

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																		
	ABOVE	UP TO																			TOLERANCES																	
																					MICROMETERS (µm)									MILLIMETERS (mm)								
1	-	3	0.8	1.2	2	3	4	6	10	14	20	30	40	60	0.1	0.14	0.2	0.3	0.5	0.8	ORANGE LIGHT																	
2	3	4	1	1.5	2.5	4	5	8	12	18	26	40	50	75	0.12	0.18	0.3	0.45	0.75	1.2	1.8	AGU'S LIGHT																
3	4	10	1	1.5	2.5	4	6	9	15	22	36	50	80	0.15	0.22	0.36	0.50	0.9	1.5	2.2	PURPLE LIGHT																	
4	10	18	1.2	2	3	5	8	12	18	27	43	70	110	0.18	0.27	0.43	0.7	1.1	1.8	2.7	ORANGE GREEN																	
5	18	30	1.5	2.5	4	6	9	15	23	35	54	84	130	0.21	0.33	0.51	0.84	1.3	2.1	3.3	RED LIGHT																	
6	30	60	1.5	2.5	4	7	11	18	28	42	63	96	144	0.25	0.38	0.57	1	1.6	2.5	3.8	RED LIGHT																	
7	60	90	2	3	5	8	13	20	30	45	68	100	150	0.3	0.45	0.68	1.2	1.8	3	4.5	DARK RED																	
8	90	120	2.5	4	6	10	15	23	35	52	78	115	170	0.36	0.54	0.81	1.4	2.2	3.6	5.4	PAN DARKER																	
9	120	180	3.5	5	8	13	18	28	40	60	90	135	200	0.45	0.68	1	1.6	2.5	4	6.3	ORANGE LIGHT																	
10	180	250	4.5	7	10	16	22	33	46	70	105	155	230	0.54	0.81	1.21	1.81	2.8	4.5	7.2	AGU'S LIGHT																	
11	250	315	6	8	12	18	25	37	52	80	120	180	270	0.63	0.95	1.4	2.1	3.2	5.2	8.1	PURPLE LIGHT																	
12	315	400	7	9	14	18	28	38	54	81	120	180	270	0.75	1.13	1.6	2.3	3.5	5.4	8.3	ORANGE GREEN																	
13	400	500	8	10	16	20	30	42	60	87	126	189	280	0.9	1.35	1.9	2.8	4	6.3	9.2	RED LIGHT																	
14	500	630	9	11	18	23	34	48	68	100	145	215	320	0.9	1.3	1.9	2.8	4.2	7	11	RED LIGHT																	
15	630	800	10	13	18	25	36	50	70	100	145	210	310	1.1	1.6	2.2	3.2	5	8	12.5	DARK RED																	
16	800	1000	12	15	21	28	40	55	75	105	150	210	300	1.2	1.8	2.5	3.6	5.4	9	14	PAN DARKER																	
17	1000	1250	14	18	25	33	47	64	88	125	175	250	350	1.5	2.25	3.4	4.7	6.8	10.5	16.5	ORANGE LIGHT																	
18	1250	1600	15	21	28	38	52	70	95	130	185	260	360	1.6	2.4	3.5	5	7.2	11.5	17.5	AGU'S LIGHT																	
19	1600	2000	18	25	33	45	60	80	110	150	210	290	400	1.8	2.7	3.9	5.4	8.1	12	18	PURPLE LIGHT																	
20	2000	2500	22	30	40	55	75	100	135	185	260	360	500	2.2	3.3	4.6	6.3	9	13	20	ORANGE GREEN																	
21	2500	3150	26	35	48	65	88	120	165	225	310	430	600	2.6	3.9	5.4	7.5	11.5	16	25	RED LIGHT																	

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

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