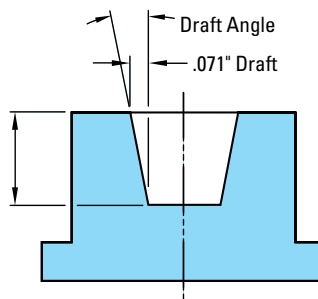


Draft Angles

DEPTH	1/2°	1°	2°	3°	4°	5°	6°	7°	8°	9°	10°	11°	12°	15°	20°	25°	30°	DEPTH
1/32	.0003	.0005	.001	.0016	.002	.0027	.003	.0038	.004	.005	.0055	.006	.0066	.008	.011	.014	.018	1/32
1/16	.0005	.0011	.002	.0033	.004	.0055	.007	.0077	.009	.010	.011	.012	.013	.017	.023	.029	.036	1/16
3/32	.0008	.0017	.003	.0049	.006	.008	.010	.0115	.013	.015	.0165	.018	.020	.025	.034	.044	.054	3/32
1/8	.0011	.0022	.004	.0066	.009	.0109	.013	.015	.018	.020	.022	.024	.027	.033	.045	.058	.072	1/8
5/32	.0014	.0028	.005	.008	.011	.014	.016	.019	.022	.025	.027	.030	.033	.042	.057	.073	.089	5/32
3/16	.0016	.0033	.006	.0098	.013	.016	.019	.023	.027	.030	.033	.036	.040	.050	.068	.087	.108	3/16
7/32	.0019	.0039	.008	.011	.015	.019	.023	.027	.031	.035	.039	.042	.047	.059	.080	.102	.126	7/32
1/4	.0022	.0043	.009	.013	.018	.022	.026	.031	.035	.040	.044	.049	.053	.067	.091	.117	.144	1/4
9/32	.0025	.005	.010	.014	.020	.024	.030	.034	.040	.045	.049	.055	.060	.075	.102	.131	.162	9/32
5/16	.0027	.0055	.011	.016	.022	.027	.033	.038	.044	.050	.055	.061	.066	.084	.114	.146	.180	5/16
11/32	.003	.006	.012	.018	.024	.030	.036	.042	.049	.055	.061	.067	.073	.092	.125	.160	.197	11/32
3/8	.0032	.0066	.013	.020	.026	.033	.039	.046	.053	.060	.066	.073	.080	.100	.136	.175	.217	3/8
13/32	.0035	.007	.014	.021	.028	.035	.043	.050	.057	.064	.071	.079	.086	.108	.148	.189	.234	13/32
7/16	.0038	.0077	.015	.023	.031	.038	.046	.054	.062	.069	.077	.085	.093	.117	.159	.204	.253	7/16
15/32	.0041	.008	.016	.024	.033	.041	.049	.058	.066	.074	.083	.091	.100	.126	.171	.219	.270	15/32
1/2	.0044	.0088	.018	.026	.035	.044	.053	.061	.071	.079	.088	.097	.106	.134	.182	.233	.289	1/2
17/32	.0046	.009	.019	.028	.037	.046	.056	.065	.075	.084	.093	.103	.113	.142	.193	.247	.306	17/32
9/16	.0049	.0099	.020	.030	.039	.049	.059	.069	.079	.088	.099	.109	.120	.151	.205	.262	.325	9/16
19/32	.0052	.010	.021	.031	.042	.052	.062	.073	.084	.094	.105	.115	.127	.159	.216	.277	.343	19/32
5/8	.0055	.011	.022	.033	.044	.055	.066	.077	.088	.100	.110	.120	.133	.167	.227	.291	.361	5/8
21/32	.0057	.011	.023	.035	.046	.057	.069	.082	.092	.104	.115	.127	.140	.176	.239	.306	.379	21/32
11/16	.006	.012	.024	.036	.048	.060	.072	.085	.096	.109	.121	.133	.147	.183	.250	.321	.397	11/16
23/32	.0063	.013	.025	.038	.050	.063	.075	.088	.101	.114	.126	.139	.153	.193	.261	.335	.415	23/32
3/4	.0065	.013	.027	.039	.053	.066	.079	.092	.106	.119	.132	.146	.159	.201	.273	.350	.433	3/4
25/32	.0068	.014	.028	.040	.055	.068	.081	.096	.110	.124	.137	.152	.166	.209	.284	.364	.451	25/32
13/16	.0071	.014	.029	.043	.057	.071	.085	.100	.115	.129	.143	.158	.173	.218	.296	.379	.469	13/16
27/32	.0074	.015	.030	.045	.059	.074	.089	.104	.119	.134	.149	.163	.180	.226	.307	.393	.487	27/32
7/8	.0076	.015	.031	.046	.061	.077	.092	.107	.123	.139	.154	.171	.186	.234	.318	.408	.505	7/8
29/32	.0079	.016	.032	.048	.063	.079	.095	.111	.128	.144	.159	.176	.193	.243	.329	.422	.523	29/32
15/16	.0082	.017	.033	.050	.066	.082	.098	.115	.132	.149	.165	.182	.200	.251	.341	.437	.541	15/16
31/32	.0085	.017	.034	.051	.068	.084	.101	.119	.137	.153	.170	.188	.206	.260	.353	.452	.559	31/32
1	.0087	.0175	.035	.052	.070	.087	.105	.123	.141	.158	.176	.194	.213	.268	.364	.466	.577	1
DEPTH	1/2°	1°	2°	3°	4°	5°	6°	7°	8°	9°	10°	11°	12°	15°	20°	25°	30°	DEPTH

The depth columns represent cavities from 1/32" to 1" in increments of 1/32". The most commonly used draft angles are noted in degrees at the top and bottom of the table. The measurement listed in any block represents the amount of draft obtained with the corresponding angle and cavity depth.

EXAMPLE: The difference between the diameter of the top and the diameter of the bottom of a 1/2" inch cavity with a draft angle of 8° is found by noting the figure in the table opposite the 1/2" depth and corresponding to the 8° draft angle (.071") and multiplying by two (1.420").



The length and necessary angle for cam pins used in actuating core pulls can also be calculated with this table.

EXAMPLE: The length of a pin set at a 15° angle required to pull a core 1". Since 20° and 1" of length allow .364" travel, a 4" pin permits four times the travel (1.456").