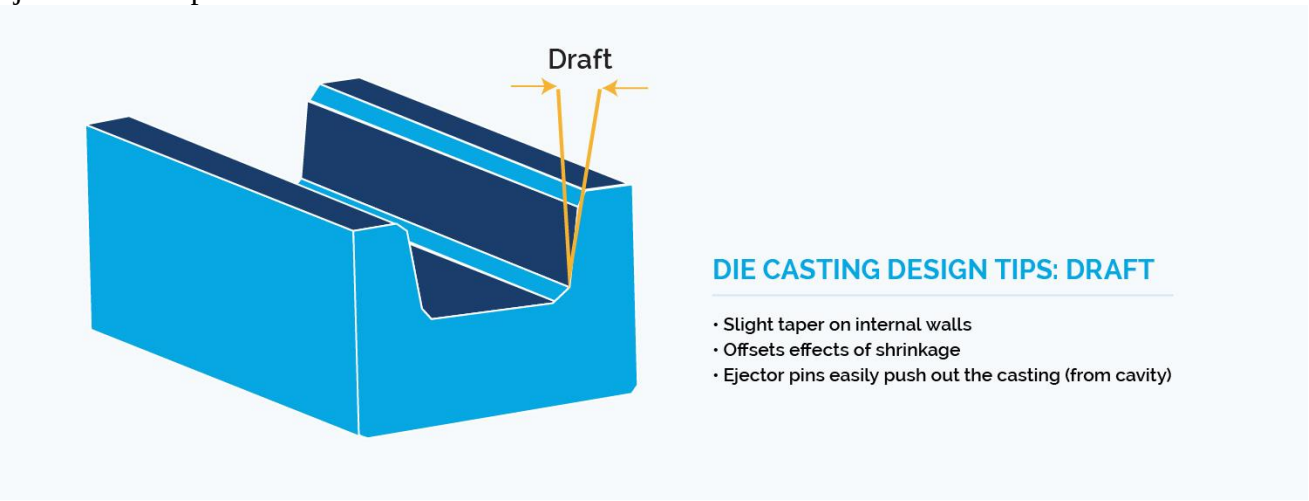
DRAFT REQUIREMENTS

Draft is necessary on surfaces parallel to the direction of the die draw because it facilitates the ejection of the part from the tool.



- It is not common practice to compute the draft angle for each feature on a component, and it is normally generalized with some exceptions
- Twice as much draft angle is recommended for inside walls or surfaces as for outside walls or surfaces
- This is because the alloy solidifies and shrinks onto the features that form the inside surface and away from the features that form the outside surfaces.

MmMULTI-SLIDE ZINC DIE CASTING	Cores	0 Degree ≤ 6.35 0.15 Degree > 6.35	0 Degree ≤ .250” 0.25 Degree > .250”
	Cavity	0-0.15 Degree	0-0.25 Degree
CONVENTIONAL ZINC DIE CASTING	Cores	1/2 Degree	1/2 Degree
	Cavity	1/8 – 1/4 Degree	1/8 – 1/4 Degree
PRECISION ALUMINUM DIE CASTING	Cores	2 Degrees	2 Degrees
	Cavity	1/2 Degree	1/2 Degree