

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-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	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	52	84	130	0.21	0.33	0.52	0.84	1.3	2.1	3.3	RED LIGHT																	
6	30	50	1.5	2.5	4	7	11	16	25	38	57	90	140	0.25	0.38	0.57	1	1.6	2.5	3.8	RED LIGHT																	
7	50	80	2	3	5	8	12	18	28	42	64	100	150	0.3	0.45	0.64	1.2	1.8	3	4.5	DARK RED																	
8	80	120	2.5	4	6	10	15	22	35	54	82	120	180	0.36	0.54	0.82	1.6	2.2	3.6	5.4	PAN DARKER																	
9	120	180	3.5	5	8	12	18	28	40	63	95	150	220	0.45	0.63	1	1.6	2.5	4	6.3	ORANGE LIGHT																	
10	180	250	4.5	7	10	14	20	30	45	70	105	160	250	0.60	0.9	1.35	1.8	2.8	4.5	7.2	AGU-A LIGHT																	
11	250	315	6	8	12	16	23	32	47	70	105	160	250	0.80	1.2	1.8	2.5	3.7	5.7	8.5	PURPLE LIGHT																	
12	315	400	7	9	14	18	26	36	52	75	110	160	250	0.90	1.35	2.0	2.8	4.2	6.3	9.0	ORANGE GREEN																	
13	400	500	8	10	15	20	28	40	56	80	115	170	260	1.00	1.5	2.2	3.0	4.5	6.8	10.0	RED LIGHT																	
14	500	630	9	11	16	22	30	42	60	85	125	180	270	1.10	1.6	2.3	3.2	4.8	7.2	11	RED LIGHT																	
15	630	800	10	12	18	25	35	50	70	100	140	200	300	1.20	1.8	2.7	3.6	5.4	8.1	12	DARK RED																	
16	800	1000	12	15	22	30	42	60	85	120	170	240	360	1.40	2.1	3.0	4.2	6.0	9	14	PAN DARKER																	
17	1000	1250	14	18	26	35	48	68	95	135	190	270	400	1.60	2.4	3.6	5.0	7.2	10.5	15	ORANGE LIGHT																	
18	1250	1600	16	21	30	40	55	75	105	150	210	300	450	1.80	2.7	4.0	5.5	8.0	12	18	AGU-A LIGHT																	
19	1600	2000	18	25	35	48	65	90	125	180	250	360	540	2.00	3.0	4.5	6.3	9.0	13	21	PURPLE LIGHT																	
20	2000	2500	20	30	42	55	75	105	150	210	300	450	700	2.20	3.3	4.8	6.6	9.0	13.5	18	ORANGE GREEN																	
21	2500	3150	25	35	50	65	90	125	180	250	360	540	800	2.50	3.8	5.4	7.5	10.5	15	21	RED LIGHT																	

TO CHOOSE IT GRADE FOR MANUFACTURING AND MAJOR STEPS TO BE FOLLOWED IN ISO 286-1 STANDARD CHART EXPLAINED WITH EXAMPLES

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