



Investment Castings - Carbon Steel, Alloy Steel, & Stainless Steel

		Weight (Lbs)			
		0.1-5	5.1-25	25.1-100	100-250
Q u a n t i t y	1 - 50	3	3	2	1
	50 - 250	2	2	1	1
	250 - 1000	2	1	1	1
	1000 - 5000	1	1	1	1
	5000 +	1	1	1	2

- 1 Greatest Strength
- 2 Good Capability
- 3 Capable, but undesirable



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Sand Castings - Iron (Grey and Ductile), Carbon Steel, Alloy Steel & Stainless Steel

		Weight (Lbs)				
		0.5-25	25-100	100-500	500-5000	5000+
Q u a n t i t y	1 - 25	3	3	2	2	2
	25 - 100	3	2	1	2	2
	100 - 500	2	1	1	2	2
	500 - 2500	1	1	1	3	3
	2500 +	1	1	1	3	3

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Permanent Mold Castings - Aluminum

		Weight (Lbs)			
		0.5-10	10-30	30-50	50+
Q u a n t i t y	1 - 100	3	3	2	2
	100 - 1000	3	2	1	2
	1000 - 5000	2	1	1	2
	5000+	1	1	1	2

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Die Castings - Aluminum and Zinc

		Weight (Lbs)			
		0.5-10	10-30	30-50	50+
Q u a n t i t y	1 - 1000	3	3	2	2
	1000 - 5000	3	2	2	2
	5000 - 10000	2	2	1	2
	10000 - 1000000	2	1	1	3
	1000000+	1	1	3	3

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Closed Die Forgings - Carbon Steel, Alloy Steel & Stainless Steel

		Weight (Lbs)			
		0.1-5	5.1-25	25.1-100	100-250
Q u a n t i t y	1 - 50	3	3	3	3
	50 - 250	2	2	2	3
	250 - 1000	2	1	1	2
	1000 - 5000	1	1	1	1
	5000 +	1	1	1	1

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Open Die Forgings - Carbon Steel, Alloy Steel & Stainless Steel

		Weight (Lbs)			
		25-100	100-500	500-5000	5000+
Q u a n t i t y	1 - 25	3	3	2	2
	25 - 100	2	2	2	2
	100 - 500	1	1	2	2
	500 - 2500	1	1	2	3
	2500 +	1	1	2	3

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Rolled Ring Forgings – Carbon Steel, Alloy Steel & Stainless Steel

		Size - Outside Diameter (Inch)			
		2" - 24"	24"-48"	48"-120"	120"-196"
W e i g h t	1 - 25	3	3	2	2
	25 - 100	2	2	2	2
	100 - 500	1	1	2	2
	500 - 2500	1	1	1	1
	2500 +	1	1	1	1

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Domestic Machining

		Category									
		Milling	Turning	Threading	Drilling	Boring	Gear Cutting	Surface Grinding	Cylindrical Grinding	Reaming	Broaching
Work piece Size	< 6"	1	1	1	1		3	3	3	3	3
	6"-12"	1	1	1	1		3	3	3	3	3
	12"-20"	1	1	1	1		3	3	3	3	3
	20"-100"	1	1	1	1	3	3	3	3	3	3
	> 100"	1	1	1	1	3	3	3	3	3	3

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***Subject to review of drawing tolerances and requirements



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International Machining

		Category									
		Milling	Turning	Threading	Drilling	Boring	Gear Cutting	Surface Grinding	Cylindrical Grinding	Reaming	Broaching
W o r k p i e c e S i z e	< 6"	1	1	1	1		2	2	2	2	1
	6"-12"	1	1	1	1		2	2	2	2	1
	12"-20"	1	1	1	1		2	2	1	2	1
	20"-100"	1	1	1	1	2	2	2	1	2	2
	> 100"	1	1	1	1	2	2	2	1	2	2

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