

# 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															COLOR CODE					
			MICROMETERS (µm)							MILLIMETERS (mm)													
1	-	3	0.8	1.2	2	3	4	6	10	14	20	30	40	60	0.1	0.14	0.21	0.3	0.4	1	1.4	ORANGE LIGHT	
2	3	4	1	1.5	2.5	4	5	8	12	18	26	40	50	75	0.12	0.18	0.24	0.36	0.5	0.7	1.8	1.8	AGU A 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	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	2.7	ORANGE GREEN	
5	18	30	1.5	2.5	4	6	9	15	23	35	52	84	140	0.21	0.33	0.52	0.84	1.3	2.1	3.3	3.3	RED LIGHT	
6	30	50	1.5	2.5	4	7	11	18	28	42	63	100	160	0.25	0.38	0.63	1	1.6	2.5	3.8	3.8	RED LIGHT	
7	50	80	2	3	5	8	13	20	30	45	70	110	180	0.3	0.45	0.7	1.1	1.8	3	4.5	4.5	DARK RED	
8	80	120	2.5	4	6	10	16	25	38	58	87	140	220	0.36	0.54	0.87	1.4	2.2	3.6	5.4	5.4	PAN DARKER	
9	120	180	3.5	5	8	12	18	28	40	63	100	160	250	0.4	0.6	1	1.6	2.5	4	6.3	6.3	ORANGE LIGHT	
10	180	250	4.5	7	10	16	24	36	50	75	110	180	280	0.48	0.72	1.1	1.8	2.8	4.8	7.2	7.2	AGU A LIGHT	
11	250	315	6	8	12	18	27	40	55	80	120	180	280	0.52	0.78	1.2	2.1	3.2	5.2	7.8	7.8	PURPLE LIGHT	
12	315	400	7	9	14	20	30	45	60	85	140	210	300	0.57	0.85	1.4	2.3	3.5	5.7	8.5	8.5	ORANGE GREEN	
13	400	500	8	10	16	24	36	54	72	105	160	250	400	0.63	0.95	1.55	2.5	4	6.3	9.5	9.5	RED LIGHT	
14	500	630	9	11	18	27	40	60	80	120	175	280	450	0.7	1.1	1.75	2.8	4.5	7	11	11	RED LIGHT	
15	630	800	10	13	20	30	45	70	95	140	200	300	500	0.8	1.25	2	3.2	5	8	12.5	12.5	DARK RED	
16	800	1000	12	15	24	36	54	80	110	160	230	350	600	0.9	1.4	2.3	3.6	5.4	9	14	14	PAN DARKER	
17	1000	1250	14	18	28	42	63	90	125	180	260	400	600	1.05	1.55	2.4	3.7	5.6	10.5	15.5	15.5	ORANGE LIGHT	
18	1250	1600	15	20	30	45	68	95	135	190	280	450	700	1.25	1.85	2.8	4	6	12.5	18.5	18.5	AGU A LIGHT	
19	1600	2000	18	25	36	54	80	110	160	230	350	550	850	1.5	2.2	3.2	4	6.2	15	22	22	PURPLE LIGHT	
20	2000	2500	22	30	45	68	95	140	200	280	400	600	1000	1.75	2.6	3.8	5	7.5	17.5	26	26	ORANGE GREEN	
21	2500	3150	26	36	54	80	110	160	230	330	500	750	1100	2.1	3.2	4.5	6.3	9.5	21	31	31	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

**W. H. Clobberly, Ramon Bakerjian**



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## **Table of Contents Standard Engineering Tolerance Chart**

1. Understanding the eBook Standard Engineering Tolerance Chart
  - The Rise of Digital Reading Standard Engineering Tolerance Chart
  - Advantages of eBooks Over Traditional Books
2. Identifying Standard Engineering Tolerance Chart
  - Exploring Different Genres
  - Considering Fiction vs. Non-Fiction
  - Determining Your Reading Goals
3. Choosing the Right eBook Platform
  - Popular eBook Platforms
  - Features to Look for in an Standard Engineering Tolerance Chart
  - User-Friendly Interface

4. Exploring eBook Recommendations from Standard Engineering Tolerance Chart
  - Personalized Recommendations
  - Standard Engineering Tolerance Chart User Reviews and Ratings
  - Standard Engineering Tolerance Chart and Bestseller Lists
5. Accessing Standard Engineering Tolerance Chart Free and Paid eBooks
  - Standard Engineering Tolerance Chart Public Domain eBooks
  - Standard Engineering Tolerance Chart eBook Subscription Services
  - Standard Engineering Tolerance Chart Budget-Friendly Options
6. Navigating Standard Engineering Tolerance Chart eBook Formats
  - ePub, PDF, MOBI, and More
  - Standard Engineering Tolerance Chart Compatibility with Devices
  - Standard Engineering Tolerance Chart Enhanced eBook Features
7. Enhancing Your Reading Experience
  - Adjustable Fonts and Text Sizes of Standard Engineering Tolerance Chart
  - Highlighting and Note-Taking Standard Engineering Tolerance Chart
  - Interactive Elements Standard Engineering Tolerance Chart
8. Staying Engaged with Standard Engineering Tolerance Chart
  - Joining Online Reading Communities
  - Participating in Virtual Book Clubs
  - Following Authors and Publishers Standard Engineering Tolerance Chart
9. Balancing eBooks and Physical Books Standard Engineering Tolerance Chart
  - Benefits of a Digital Library
  - Creating a Diverse Reading Collection Standard Engineering Tolerance Chart
10. Overcoming Reading Challenges
  - Dealing with Digital Eye Strain
  - Minimizing Distractions
  - Managing Screen Time
11. Cultivating a Reading Routine Standard Engineering Tolerance Chart
  - Setting Reading Goals Standard Engineering Tolerance Chart
  - Carving Out Dedicated Reading Time

12. Sourcing Reliable Information of Standard Engineering Tolerance Chart
  - Fact-Checking eBook Content of Standard Engineering Tolerance Chart
  - Distinguishing Credible Sources
13. Promoting Lifelong Learning
  - Utilizing eBooks for Skill Development
  - Exploring Educational eBooks
14. Embracing eBook Trends
  - Integration of Multimedia Elements
  - Interactive and Gamified eBooks

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