

HOW TO APPLY GENERAL TOLERANCE

STANDARD TOLERANCE GRADES ISO 286-1																						
ST. NO.	BASIC SIZE (mm)		IT1	IT2	IT3	IT4	IT5	IT6	IT7	IT8	IT9	IT10	IT11	IT12	IT13	IT14	IT15	IT16	IT17	IT18	TOLERANCE	
	ABOVE	UP TO	MICROMETERS (µm)										MILLIMETERS (mm)									
			0.01	0.02	0.03	0.04	0.05	0.06	0.07	0.08	0.09	0.10	0.15	0.20	0.30	0.40	0.50	0.60	0.70	0.80		1.00
1	-	3	0.01	0.02	0.03	0.04	0.05	0.06	0.07	0.08	0.09	0.10	0.15	0.20	0.30	0.40	0.50	0.60	0.70	0.80	1.00	GRADE 18H7
2	3	4	0.01	0.02	0.03	0.04	0.05	0.06	0.07	0.08	0.09	0.10	0.15	0.20	0.30	0.40	0.50	0.60	0.70	0.80	1.00	GRADE 18H8
3	4	10	0.01	0.02	0.03	0.04	0.05	0.06	0.07	0.08	0.09	0.10	0.15	0.20	0.30	0.40	0.50	0.60	0.70	0.80	1.00	GRADE 18H9
4	10	18	0.01	0.02	0.03	0.04	0.05	0.06	0.07	0.08	0.09	0.10	0.15	0.20	0.30	0.40	0.50	0.60	0.70	0.80	1.00	GRADE 18H10
5	18	30	0.01	0.02	0.03	0.04	0.05	0.06	0.07	0.08	0.09	0.10	0.15	0.20	0.30	0.40	0.50	0.60	0.70	0.80	1.00	GRADE 18H11
6	30	50	0.01	0.02	0.03	0.04	0.05	0.06	0.07	0.08	0.09	0.10	0.15	0.20	0.30	0.40	0.50	0.60	0.70	0.80	1.00	GRADE 18H12
7	50	80	0.01	0.02	0.03	0.04	0.05	0.06	0.07	0.08	0.09	0.10	0.15	0.20	0.30	0.40	0.50	0.60	0.70	0.80	1.00	GRADE 18H13
8	80	120	0.01	0.02	0.03	0.04	0.05	0.06	0.07	0.08	0.09	0.10	0.15	0.20	0.30	0.40	0.50	0.60	0.70	0.80	1.00	GRADE 18H14
9	120	180	0.01	0.02	0.03	0.04	0.05	0.06	0.07	0.08	0.09	0.10	0.15	0.20	0.30	0.40	0.50	0.60	0.70	0.80	1.00	GRADE 18H15
10	180	250	0.01	0.02	0.03	0.04	0.05	0.06	0.07	0.08	0.09	0.10	0.15	0.20	0.30	0.40	0.50	0.60	0.70	0.80	1.00	GRADE 18H16
11	250	315	0.01	0.02	0.03	0.04	0.05	0.06	0.07	0.08	0.09	0.10	0.15	0.20	0.30	0.40	0.50	0.60	0.70	0.80	1.00	GRADE 18H17
12	315	400	0.01	0.02	0.03	0.04	0.05	0.06	0.07	0.08	0.09	0.10	0.15	0.20	0.30	0.40	0.50	0.60	0.70	0.80	1.00	GRADE 18H18
13	400	500	0.01	0.02	0.03	0.04	0.05	0.06	0.07	0.08	0.09	0.10	0.15	0.20	0.30	0.40	0.50	0.60	0.70	0.80	1.00	GRADE 18H19
14	500	630	0.01	0.02	0.03	0.04	0.05	0.06	0.07	0.08	0.09	0.10	0.15	0.20	0.30	0.40	0.50	0.60	0.70	0.80	1.00	GRADE 18H20
15	630	800	0.01	0.02	0.03	0.04	0.05	0.06	0.07	0.08	0.09	0.10	0.15	0.20	0.30	0.40	0.50	0.60	0.70	0.80	1.00	GRADE 18H21
16	800	1000	0.01	0.02	0.03	0.04	0.05	0.06	0.07	0.08	0.09	0.10	0.15	0.20	0.30	0.40	0.50	0.60	0.70	0.80	1.00	GRADE 18H22
17	1000	1250	0.01	0.02	0.03	0.04	0.05	0.06	0.07	0.08	0.09	0.10	0.15	0.20	0.30	0.40	0.50	0.60	0.70	0.80	1.00	GRADE 18H23
18	1250	1600	0.01	0.02	0.03	0.04	0.05	0.06	0.07	0.08	0.09	0.10	0.15	0.20	0.30	0.40	0.50	0.60	0.70	0.80	1.00	GRADE 18H24
19	1600	2000	0.01	0.02	0.03	0.04	0.05	0.06	0.07	0.08	0.09	0.10	0.15	0.20	0.30	0.40	0.50	0.60	0.70	0.80	1.00	GRADE 18H25
20	2000	2500	0.01	0.02	0.03	0.04	0.05	0.06	0.07	0.08	0.09	0.10	0.15	0.20	0.30	0.40	0.50	0.60	0.70	0.80	1.00	GRADE 18H26
21	2500	3150	0.01	0.02	0.03	0.04	0.05	0.06	0.07	0.08	0.09	0.10	0.15	0.20	0.30	0.40	0.50	0.60	0.70	0.80	1.00	GRADE 18H27

TO CHOOSE IT GRADE FOR MANUFACTURING AND MAJOR STEPS TO BE FOLLOWED IN ISO 286-1 STANDARD CHART EXPLAINED WITH EXAMPLES

Standard Engineering Tolerance Chart

**Thirumalaisamy P.
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