

# 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	-	3	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	0.90	ORANGE LIGHT
2	3	6	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	0.90	1.00	AGY LIGHT
3	6	18	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	0.90	1.00	1.20	PURPLE LIGHT
4	18	30	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	0.90	1.00	1.20	1.50	GRY GREEN
5	30	60	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	0.90	1.00	1.20	1.50	1.80	RED LIGHT
6	60	180	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	0.90	1.00	1.20	1.50	1.80	2.00	RED LIGHT
7	180	300	0.07	0.08	0.09	0.10	0.15	0.20	0.30	0.40	0.50	0.60	0.70	0.80	0.90	1.00	1.20	1.50	1.80	2.00	2.50	DARK RED
8	300	1000	0.08	0.09	0.10	0.15	0.20	0.30	0.40	0.50	0.60	0.70	0.80	0.90	1.00	1.20	1.50	1.80	2.00	2.50	3.00	PAN DARKER
9	1000	1800	0.10	0.15	0.20	0.30	0.40	0.50	0.60	0.70	0.80	0.90	1.00	1.20	1.50	1.80	2.00	2.50	3.00	3.60	4.00	ORANGE LIGHT
10	1800	3000	0.15	0.20	0.30	0.40	0.50	0.60	0.70	0.80	0.90	1.00	1.20	1.50	1.80	2.00	2.50	3.00	3.60	4.00	5.00	AGY LIGHT
11	3000	10000	0.20	0.30	0.40	0.50	0.60	0.70	0.80	0.90	1.00	1.20	1.50	1.80	2.00	2.50	3.00	3.60	4.00	5.00	6.00	PURPLE LIGHT
12	10000	18000	0.30	0.40	0.50	0.60	0.70	0.80	0.90	1.00	1.20	1.50	1.80	2.00	2.50	3.00	3.60	4.00	5.00	6.00	7.00	GRY GREEN
13	18000	30000	0.40	0.50	0.60	0.70	0.80	0.90	1.00	1.20	1.50	1.80	2.00	2.50	3.00	3.60	4.00	5.00	6.00	7.00	8.00	RED LIGHT
14	30000	100000	0.50	0.60	0.70	0.80	0.90	1.00	1.20	1.50	1.80	2.00	2.50	3.00	3.60	4.00	5.00	6.00	7.00	8.00	10.00	RED LIGHT
15	100000	180000	0.60	0.70	0.80	0.90	1.00	1.20	1.50	1.80	2.00	2.50	3.00	3.60	4.00	5.00	6.00	7.00	8.00	10.00	12.00	DARK RED
16	180000	300000	0.70	0.80	0.90	1.00	1.20	1.50	1.80	2.00	2.50	3.00	3.60	4.00	5.00	6.00	7.00	8.00	10.00	12.00	15.00	PAN DARKER
17	300000	1000000	0.80	0.90	1.00	1.20	1.50	1.80	2.00	2.50	3.00	3.60	4.00	5.00	6.00	7.00	8.00	10.00	12.00	15.00	18.00	ORANGE LIGHT
18	1000000	1800000	1.00	1.20	1.50	1.80	2.00	2.50	3.00	3.60	4.00	5.00	6.00	7.00	8.00	10.00	12.00	15.00	18.00	20.00	25.00	AGY LIGHT
19	1800000	3000000	1.20	1.50	1.80	2.00	2.50	3.00	3.60	4.00	5.00	6.00	7.00	8.00	10.00	12.00	15.00	18.00	20.00	25.00	30.00	PURPLE LIGHT
20	3000000	10000000	1.50	1.80	2.00	2.50	3.00	3.60	4.00	5.00	6.00	7.00	8.00	10.00	12.00	15.00	18.00	20.00	25.00	30.00	36.00	GRY GREEN
21	10000000	18000000	2.00	2.50	3.00	3.60	4.00	5.00	6.00	7.00	8.00	10.00	12.00	15.00	18.00	20.00	25.00	30.00	36.00	40.00	50.00	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

**RJ Alexander**



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