



Standard Practice for Investment Castings, Surface Acceptance Standards, Visual Examination¹

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1. Scope

1.1 This practice covers the acceptance criteria for surface inspection of investment castings by visual examination.

1.2 The values stated in inch-pound units are to be regarded as standard. The values given in parentheses are mathematical conversions to SI units that are provided for information only and are not considered standard.

1.3 *This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the responsibility of the user of this standard to establish appropriate safety and health practices and determine the applicability of regulatory limitations prior to use.*

2. Terminology

2.1 *Definitions of Terms Specific to This Standard:*

2.1.1 *linear discontinuity, n*—a discontinuity whose length is equal to or greater than three times its width. Cracks and cold shuts are examples of linear discontinuity.

2.1.2 *positive metal, n*—raised metal on the casting surface usually associated with the breakdown of the mold and its replacement with the casting metal.

2.1.3 *surface pit, n*—a non linear depression in the cast surface whose length is less than three times its width. Surface pits may be the result of gas or non metallic inclusions.

2.1.4 *surface roughness, n*—a measure of surface texture usually determined by the use of a comparator.

3. Ordering Information

3.1 The inquiry or order should specify the following information:

3.1.1 *Acceptance Level*—More than one acceptance level may be specified for different surfaces of the same casting (see Section 4),

3.1.2 If any types of discontinuities are unacceptable,

3.1.3 Casting surfaces to be examined,

3.1.4 Number of castings to be examined, and

3.1.5 Additional acceptance criteria as applicable to all or portions of the casting surface.

4. Acceptance Criteria

4.1 Levels of acceptance for visual inspection are listed in **Table 1**.

4.2 Parts shall not exhibit any linear discontinuities.

4.3 Surface roughness and surface pits that will be removed by machining are considered acceptable.

4.4 Surface discontinuities not covered in this practice shall be a matter of agreement between the purchaser and the manufacturer.

¹ This practice is under the jurisdiction of ASTM Committee A01 on Steel, Stainless Steel and Related Alloys and is the direct responsibility of Subcommittee A01.18 on Castings.

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TABLE 1 Visual Inspection Acceptance Criteria^{A,B}

Surface Feature	Level II	Level III	Level IV
Surface Pits ^{C, D, E}	0.030 in. (0.76 mm) diameter by 0.015 in. (0.38 mm) deep with no more than 1 per in. ² (645 mm ²)	0.060 in. (1.52 mm) diameter by 0.030 in. (0.76 mm) deep with no more than 1 per in. ² (645 mm ²)	0.060 in. (1.52 mm) diameter by 0.030 in. (0.76 mm) deep with no more than 4 per in. ² (645 mm ²)†
Positive Metal ^{D, E}	0.060 in. (1.52 mm) diameter by 0.015 in. (0.38 mm) high with no more than 1 per in. ² (645 mm ²)	0.125 in. (3.18 mm) diameter by 0.030 in. (0.76 mm) high with no more than 1 per in. ² (645 mm ²)	0.125 in. (3.18 mm) diameter by 0.030 in. (0.76 mm) high with no more than 4 per in. ² (645 mm ²)
Parting Line and Ejector Pin Marks Height or Depth ^C	0.005 in. (0.13 mm)	0.010 in. (0.25 mm)	0.020 in. (0.51 mm)
Gate Height ^F	0.015 in. (0.38 mm)	0.030 in. (0.76 mm)	0.045 in. (1.14 mm)
Surface Roughness ^E	100 µin. (2.5 µm)	125 µin. (3.2 µm)	200 µin. (5.0 µm)

^A Features in excess of those specified in the table are not acceptable.

^B Level I criteria may be established in the future depending on need.

^C Maximum surface pit, parting line, and ejector pin mark depth shall not violate drawing minimum wall thickness.

^D Surface pits or positive metal less than 0.010 in. (0.25 mm) diameter and less than 0.010 in. (0.25 mm) deep or high shall be considered non-relevant.

^E Determined by comparator or tactile source.

^F Machined and non-machined surfaces

†Value was editorially corrected in June 2006.

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