

GAGEMAKER'S TOLERANCE CHART						
Above	To & Includ.	CL - XXX	CL - XX	CL - X	CL - Y	CL - Z
0.010" .254mm	0.825" 20.95mm	.000010 0.25um	.000020 0.5um	.000040 1.0um	.000070 1.75um	.0001 2.5um
0.825" 20.95mm	1.510" 38.35mm	.000015 0.38um	.000030 0.75um	.000060 1.5um	.000090 2.25um	.00012 3.0um
1.510" 38.35mm	2.510" 63.75mm	.000020 0.50um	.000040 1.0um	.000080 2.0um	.00012 3.0um	.00016 4.0um
2.510" 63.75mm	4.510" 114.55mm	.000025 0.63um	.000050 1.25um	.0001 2.5um	.00015 3.75um	.00020 5.0um
4.510" 114.5mm	6.510" 165.35mm	.000033 0.83um	.000065 1.625um	.00013 3.25um	.00019 4.75um	.00025 6.25um
6.510" 165.35mm	9.010" 228.85mm	.000040 1.00um	.000080 2.0um	.00016 4.0um	.00024 6.0um	.00032 8.0um
9.010" 228.85mm	12.010" 305.05mm	.000050 1.25um	.0001 2.5um	.0002 5.0um	.0003 7.5um	.0004 10um
12.010" 305.05mm	15.010" 381.25mm	.000075 1.88um	.00015 3.75um	.0003 7.5um	.00045 11.25um	.0006 15um
15.010" 381.25mm	18.010" 457.45mm	.0001 2.50um	.0002 5um	.0004 10um	.0006 15um	.00080 20um
18.010" 457.45mm	21.010" 533.65mm	.000125 3.13um	.00025 6.25um	.0005 12.5um	.00075 18.75um	.001 25um
21.010" 533.65mm	24.010" 609.85mm		.0003 7.5um	.0006 15um	.0009 23um	.0012 30um
24.010" 609.85mm	27.010" 686.05mm		.00035 8.9um	.0007 18um	.00105 27um	.0014 36um
27.010" 686.05mm	30.010" 762.25mm		.0004 10um	.0008 20um	.0012 30um	.0016 41um



STANDARD PLUG AND RING GAGE CLASSES FOR PRODUCT TOLERANCES

The chart of Product Tolerances for plain plug and ring gages may be used as a guide for recommended gage tolerance. This assumes a given product tolerance. Wear allowance and other similar concerns should be included when gage specifications are being defined. These are left for the user to determine. Plain plug gages normally use a plus tolerance to be considered "go" and a minus tolerance constitutes a "nogo" status. Ring gages normally use a minus tolerance to be considered "go" and a plus tolerance for "nogo". These descriptions are fitting with normal practice that allows 10% of the product tolerance to be equally divided between "go" and "nogo" conditions.

Product Tolerances	Class of Gage for Size Range			
	.010-.825	.825-1.510	1.510-2.510	2.510-4.510
.0002	XXX			
.0003	XXX			
.0004	XX	XX		
.0005	XX	XX		
.0006	XX	XX	XX	
.0007	X	XX	XX	
.0008	X	XX	XX	XX
.0009	X	XX	XX	XX
.0010	X	X	XX	XX
.0012	Y	X	XX	XX
.0014	Y	X	X	XX
.0016	Y	Y	X	X
.0018	Z	Y	X	X
.0020		Y	X	X
.0022		Z	Y	X
.0024			Y	X
.0026			Y	Y
.0028			Y	Y
.0030			Z	X
.0032				Y
.0034				Y
.0036				Z

Product Limits and Tolerances

