

# GENERAL TOLERANCES

- All drilled holes will be  $\pm .005$  from the center of wire
- Drilled hole orientation to be  $\pm 2^\circ$  from nominal
- Straighten and cut length will be held to  $\pm .03$  as a standard. If tighter tolerances are needed, they can be held at an additional charge
- Bend angles with center line radii  $.03$ - $2"$   $\pm 2^\circ$
- Bend angles with center line radii  $>2$   $\pm 3^\circ$
- Radii of Press Forms:

| Radii         | $\pm$ of radii         |
|---------------|------------------------|
| $.03"$ - $1"$ | $0.03"$                |
| $1"$ - $3"$   | $0.06"$                |
| $3"$ - $5"$   | $0.125"$               |
| $>5"$         | As formed for function |

- Radii of CNC Bender formed parts:

| Radii         | $\pm$ of radii         |
|---------------|------------------------|
| $.03"$ - $1"$ | $0.03"$                |
| $1"$ - $3"$   | $0.09"$                |
| $>3"$         | As formed for function |

- Leg length on formed part should be 2x the wire diameter from the end of the radii to the end of the part
- Shorter leg length possible at additional cost (due to slower processes/tool designs)
- All accumulated tolerances will apply
- All tolerances stated are for reference only. Each wire form has it's own set of circumstances and will be addressed on a part by part basis
- This is to be used as a tool to lower the number of deviations requested and to deliver tooling/parts in a timely manner