

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	50	1.5	2.5	4	7	11	18	28	43	67	100	150	0.25	0.38	0.57	1	1.6	2.5	3.8	RED LIGHT																	
7	50	80	2	3	5	8	13	20	30	45	70	100	150	0.3	0.45	0.7	1.1	1.8	3	4.5	DARK RED																	
8	80	120	2.5	4	6	10	16	25	38	58	87	130	200	0.35	0.54	0.81	1.4	2.2	3.5	5.4	PAN DARKER																	
9	120	180	3.5	5	8	12	18	28	40	63	90	130	200	0.4	0.63	1	1.6	2.5	4	6.3	ORANGE LIGHT																	
10	180	250	4.5	7	10	16	25	38	56	84	120	180	250	0.45	0.72	1.1	1.8	2.8	4.5	7.2	AGU'S LIGHT																	
11	250	315	6	8	12	18	28	42	63	90	130	200	300	0.52	0.81	1.3	2.1	3.2	5.2	8.1	PURPLE LIGHT																	
12	315	400	7	9	14	20	30	45	67	99	140	210	300	0.57	0.85	1.4	2.3	3.5	5.7	8.5	ORANGE GREEN																	
13	400	500	8	10	16	25	37	55	83	125	180	260	400	0.63	0.95	1.55	2.5	4	6.3	9.5	RED LIGHT																	
14	500	630	9	11	18	27	42	63	95	140	210	300	450	0.7	1.1	1.75	2.8	4.5	7	11	RED LIGHT																	
15	630	800	10	13	20	30	45	70	105	150	220	320	500	0.8	1.25	2	3.2	5	8	12.5	DARK RED																	
16	800	1000	12	15	25	36	54	80	120	180	260	400	600	0.9	1.4	2.3	3.6	5.4	9	14	PAN DARKER																	
17	1000	1250	14	18	28	42	63	94	140	210	300	450	700	1.05	1.55	2.4	3.7	5.6	10.5	15.5	ORANGE LIGHT																	
18	1250	1600	15	20	30	45	70	105	150	220	320	500	750	1.25	1.95	3.1	5	7.5	12.5	19.5	AGU'S LIGHT																	
19	1600	2000	18	25	36	54	80	120	180	260	400	600	900	1.5	2.3	3.7	6	9	15	23	PURPLE LIGHT																	
20	2000	2500	22	30	45	67	100	150	220	320	480	700	1000	1.75	2.6	4.2	7	11	17.5	26	ORANGE GREEN																	
21	2500	3150	26	36	54	80	120	180	260	380	560	800	1150	2.1	3.2	5.1	8.5	12.5	21	32	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

Thomas J. Drozda



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