

	SAND CASTING	SHELL MOULD CASTING	GRAVITY DIE CASTING	LOW PREASSURE DIE CASTING	HIGH PRESSURE DIE CASTING at LENAAL (our capacities)
Casting weight (kg)	0,1 ... 500	0,1.....15	0,01 50	1 70	0,0110
Annual volume (pcs)	1 - 5.000	50 - 10.000	100 - 50.000	100 - 10.000	20.000 - 2.000.000
Tooling cost	relatively low	relatively low / moderate	moderate	moderate	high
Cost of changes	low	relatively low / moderate	moderate	moderate	high
Minimum wall thickness (mm)	4 - 6	2 - 4	3 - 4	3 - 4	ALU 1,5 - 3 ZN 0,8 - 1,5
Dimension accuracy	Fairly good	Good	Good	Good	Very good
Possible surface roughness (Ra)	> 6.3 - 12.3	> 6.3	> 3.2 (2.5)	> 3.2	> 1.6 (0.8)
Casting alloys	AlSi7Cu2 AlSi7Mg AlSi9Cu2 AlSi10Mg	AlMg3 AlSi7Mg AlSi10Mg AlSi12	AlSi7Mg AlSi10Mg AlSi12	AlSi7Mg AlSi10Mg AlSi12	AlSi9Cu3(Fe) AlSi9MgMn AlSi10Mg(Fe) AlSi12(Fe) AlSi12Cu1(Fe) ZnAl4Cu1
Lead time for tools and samples (weeks)	3 - 6	2 - 4	5 - 12	8 - 15	10 - 20