

ISO 286 Tolerances for stainless steel bar

TOLERANCES

~ The ISO tolerances shown are taken from ISO 286.

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REVISION HISTORY

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Diameters (mm)	Tolerance in mm for given Tolerance Number							
	6	7	8	9	10	11	12	13
> 1 – 3 inc.	0.007	0.009	0.014	0.025	0.040	0.060	0.090	0.140
> 3 – 6 inc.	0.008	0.012	0.018	0.030	0.048	0.075	0.120	0.180
> 6 – 10 inc.	0.009	0.015	0.022	0.036	0.058	0.090	0.150	0.220
> 10 – 18 inc.	0.011	0.018	0.027	0.043	0.070	0.110	0.180	0.270
> 18 – 30 inc.	0.013	0.021	0.033	0.052	0.084	0.130	0.210	0.330
> 30 – 50 inc.	0.016	0.025	0.039	0.062	0.100	0.160	0.250	0.390
> 50 – 80 inc.	0.019		0.046	0.074	0.120	0.190	0.300	0.460
> 80 – 120 inc.	0.022			0.087	0.140	0.220	0.350	0.540
> 120 – 180 inc.	0.025			0.100	0.160	0.250	0.400	0.630
> 180 – 250 inc.				0.115	0.185	0.290	0.460	0.720
> 250 – 315 inc.						0.320	0.520	0.810
> 315 – 400 inc.						0.360	0.570	0.890
> 400 – 500 inc..						0.400	0.630	0.970
> 500						0.440	0.700	1.100

EXAMPLES:

H = All Minus tolerance e.g. 45 mm dia **H9** = + 0 / - 0.062

J = Tolerance divided e.g. 45 mm dia **J9** = + / - 0.031

K = All Plus tolerance e.g. 45 mm dia **K9** = + 0.062 / - 0
The K tolerance is usually only applied to larger diameter bars (Over 75mm)

H8 = Precision Ground

H9 = Bright Drawn

H10 = Smooth Turned