of casting. Accuracy class for the mass of casting</p> | | | | |
| <p>(1) (2) (3) (4) (5) (6)</p> | | | | |
| <p>Pressure-die casting in metallic moulds and as per burnt-pattern casting using low-heat dispersing, heat resisting materials (fused quartz, corundum and so on)</p> | | | | |
| <p>From above 1.0" upto 1.0" 1 - 7 2 - 8 3T - 9T 3T - 9T 3 - 9 3 - 9 4 - 10 5T - 11T</p> | | | | |
| <p>Being-heat-treated steel alloys. Being-heat-treated ferrous and non-ferrous high melting alloys. Being-heat-treated non-ferrous and light alloys.</p> | | | | |

| APP | SHEET | No. OF DOCUMENT | SIGNATURE | DATE | (1) | (2) | (3) | (4) | (5) | (6) |
|-----|-------|-----------------|-----------|------|---|------------------------------|------------------------------|---|------------------------------|--|
| | | | | | | | | | | |
| | | | | | Burnt-pattern-casting, using heat resistant quartz materials. | upto 1.0 from above 1.0 " | 2 - 9T 3T - 9 | 3T - 9 3 - 10 4 - 11T 5T - 11 | 3 - 10 4 - 11T | 4 - 11T 5T - 11 |
| | | | | | | 10 " 100 | 3 - 10 | 4 - 11T 5T - 11 | | 5 - 12 |
| | | | | | Precision investment casting, using heat resisting quartz materials. | upto 1.0 from above 1.0 " | 3T - 9 3 - 10 4 - 11T | 3 - 10 4 - 11T 5T - 11 | 3 - 10 4 - 11T | 5T - 11 5 - 12 6 - 13T |
| | | | | | | 10 " 100 | | | | |
| | | | | | | 1000 " 10000 | 6 - 13T | 7T - 13 | 7 - 14 | 8 - 15 |
| | | | | | Low-pressure die casting and without sand cores in the metal mould. | upto 1.0 from above 1.0 " | 3 - 10 4 - 11T 5T - 11 | 4 - 11T 5T - 11 | 4 - 11T 5T - 11 | 5 - 12 6 - 13T |
| | | | | | | 10 " 100 | 5 - 12 | 6 - 13T | 6 - 13T | 7T - 13 |
| | | | | | | 100 " 1000 | 5 - 12 | 6 - 13T 7T - 13 | 7 - 14 | 8 - 15 |
| | | | | | | 1000 " 10000 | 6 - 13T | 7T - 13 | 7 - 14 | 8 - 15 |
| | | | | | Casting in low silica green sand moulds made from less damp (upto 2.8%) and highly-strong compounds (more than 160 kPa or 1.6 kg/cm ²), having high or uniform consolidation upto hardness of not less than 90 units. | upto 1.0 from above 1.0 " | 4 - 11 5T - 12 5 - 13T | 5T - 12 5 - 13T 6 - 13 6 - 13 7T - 14 | 5 - 13T 6 - 13 7T - 14 | 6 - 13 7T - 14 8 - 15 9T - 16 |
| | | | | | | 100 " 1000 | 6 - 13 | 7T - 14 | 7 - 15 | 8 - 15 |
| | | | | | | 1000 " 10000 | 7T - 14 | 8 - 15 9T - 16 | 8 - 15 | 9 - 16 |

| APP | SHEET | No. OF DOCUMENT | SIGNATURE | DATE |
|-----|-------|-----------------|-----------|------|
| | | | | |

(1)

(2)

(3)

(4)

(5)

(6)

Gasified pattern casting in sand moulds

| from above | upto | (3) | (4) | (5) | (6) |
|------------|--------------|---------|---------|---------|---------|
| 1.0 " | 1.0 " | 4 - 11 | 5T- 12 | 5 - 13T | 6 - 13 |
| " " | 10 " | 5T - 12 | 5 - 13T | 6 - 13 | 7T - 14 |
| " " | 100 " | 5 - 13T | 6 - 13 | 7T - 14 | 7 - 15 |
| " " | 100 "1000 | 6 - 13 | 7T- 14 | 7 - 15 | 8 - 15 |
| " " | 1000"10000 | 7T - 14 | 7 - 15 | 8 - 15 | 9T - 16 |
| " " | 10000"100000 | 7 - 15 | 8 - 15 | 9T - 16 | 9 - 16 |

Casting into moulds, solidified in contact with the cold equipment.

Low-pressure die casting, and in metal mould with sand cores.

Casting in facing metal mould.

Casting in low silica green sand moulds from compounds having dampness from 2.8 upto 3.5% and strength from 120 to 160 kPa (from 1.2-1.6 kg/cm²) with the mean level of consolidation upto the hardness not less than 80 units.

| from above | upto | (3) | (4) | (5) | (6) |
|------------|----------|---------|---------|---------|---------|
| 1.0 " | 1.0 " | 5T - 12 | 5 - 13T | 6 - 13 | 7T - 14 |
| " " | 10 " | 5 - 13T | 6 - 13 | 7T - 14 | 7 - 15 |
| " " | 100 " | 6 - 13 | 7T- 14 | 7 - 15 | 8 - 15 |
| " " | 1000 " | 7T - 14 | 7 - 15 | 8 - 15 | 9T- 16 |
| " " | 10000 " | 7 - 15 | 8 - 15 | 9T - 16 | 9 - 16 |
| " " | 100000 " | 8 - 15 | 9T- 16 | 9 - 16 | 10 - 16 |

Centrifugal casting (inner surfaces) Casting in moulds, solidified in contact with the hot equipment.

| | | | | |
|-----|-------|-----------------|-----------|------|
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(1)

(2)

(3)

(4)

(5)

(6)

Casting in shell moulds.

Casting in vacuum film sand mould.

Casting in low silica green sand moulds made from compounds with a dampness from 3.5 to 4.5% and strength from with the level of consolidation upto the hardness not less than 70 units.

Casting in shell moulds from thermoreactive compounds.

Casting in moulds, solidified without contact with the equipment without heat drying.

Casting in low-silica green sand dried and dry moulds.

Casting in moulds made from fluid type self hardening compounds.

| | | | | | |
|----------------|----------|-------|-------|-------|--------|
| upto 1.0 | 5-13T | 6-13 | 7T-14 | 7-15 | 7-15 |
| From above 1.0 | " 10 | 6-13 | 7T-14 | 7-15 | 8-15 |
| " 100 | " 100 | 7T-14 | 7-15 | 8-15 | 9T-16 |
| " 1000 | " 1000 | 7-15 | 8-15 | 9T-16 | 9-16 |
| " 10000 | " 10000 | 8-15 | 9T-16 | 9-16 | 10-16 |
| " 100000 | " 100000 | 9T-16 | 9-16 | 10-16 | 11T-16 |

| (1) | (2) | (3) | (4) | (5) | (6) |
|---|----------------|-------|--------|--------|--------|
| Casting in green silica green sand moulds made from highly damp (more than 4.5%) less-strong (upto 60 kpa or 0.6 kg/cm ²) compounds having low level of consolidation upto the hardness not less than 70 units. | Upto 1.0 | 6-13 | 7T-14 | 7-15 | 8-15 |
| | From above 1.0 | 10 | 7T-14 | 7-15 | 8-15 |
| | " " 100 | 7-15 | 8-15 | 9T-16 | 9-16 |
| | " " 1000 | 8-15 | 9T-16 | 9-16 | 10-16 |
| | " " 1000 | 9T-16 | 9-16 | 10-16 | 11T-16 |
| | " 10000 | 9-16 | 10-16 | 11T-16 | 11-16 |
| | " 100000 | 10-16 | 11T-16 | 11-16 | 12-16 |

Note: Ranges of classes of dimensional accuracy of castings, ensured by different technological processes of casting are given in the Table. Their lower values are related to the simple compact castings and to the conditions of mass - automatized production, the higher ones to the complex castings of individual and small-scale production, the mean ones to the castings of mean complexity and to the conditions of mechanized series production.

| | | | | |
|-----|-------|-----------------|-----------|------|
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|-----|-------|-----------------|-----------|------|

Special Appendix 6

Allowance ranges for machining of the castings.

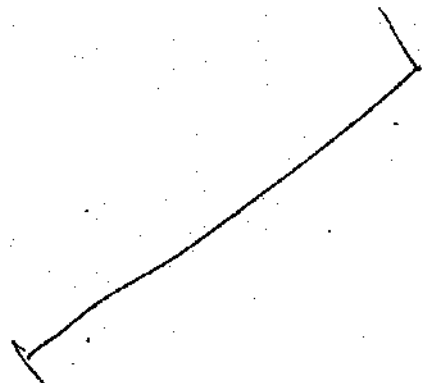
Table 14

| | | | | | | | | | |
|---------------------------------|-----|-----|-----|-----|------|-------|-------|-----|------|
| Accuracy degree for the surface | 1-2 | 3-4 | 5-6 | 7-8 | 9-10 | 11-12 | 13-14 | 15 | 16 |
| Ranges of allowance | 1-2 | 1-3 | 1-4 | 2-5 | 3-6 | 4-7 | 5-8 | 6-9 | 7-10 |

Continued in Table 14

| | | | | | | |
|---------------------------------|----|----|----|----|----|----|
| Accuracy degree for the surface | 17 | 18 | 19 | 20 | 21 | 22 |
|---------------------------------|----|----|----|----|----|----|

| | | | | | | |
|---------------------|------|------|-------|-------|-------|-------|
| Ranges of allowance | 8-11 | 9-12 | 10-13 | 11-17 | 12-15 | 13-16 |
|---------------------|------|------|-------|-------|-------|-------|



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|-----------|-----------------|-----------|------|

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Table 15

Characteristics of metal-working equipment.

Accuracy level of machining at the following accuracy degree of machines.

| | Normal | High |
|---|---------|-----------|
| Automatized equipment, fitted with the devices for stabilizing and monitoring of accuracy of machining. | - | High |
| Automatized equipment (machine sets and machines with CNC, transfer lines from the transfer machine with CNC and flexible production modules and so on) | Medium | Increased |
| Unautomatized equipment. | Reduced | Medium. |

Note:

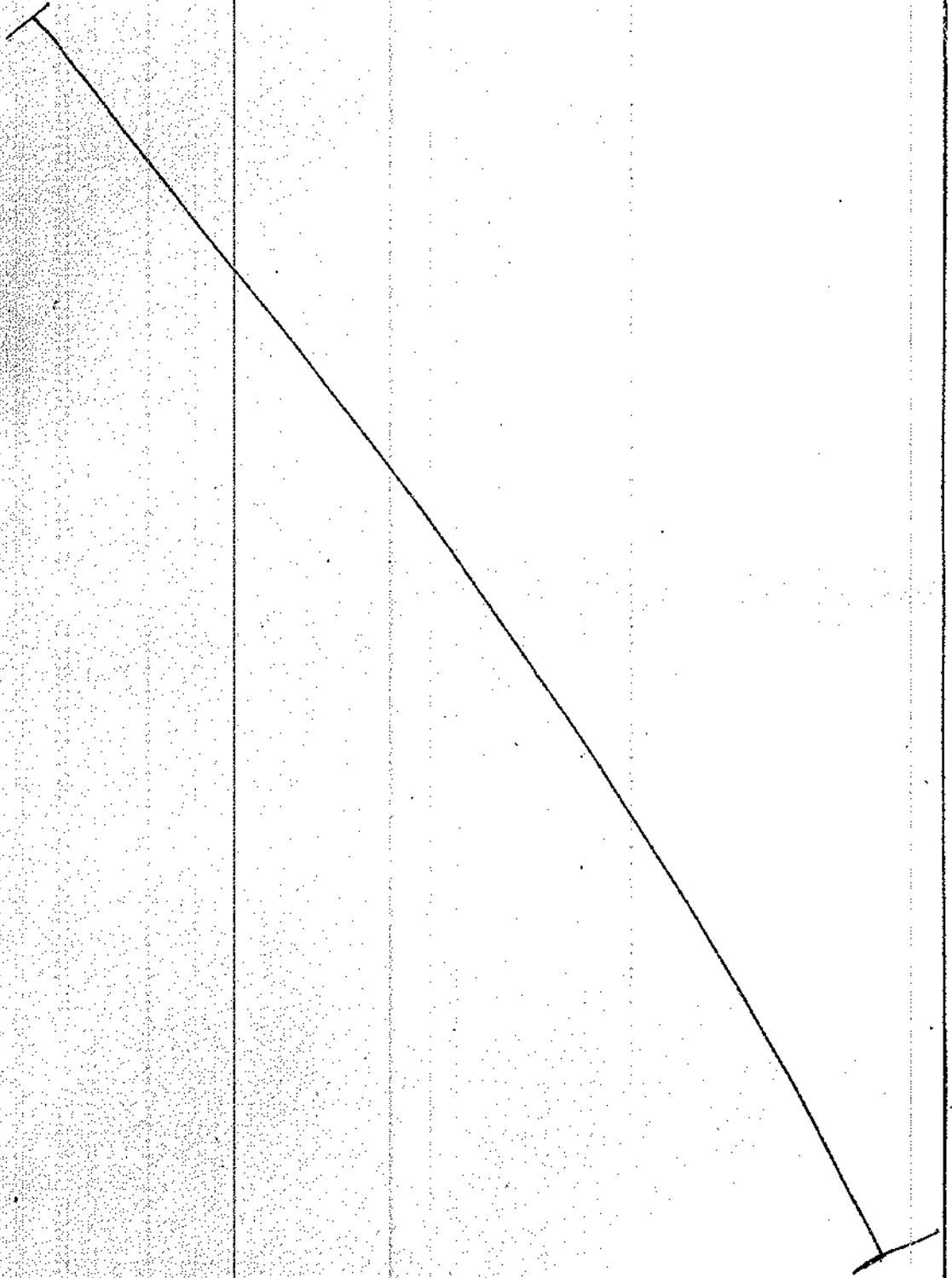
Machines of normal accuracy as per GOST 8-82 machines with increased accuracy, high accuracy, extra-high accuracy as per GOST 8-82 should belong to the high degree of accuracy for machines.

2. Values of allowances, given in Table 6 of the standard, should be used for the medium level of accuracy for machining (Table 15).

For the increased or high level of accuracy of machining, values of allowances, corresponding to the intervals of common tolerances given in Table 6 on 1 and 2 lines accordingly above the interval of actual tolerance and for the - to 1 line

| | | | | |
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below the interval of actual tolerance should be taken into account.



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| | | | | |

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SHEET
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Common tolerance for casting
elements, mm
Общие допуски элементов отливок

Обязательное

Таблица 16
TABLE - 16

мм

| Tolerance of the dimension from the surface Допуск размера от поверхности до базы to the datum surface. | | Tolerance of mould and location of the surface. Допуск формы и расположения поверхности | | Common tolerance for the element of casting, not exceeding. Общий допуск элемента отливки, не более exceeding. |
|---|------------|--|---|---|
| upto До 0.01 | from above | upto До 0.01 | Св. 0.01 » 0.02 | 0.02 0.03 |
| from above Св. 0.01 до 0.02 | from above | upto До 0.01 | Св. 0.01 » 0.02 » 0.02 » 0.03 » 0.03 » 0.04 | 0.02 0.03 0.04 0.05 |
| from above Св. 0.02 до 0.03 | from above | upto До 0.01 | Св. 0.01 » 0.02 » 0.02 » 0.03 » 0.03 » 0.04 » 0.04 » 0.05 » 0.05 » 0.06 | 0.03 0.04 0.05 0.06 0.07 0.08 |
| from above Св. 0.03 до 0.04 | from above | upto До 0.01 | Св. 0.01 » 0.03 » 0.03 » 0.04 » 0.04 » 0.05 » 0.05 » 0.06 » 0.06 » 0.08 | 0.04 0.05 0.06 0.07 0.08 0.11 |
| from above Св. 0.04 до 0.05 | from above | upto До 0.01 | Св. 0.01 » 0.03 » 0.03 » 0.04 » 0.04 » 0.05 » 0.05 » 0.06 » 0.06 » 0.08 » 0.08 » 0.10 | 0.05 0.06 0.07 0.08 0.09 0.11 0.14 |
| from above Св. 0.05 до 0.06 | from above | upto До 0.02 | Св. 0.02 » 0.03 » 0.03 » 0.04 » 0.04 » 0.05 » 0.05 » 0.06 » 0.06 » 0.08 » 0.08 » 0.10 » 0.10 » 0.12 | 0.06 0.07 0.08 0.09 0.10 0.12 0.14 0.16 |
| from above Св. 0.06 до 0.08 | from above | upto До 0.02 | Св. 0.02 » 0.04 » 0.04 » 0.05 » 0.05 » 0.06 » 0.06 » 0.08 » 0.08 » 0.10 » 0.10 » 0.12 » 0.12 » 0.16 | 0.08 0.09 0.10 0.11 0.14 0.16 0.18 0.22 |

мм

| Tolerance of the dimension from the surface Допуск размера от поверхности до базы to the datum surface | Tolerance of mould and location of the surface Допуск формы и расположения поверхности | Common tolerance for the element of casting, not exceeding. Общий допуск элемента отливки, не более |
|--|--|--|
| upto from above Св. 0.08 до 0.10 | upto До 0.02 from above Св. 0.02 » 0.04 » 0.04 » 0.06 » 0.06 » 0.08 » 0.08 » 0.10 » 0.10 » 0.12 » 0.12 » 0.16 » 0.16 » 0.20 | 0.10 0.11 0.12 0.14 0.16 0.18 0.22 0.28 |
| upto from above Св. 0.10 до 0.12 | upto До 0.02 from above Св. 0.02 » 0.06 » 0.06 » 0.08 » 0.08 » 0.10 » 0.10 » 0.12 » 0.12 » 0.16 » 0.16 » 0.20 » 0.20 » 0.24 | 0.12 0.14 0.16 0.18 0.20 0.24 0.28 0.32 |
| upto from above Св. 0.12 до 0.16 | upto До 0.03 from above Св. 0.03 » 0.06 » 0.06 » 0.10 » 0.10 » 0.12 » 0.12 » 0.16 » 0.16 » 0.20 » 0.20 » 0.24 » 0.24 » 0.32 | 0.16 0.18 0.20 0.22 0.28 0.32 0.36 0.44 |
| upto from above Св. 0.16 до 0.20 | upto До 0.03 from above Св. 0.03 » 0.08 » 0.08 » 0.12 » 0.12 » 0.16 » 0.16 » 0.20 » 0.20 » 0.24 » 0.24 » 0.32 » 0.32 » 0.40 | 0.20 0.22 0.24 0.28 0.32 0.36 0.44 0.56 |
| upto from above Св. 0.20 до 0.24 | upto До 0.06 from above Св. 0.06 » 0.12 » 0.12 » 0.16 » 0.16 » 0.20 » 0.20 » 0.24 » 0.24 » 0.32 » 0.32 » 0.40 » 0.40 » 0.48 | 0.24 0.28 0.32 0.36 0.40 0.50 0.56 0.64 |

мм

| Tolerance of the dimension from the surface Допуск размера от поверхности до базы to the datum surface. | Tolerance of mould and location of the surface. Допуск формы и расположения поверхности. | Common tolerance for the element of casting, not exceeding. Общий допуск элемента отливки, не более exceeding. |
|---|---|---|
|---|---|---|

from above

upto
Св. 0,24 до 0,32

| from above | upto | to |
|------------|------|------|
| Св. 0,06 | > | 0,06 |
| > | > | 0,12 |
| > | > | 0,20 |
| > | > | 0,24 |
| > | > | 0,32 |
| > | > | 0,40 |
| > | > | 0,50 |
| > | > | 0,64 |

0,32
0,36
0,40
0,44
0,50
0,56
0,70
0,90from above upto
Св. 0,32 до 0,40

| from above | upto | to |
|------------|------|------|
| Св. 0,08 | > | 0,08 |
| > | > | 0,16 |
| > | > | 0,24 |
| > | > | 0,32 |
| > | > | 0,40 |
| > | > | 0,50 |
| > | > | 0,64 |
| > | > | 0,80 |

0,40
0,44
0,50
0,56
0,64
0,70
0,90
1,10from above upto
Св. 0,40 до 0,50

| from above | upto | to |
|------------|------|------|
| Св. 0,12 | > | 0,12 |
| > | > | 0,24 |
| > | > | 0,32 |
| > | > | 0,40 |
| > | > | 0,50 |
| > | > | 0,64 |
| > | > | 0,80 |
| > | > | 1,00 |

0,50
0,56
0,64
0,70
0,80
0,90
1,10
1,40from above upto
Св. 0,50 до 0,64

| from above | upto | to |
|------------|------|------|
| Св. 0,12 | > | 0,12 |
| > | > | 0,24 |
| > | > | 0,40 |
| > | > | 0,50 |
| > | > | 0,64 |
| > | > | 0,80 |
| > | > | 1,00 |
| > | > | 1,20 |
| > | > | 1,28 |

0,64
0,70
0,80
0,90
1,00
1,20
1,40
1,60
1,80from above upto
Св. 0,64 до 0,80

| from above | upto | to |
|------------|------|------|
| Св. 0,20 | > | 0,20 |
| > | > | 0,40 |
| > | > | 0,50 |
| > | > | 0,64 |
| > | > | 0,80 |
| > | > | 1,00 |
| > | > | 1,20 |
| > | > | 1,60 |

0,80
0,90
1,00
1,10
1,20
1,40
1,80
2,20

мм

| | Tolerance of the dimension from the surface to the datum surface. Допуск размера от поверхности до базы | Tolerance of mould and location of the surface Допуск формы и расположения поверхности | Common tolerance for the element of casting not exceeding. Общий допуск элемента отливки, не более |
|------------|--|---|---|
| from above | upto Св. 0,80 до 1,00 | from above upto До 0,24 Св. 0,24 > 0,40 > 0,40 > 0,64 > 0,64 > 0,80 > 0,80 > 1,00 > 1,00 > 1,20 > 1,20 > 1,60 > 1,60 > 2,00 | 1,00 1,10 1,20 1,40 1,60 1,80 2,20 2,80 |
| from above | upto Св. 1,00 до 1,20 | from above upto До 0,32 Св. 0,32 > 0,64 > 0,64 > 0,80 > 0,80 > 1,00 > 1,00 > 1,20 > 1,20 > 1,60 > 1,60 > 2,00 > 2,00 > 2,40 | 1,20 1,40 1,60 1,80 2,00 2,40 2,80 3,20 |
| from above | upto Св. 1,20 до 1,60 | from above upto До 0,40 Св. 0,40 > 0,80 > 0,80 > 1,00 > 1,00 > 1,20 > 1,20 > 1,60 > 1,60 > 2,00 > 2,00 > 2,40 > 2,40 > 3,20 | 1,60 1,80 2,00 2,20 2,40 2,80 3,60 4,40 |
| from above | upto Св. 1,60 до 2,00 | from above upto До 0,40 Св. 0,40 > 0,80 > 0,80 > 1,20 > 1,20 > 1,60 > 1,60 > 2,00 > 2,00 > 2,40 > 2,40 > 3,20 > 3,20 > 4,00 | 2,00 2,20 2,40 2,80 3,20 3,60 4,40 5,60 |
| from above | upto Св. 2,00 до 2,40 | from above upto До 0,64 Св. 0,64 > 1,20 > 1,20 > 1,60 > 1,60 > 2,00 > 2,00 > 2,40 > 2,40 > 3,20 > 3,20 > 4,00 > 4,00 > 4,80 | 2,40 2,80 3,20 3,60 4,00 4,40 5,60 6,40 |

Gost

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мм

| ② Допуск размера от поверхности до базы | Допуск формы и расположения поверхности | Общий допуск элемента отливки, не более |
|---|--|---|
| from above upto Св. 2,40 до 3,20 | from above upto До 0,80 Св. 0,80 » 1,60 » 1,60 » 2,00 » 2,00 » 2,40 » 2,40 » 3,20 » 3,20 » 4,00 » 4,00 » 5,00 » 5,00 » 6,40 | 3,20 3,60 4,00 4,40 5,00 5,60 7,00 9,00 |
| from above upto Св. 3,20 до 4,00 | from above upto До 1,00 Св. 1,00 » 1,60 » 1,60 » 2,40 » 2,40 » 3,20 » 3,20 » 4,00 » 4,00 » 5,00 » 5,00 » 6,40 » 6,40 » 8,00 | 4,00 4,40 5,00 5,60 6,40 7,00 9,00 11,00 |
| from above upto Св. 4,00 до 5,00 | from above upto До 1,20 Св. 1,20 » 2,40 » 2,40 » 3,20 » 3,20 » 4,00 » 4,00 » 5,00 » 5,00 » 6,40 » 6,40 » 8,00 » 8,00 » 10,00 | 5,00 5,60 6,40 7,00 8,00 9,00 11,00 14,00 |
| from above upto Св. 5,00 до 6,40 | from above upto До 1,20 Св. 1,20 » 2,40 » 2,40 » 4,00 » 4,00 » 5,00 » 5,00 » 6,40 » 6,40 » 8,00 » 8,00 » 10,00 » 10,00 » 12,00 » 12,00 » 12,80 | 6,40 7,00 8,00 9,00 10,00 12,00 14,00 16,00 18,00 |
| from above upto Св. 6,40 до 8,00 | from above upto До 2,00 Св. 2,00 » 4,00 » 4,00 » 5,00 » 5,00 » 6,40 » 6,40 » 8,00 » 8,00 » 10,00 » 10,00 » 12,00 » 12,00 » 16,00 | 8,00 9,00 10,00 11,00 12,00 14,00 18,00 22,00 |

мм

| Tolerance of the dimension from the surface to the datum surface Допуск размера от поверхности до базы | Tolerance of mould and location of the surface Допуск формы и расположения поверхности | Common tolerance for the element of casting, not exceeding. Общий допуск элемента отливки, не более |
|---|---|--|
| upto from above Св. 8,00 до 10,00 | upto До 2,40 Св. 2,40 » 4,00 » 4,00 » 6,40 » 6,40 » 8,00 » 8,00 » 10,00 » 10,00 » 12,00 » 12,00 » 16,00 » 16,00 » 20,00 | 10,00 11,00 12,00 14,00 16,00 18,00 22,00 28,00 |
| upto from above Св. 10,00 до 12,00 | upto До 3,20 Св. 3,20 » 6,40 » 6,40 » 8,00 » 8,00 » 10,00 » 10,00 » 12,00 » 12,00 » 16,00 » 16,00 » 20,00 » 20,00 » 24,00 | 12,00 14,00 16,00 18,00 20,00 24,00 28,00 32,00 |
| upto from above Св. 12,00 до 16,00 | upto До 4,00 Св. 4,00 » 8,00 » 8,00 » 10,00 » 10,00 » 12,00 » 12,00 » 16,00 » 16,00 » 20,00 » 20,00 » 24,00 » 24,00 » 32,00 | 16,00 18,00 20,00 22,00 24,00 28,00 36,00 44,00 |
| upto from above Св. 16,00 до 20,00 | upto До 5,00 Св. 5,00 » 8,00 » 8,00 » 12,00 » 12,00 » 16,00 » 16,00 » 20,00 » 20,00 » 24,00 » 24,00 » 32,00 » 32,00 » 40,00 | 20,00 22,00 24,00 28,00 32,00 36,00 44,00 56,00 |
| upto from above Св. 20,00 до 24,00 | upto До 6,40 Св. 6,40 » 12,00 » 12,00 » 16,00 » 16,00 » 20,00 » 20,00 » 24,00 » 24,00 » 32,00 » 32,00 » 40,00 » 40,00 » 48,00 | 24,00 28,00 32,00 36,00 40,00 44,00 56,00 64,00 |

MM

| Tolerance of the dimension from the surface Допуск размера от поверхности до базы to the datum surface. | | Tolerance of mould and location of the surface. Допуск формы и расположения поверхности | | Common tolerance for the element of casting, not exceeding Общий допуск элемента отливки, не более |
|---|----------------------------|--|-------------------|---|
| from above | upto Св. 24,00 до 32,00 | from above | upto До 8,00 | 32,00 |
| | | | Св. 8,00 > 16,00 | 36,00 |
| | | | > 16,00 > 20,00 | 40,00 |
| | | | > 20,00 > 24,00 | 44,00 |
| | | | > 24,00 > 32,00 | 50,00 |
| | | | > 32,00 > 40,00 | 56,00 |
| from above | upto Св. 32,00 до 40,00 | from above | upto До 10,00 | 70,00 |
| | | | Св. 10,00 > 16,00 | 80,00 |
| | | | > 16,00 > 24,00 | 90,00 |
| | | | > 24,00 > 32,00 | 100,00 |
| | | | > 32,00 > 40,00 | 110,00 |
| | | | > 40,00 > 50,00 | 120,00 |
| from above | upto Св. 40,00 до 50,00 | from above | upto До 12,00 | 140,00 |
| | | | Св. 12,00 > 24,00 | 160,00 |
| | | | > 24,00 > 32,00 | 180,00 |
| | | | > 32,00 > 40,00 | 200,00 |
| | | | > 40,00 > 50,00 | 220,00 |
| | | | > 50,00 > 64,00 | 240,00 |
| from above | upto Св. 50,00 до 64,00 | from above | upto До 12,00 | 280,00 |
| | | | Св. 12,00 > 24,00 | 320,00 |
| | | | > 24,00 > 40,00 | 360,00 |
| | | | > 40,00 > 50,00 | 400,00 |
| | | | > 50,00 > 64,00 | 450,00 |
| | | | > 64,00 > 80,00 | 500,00 |
| from above | upto Св. 64,00 до 80,00 | from above | upto До 20,00 | 560,00 |
| | | | Св. 20,00 > 40,00 | 630,00 |
| | | | > 40,00 > 50,00 | 700,00 |
| | | | > 50,00 > 64,00 | 770,00 |
| | | | > 64,00 > 80,00 | 840,00 |
| | | | > 80,00 > 100,00 | 910,00 |

6. Common tolerance of the casting element - complex tolerance, including the tolerance of dimension from the surface to the datum surface and independently designated tolerances of mould and location of the being standardized section of the surface.

7. Unevenness of the surface of casting - sum-total of alternating projections and cavities on the surface of casting. Unevenness of the surface of casting is subdivided into roughness (microunevenness) and waviness (mesounevenness).

8. Surface roughness - as per GOST 2789 - 73 and GOST 25142-82. Roughness of surfaces - sum-total of repeated unevenness of smaller value (microunevenness).

Pitch line of the microprofile of the surface serves as the datum line for determining the parameters of surface roughness. The following designations are used; Ra, micron - mean arithmetic deviation of the microprofile of surface; Rz, micron - height of unevenness of the profile (upto 10 point).

9. Waviness of surface - as per CЭB 3951 - 73.

Waviness of surface - is the sum-total of the repeating surface irregularities of medium value (mesoirregularities) that is irregularities of surface with a pitch, exceeding the datum line, on which surface - roughness of the given surface is measured.

Pitch line of the surface profile serves as the datum line for determining the values of parameters.

Base length for measuring the waviness of surfaces of castings is taken as equal to 4-10 to the base lengths for measuring the roughness, but not less than 5 pitches of waviness

| | | | | | | | |
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by the specialties of casting technology. The following are referred under technological laps; allowances, ensuring the guided crystallizing of casting; allowances, smoothening the local depressions and projections; allowances and additions compensating the distortion of configuration of casting under the effect of the stress, occurring during cooling; impossible holes; shrinkable ribs; drafts.

16. Parameters for the accuracy of casting are the generalized accuracy characteristics of the dimensions, surfaces or castings as a whole.

Parameters for the accuracy of dimensions and surfaces of casting include the accuracy class for the dimension, degree of warpage for the element of casting, degree of accuracy for the surface, as well as shift of element of casting and series of allowance for the surface of casting.

Accuracy parameters of casting as a whole include the class of dimensional accuracy, degree of warpage, degree of accuracy for the surfaces and accuracy class of mass as well as shift of casting.

17. Norms for accuracy of casting are the requirements for the level of values for the accuracy parameters of casting.

Accuracy norms are established depending upon the purpose, design-technical specialties, operating conditions and manufacturing of casting.

18. Types of machining; rough, semifinish, finish and thin. They differ from each other as per the accuracy being ensured

