

# 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	0.012	0.015	0.018	0.025	0.030	0.036	0.045	0.054	0.063	0.075	0.090	0.108	0.135	0.160	0.180	0.210	0.250	0.300	0.360	ORANGE LIGHT
2	3	6	0.015	0.020	0.025	0.030	0.036	0.045	0.054	0.063	0.075	0.090	0.108	0.135	0.160	0.180	0.210	0.250	0.300	0.360	ORANGE LIGHT	
3	6	18	0.020	0.025	0.030	0.036	0.045	0.054	0.063	0.075	0.090	0.108	0.135	0.160	0.180	0.210	0.250	0.300	0.360	0.450	PURPLE LIGHT	
4	18	30	0.025	0.030	0.036	0.045	0.054	0.063	0.075	0.090	0.108	0.135	0.160	0.180	0.210	0.250	0.300	0.360	0.450	0.600	ORANGE GREEN	
5	30	60	0.030	0.036	0.045	0.054	0.063	0.075	0.090	0.108	0.135	0.160	0.180	0.210	0.250	0.300	0.360	0.450	0.600	0.900	RED LIGHT	
6	60	180	0.036	0.045	0.054	0.063	0.075	0.090	0.108	0.135	0.160	0.180	0.210	0.250	0.300	0.360	0.450	0.600	0.900	1.500	RED LIGHT	
7	180	300	0.045	0.054	0.063	0.075	0.090	0.108	0.135	0.160	0.180	0.210	0.250	0.300	0.360	0.450	0.600	0.900	1.500	2.500	DARK RED	
8	300	1000	0.054	0.063	0.075	0.090	0.108	0.135	0.160	0.180	0.210	0.250	0.300	0.360	0.450	0.600	0.900	1.500	2.500	4.000	RED DARKER	
9	1000	1800	0.063	0.075	0.090	0.108	0.135	0.160	0.180	0.210	0.250	0.300	0.360	0.450	0.600	0.900	1.500	2.500	4.000	6.300	ORANGE LIGHT	
10	1800	3000	0.075	0.090	0.108	0.135	0.160	0.180	0.210	0.250	0.300	0.360	0.450	0.600	0.900	1.500	2.500	4.000	6.300	10.000	ORANGE LIGHT	
11	3000	10000	0.090	0.108	0.135	0.160	0.180	0.210	0.250	0.300	0.360	0.450	0.600	0.900	1.500	2.500	4.000	6.300	10.000	16.000	PURPLE LIGHT	
12	10000	18000	0.108	0.135	0.160	0.180	0.210	0.250	0.300	0.360	0.450	0.600	0.900	1.500	2.500	4.000	6.300	10.000	16.000	25.000	ORANGE GREEN	
13	18000	30000	0.135	0.160	0.180	0.210	0.250	0.300	0.360	0.450	0.600	0.900	1.500	2.500	4.000	6.300	10.000	16.000	25.000	40.000	RED LIGHT	
14	30000	100000	0.160	0.180	0.210	0.250	0.300	0.360	0.450	0.600	0.900	1.500	2.500	4.000	6.300	10.000	16.000	25.000	40.000	63.000	RED LIGHT	
15	100000	180000	0.180	0.210	0.250	0.300	0.360	0.450	0.600	0.900	1.500	2.500	4.000	6.300	10.000	16.000	25.000	40.000	63.000	100.000	DARK RED	
16	180000	300000	0.210	0.250	0.300	0.360	0.450	0.600	0.900	1.500	2.500	4.000	6.300	10.000	16.000	25.000	40.000	63.000	100.000	160.000	RED DARKER	
17	300000	1000000	0.250	0.300	0.360	0.450	0.600	0.900	1.500	2.500	4.000	6.300	10.000	16.000	25.000	40.000	63.000	100.000	160.000	250.000	ORANGE LIGHT	
18	1000000	1800000	0.300	0.360	0.450	0.600	0.900	1.500	2.500	4.000	6.300	10.000	16.000	25.000	40.000	63.000	100.000	160.000	250.000	400.000	ORANGE LIGHT	
19	1800000	3000000	0.360	0.450	0.600	0.900	1.500	2.500	4.000	6.300	10.000	16.000	25.000	40.000	63.000	100.000	160.000	250.000	400.000	630.000	PURPLE LIGHT	
20	3000000	10000000	0.450	0.600	0.900	1.500	2.500	4.000	6.300	10.000	16.000	25.000	40.000	63.000	100.000	160.000	250.000	400.000	630.000	1000.000	ORANGE GREEN	
21	10000000	18000000	0.600	0.900	1.500	2.500	4.000	6.300	10.000	16.000	25.000	40.000	63.000	100.000	160.000	250.000	400.000	630.000	1000.000	1600.000	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

**Shasha Hu**



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