

# 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	0.75	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	0.450	AGY 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	0.600	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	0.900	GRY 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	1.500	RED LIGHT
6	60	120	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	2.500	BLK LIGHT
7	120	240	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	4.000	DRK BLK
8	240	480	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	6.000	YLN DRK GR
9	480	960	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	6.000	10.000	ORANGE LIGHT
10	960	1920	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	6.000	10.000	15.000	AGY LIGHT
11	1920	3840	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	6.000	10.000	15.000	25.000	PURPLE LIGHT
12	3840	7680	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	6.000	10.000	15.000	25.000	40.000	GRY GREEN
13	7680	15360	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	6.000	10.000	15.000	25.000	40.000	60.000	RED LIGHT
14	15360	30720	0.160	0.180	0.210	0.250	0.300	0.360	0.450	0.600	0.900	1.500	2.500	4.000	6.000	10.000	15.000	25.000	40.000	60.000	90.000	BLK LIGHT
15	30720	61440	0.180	0.210	0.250	0.300	0.360	0.450	0.600	0.900	1.500	2.500	4.000	6.000	10.000	15.000	25.000	40.000	60.000	90.000	150.000	DRK BLK
16	61440	122880	0.210	0.250	0.300	0.360	0.450	0.600	0.900	1.500	2.500	4.000	6.000	10.000	15.000	25.000	40.000	60.000	90.000	150.000	250.000	YLN DRK GR
17	122880	245760	0.250	0.300	0.360	0.450	0.600	0.900	1.500	2.500	4.000	6.000	10.000	15.000	25.000	40.000	60.000	90.000	150.000	250.000	400.000	ORANGE LIGHT
18	245760	491520	0.300	0.360	0.450	0.600	0.900	1.500	2.500	4.000	6.000	10.000	15.000	25.000	40.000	60.000	90.000	150.000	250.000	400.000	600.000	AGY LIGHT
19	491520	983040	0.360	0.450	0.600	0.900	1.500	2.500	4.000	6.000	10.000	15.000	25.000	40.000	60.000	90.000	150.000	250.000	400.000	600.000	900.000	PURPLE LIGHT
20	983040	1966080	0.450	0.600	0.900	1.500	2.500	4.000	6.000	10.000	15.000	25.000	40.000	60.000	90.000	150.000	250.000	400.000	600.000	900.000	1500.000	GRY GREEN
21	1966080	3932160	0.600	0.900	1.500	2.500	4.000	6.000	10.000	15.000	25.000	40.000	60.000	90.000	150.000	250.000	400.000	600.000	900.000	1500.000	2500.000	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

**Wolfgang Guggemos**



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