

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	54	84	130	0.21	0.33	0.51	0.84	1.3	2.1	3.3	RED LIGHT																	
6	30	60	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	60	90	2	3	5	8	13	20	30	45	70	100	150	0.3	0.45	0.7	1.2	1.8	3	4.5	DARK RED																	
8	90	120	2.5	4	6	10	15	23	35	54	84	130	200	0.36	0.54	0.81	1.4	2.2	3.6	5.4	PAN DARKER																	
9	120	180	3.5	5	8	12	18	28	40	63	100	150	250	0.45	0.68	1	1.6	2.5	4	6.3	ORANGE LIGHT																	
10	180	250	4.5	7	10	16	25	38	56	85	130	200	300	0.54	0.81	1.21	1.81	2.8	4.5	7.2	AGU-A LIGHT																	
11	250	315	6	9	12	18	28	42	63	95	140	210	320	0.63	0.95	1.4	2.1	3.2	4.8	9.5	PURPLE LIGHT																	
12	315	400	7	10	14	21	32	48	71	105	160	240	360	0.75	1.13	1.69	2.5	3.7	5.6	8.5	ORANGE GREEN																	
13	400	500	9	13	18	27	40	60	90	135	200	300	450	0.9	1.35	2.02	3	4.5	6.75	10.2	RED LIGHT																	
14	500	630	9	13	18	27	40	60	90	135	200	300	450	0.9	1.35	2.02	3	4.5	6.75	10.2	RED LIGHT																	
15	630	800	10	15	20	30	45	68	100	150	220	330	500	0.9	1.35	2	3	4.5	6.8	10	15	DARK RED																
16	800	1000	12	18	24	36	54	81	120	180	270	400	600	0.9	1.4	2.1	3.2	4.8	7.2	10.8	16	PAN DARKER																
17	1000	1250	14	20	28	42	63	95	140	210	320	480	700	1.05	1.58	2.36	3.5	5.2	7.7	11.5	17.2	ORANGE LIGHT																
18	1250	1600	15	21	29	44	66	100	150	220	330	500	750	1.2	1.8	2.7	4	6	9	13.5	20.2	AGU-A LIGHT																
19	1600	2000	18	25	35	52	78	115	170	250	370	550	800	1.5	2.2	3.3	5	7.5	11	16.5	24.3	PURPLE LIGHT																
20	2000	2500	22	30	42	63	95	140	210	320	480	700	1000	1.8	2.7	4	6	9	13.5	20.2	30	ORANGE GREEN																
21	2500	3150	26	36	50	74	110	160	240	360	540	800	1150	2.2	3.3	4.8	7	10.5	15.5	23	35	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

Rosina Ehmann



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