

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

Hugh Graham Conway



Standard Engineering Tolerance Chart:

Professional Memoirs, Corps of Engineers, United States Army and Engineer Department at Large, 1918

Engineering Tolerances Hugh Graham Conway, 1966 **The Military Engineer**, 1918 Directory of members

constitution and by laws of the Society of American military engineers 1935 inserted in v 27 *Innovative Control Charting*
Stephen A. Wise, Douglas C. Fair, 2006-06-30 Designed for the quality professional with a basic understanding of traditional SPC this book presents solutions for the problems encountered when trying to apply traditional control charting techniques in a complex manufacturing environment Anyone using SPC who has felt limited by its traditional methods will find this book timely and beneficial Along with basic SPC topics such as control chart theories process capability studies data collection strategies and sampling this book concentrates on describing tools which solve the limitations of traditional SPC techniques Specifically designed for those who face the challenges of limited data collection opportunities small production runs multiple characteristics and demanding manufacturing situations *Innovative Control Charting* will become a favorite modern SPC reference Benefits Discover how SPC can be effectively applied even with complex parts numerous part dimensions similar but different characteristics and small lot sizes Learn how to overcome the three main limitations of traditional SPC techniques Explore new SPC techniques in a step by step analysis approach using real life examples **Handbook**
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