

<b>Metal Casting Comparison Chart</b>					
	<b>Sand Casting</b>	<b>Permanent Molding</b>	<b>Die Casting</b>	<b>Ceramic &amp; Investment Casting</b>	<b>Thompson Investment Casting</b>
<b>Dimensional Tolerances</b>	±.010" ±.030"	±.010" ±.050"	±.001" ±.015"	±.010" ±.020"	±.003 per inch Premium
<b>Relative Cost - High Part Quantity</b>	Low	Low	Lowest	Highest	Medium
<b>Relative Cost - Low Part Quantity</b>	Lowest	High	Highest	Medium	Medium
<b>Casting Weight Range</b>	Unlimited	oz. - 100 lb	oz. - 75 lb	Ceramic - 3-350 lb. Investment - oz. - 100 lb	Less than 1 oz to 25 pounds
<b>Minimum Wall Thickness</b>	1/10"	1/8"	1/32"	1/16"	.020"
<b>As Cast Finish (RMS)</b>	150 - 350	150 - 200	63 - 90	60 - 125	60 - 125
<b>Draft Angle (Degrees)</b>	1 - 5	2 - 4	1/2 - 2	1/4 - 1/2	=/- 1/4 to 1/2
<b>Design Complexity/Detail</b>	Fair-good	Fair	Good	Best	Best
<b>Relative Ease of Design Changes In Production</b>	Best	Poor	Poorest	Fair	Good
<b>Castable Alloys</b>	Most Ferrous / Non-ferrous Metals	Al-base & Cu- base Preferred	Al-base Preferred>	Most Ferrous / Non-ferrous Metals.	Ferrous, Copper and Copper Based, Cobalt Based, Nickel Based, Aluminum Based