

## Dimensional Tolerance

2015 - V1

**Note :** Design constraints are dependent on molded density, shape and molding technology including filling method.

The following indications are given as guidelines only.

**Dimensional tolerances:** Tool dimension have to take into account part shrinkage.

Dimensions	Tolerance / Density			
	<25g/L	25~35g/L	35~60g/L	>60g/L
0 ~ 5mm	± 0.75mm	± 0.5mm	± 0.5mm	± 0.5mm
6 ~ 25mm	± 2.0mm	± 1.5mm	± 1.5mm	± 1.0mm
26 ~ 100mm	± 2.5mm	± 2.5mm	± 2.0mm	± 2.0mm
101 ~ 250mm	± 3.0mm	± 3.0mm	± 2.5mm	± 2.5mm
251 ~ 500mm	± 4.0mm	± 3.5mm	± 3.5mm	± 3.0mm
501 ~ 1000mm	± 6.0mm	± 6.0mm	± 5.0mm	± 4.0mm
More than 1000mm	± 1.5%	± 1.2%	± 1.0%	± 0.75%

Users need to perform their own tests under end-use conditions. Because tolerances are highly dependent on machine, part geometry, tool desig, pre-treatment and post treatment.

※ The data indicated above are subject to change according to test condition and method.

※ We can supply optimized special grades besides above mentioned.