

Nylacast Semi - Finishing Guidelines

BEAM SAW

	Length	Width
Max	4000mm	4000mm
Min	50mm	50mm
Tolerance	-0.00+2.00mm	-0.00+1.00mm

CROSS CUT SAW

Max	4000mm	300mm
Min	20mm	20mm
Tolerance	-0.00+1.00	-0.00+1.00

4 SIDED PLANER

Max	4000mm	220mm
Min	750mm	30mm
Tolerance	-0 +1	+/- 0.2

BILLETING SAW

Diameter & Square mm	Cutting Tolerance on cut length<500mm	Allow extra material on length on cutting
50 - 95	0.0/+1mm	+2mm
100 - 200	0.0/+1mm	+3mm
210 - 350	0.0/+2mm	+4mm
360 - 500	0.0/+2mm	+6mm
510 - 630	0.0/+3mm	+8mm
640 - 790	0.0/+4mm	+10mm

ROD ROUNDING

Diameter mm	Tolerance	Length
10 - 18	0 to +0.4mm	See sawn table
20 - 28	0 to +0.5mm	for max. and min.
30 - 45	0 to +0.5mm	lengths and tolerances