

# VDI SURFACE DRAFT ANGLE REFERENCE TABLE

[www.delta-mold.com](http://www.delta-mold.com)

| VDI Grade | Ra (µm) | Rz (µm) | Draft Angle |     |     |
|-----------|---------|---------|-------------|-----|-----|
|           |         |         | PA          | PC  | ABS |
| 12        | 0.4     | 1.5     | 0.0         | 1.0 | 0.5 |
| 15        | 0.6     | 2.4     | 0.5         | 1.0 | 0.5 |
| 18        | 0.8     | 3.3     | 0.5         | 1.0 | 0.5 |
| 21        | 1.1     | 4.7     | 0.5         | 1.0 | 0.5 |
| 24        | 1.6     | 6.5     | 0.5         | 1.5 | 1.0 |
| 27        | 2.2     | 10.5    | 1.0         | 2.0 | 1.5 |
| 30        | 3.2     | 12.5    | 1.5         | 2.0 | 2.0 |
| 33        | 4.5     | 17.5    | 2.0         | 3.0 | 2.5 |
| 36        | 6.3     | 24.0    | 2.5         | 4.0 | 3.0 |
| 39        | 9.0     | 34.0    | 3.0         | 5.0 | 4.0 |
| 42        | 12.5    | 48.0    | 4.0         | 6.0 | 5.0 |
| 45        | 18.0    | 69.0    | 5.0         | 7.0 | -   |

PA =Polyamide

PC = Polycarbonate

ABS = Acrilnitrile-Butadiene-Styrol

Note: glass reinforced materials require more drafting