

ISO

INTERNATIONAL ORGANIZATION FOR STANDARDIZATION

ISO RECOMMENDATION R 286

ISO SYSTEM OF LIMITS AND FITS
PART I: GENERAL, TOLERANCES AND DEVIATIONS

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BRIEF HISTORY

The ISO Recommendation R 286, *ISO System of Limits and Fits—Part 1: General Tolerances and Deviations*, was drawn up by Technical Committee ISO/TC 3, *Limits and Fits*, the Secretariat of which is held by the Association Française de Normalisation (AFNOR).

Work on this question by the Technical Committee began in 1949, taking into account the studies which had been made by the former International Federation of the National Standardizing Associations (ISA), and led, in 1957, to the adoption of a Draft ISO Recommendation.

In January 1960, this Draft ISO Recommendation (No. 321) was circulated to all the ISO Member Bodies for enquiry. It was approved by the following Member Bodies:

Australia	Finland	Norway
Austria	France	Poland
Belgium	Germany	Romania
Brazil	Hungary	Spain
Bulgaria	India	Sweden
Burma	Italy	Switzerland
Chile	Japan	United Kingdom
Czechoslovakia	New Zealand	Yugoslavia

Three Member Bodies opposed the approval of the Draft:

Netherlands, Portugal, U.S.S.R.

The Draft ISO Recommendation was then submitted by correspondence to the ISO Council, which decided, in December 1962, to accept it as an ISO RECOMMENDATION.

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(see detailed summary at the beginning of the Appendix)

INTRODUCTORY NOTE

The values of the ISO System of Limits and Fits are expressed

in metric units, for countries using the metric system of measurement,
in inch units, for countries using the inch system of measurement.

The ISO System ensures complete fit interchangeability of parts manufactured to the same symbol in one or other of these systems of measurement. However, in view of the very slight numerical differences resulting from the conversion from millimetres into inches (see clause 2.4), it is recommended that checking instruments calibrated in the system of measurement in which the parts have been designed should be used, or that agreement should be reached between suppliers and customers on the choice of the system of measurement to be adopted for final inspection.

In the absence of any agreement to the contrary, the *values in metric units* will be taken as authoritative in case of dispute regarding the choice of the system of measurement which ought to have been adopted.

The same remarks apply in those borderline cases, an extremely rare class, in which the nominal size falls within one diameter range in one system of measurement and within the neighbouring range in the other system of measurement.

FOREWORD

The present ISO Recommendation, *ISO System of Limits and Fits, Part 1*, is based on the *ISA System of Limits and Fits* published in ISA Bulletin 25 (1940), and on comments included in the Draft Final Report of ISA Committee 3, December 1935.

This ISO Recommendation differs from the ISA System in its lay-out and in the following main items:

1. Inclusion of sizes below 1 mm for grades up to grade 13.
 2. Inclusion of the two grades 01 and 0 finer than grade 1.
 3. Inclusion of new shaft and hole deviations:

cd, CD, ef, EF, fg, FG	up to 10 mm only	for fine mechanisms and horology,
j _s and J _s		providing a complete range of symmetrical deviations for all diameter steps and all grades,*
za, ZA, zb, ZB, zc, ZC		for high interference fits.
 4. Amendments of some standard tolerances for fine grades and of some deviations to connect the existing values with those included in the above paragraphs. Numerical values amended with regard to those deriving from the former ISA System are framed in a bold line in Table 7, page 22, Tables 8 and 9, pages 23 to 26, and in the practical tables in the Appendix.
 5. Inclusion of Tables 7, 8 and 9, permitting the easy calculations of the deviations corresponding to any symbol through the whole range of diameter steps (upper and lower deviations).
- It should be noted, however, that this possibility does not involve the use of all symbols. Indeed, in addition to the exceptions mentioned above in point 3,
- shafts and holes a A, b B are provided only for sizes above 1 mm;
 - shafts j8 are provided only for sizes up to 3 mm;
 - holes K, in grades above 8, are provided only for sizes up to 3 mm;
 - shafts and holes t T, v V, y Y are provided only for sizes from 24, 14 and 18 mm respectively (since, below those sizes, they would only repeat adjoining symbols).

* The former deviations j and J have not in general been maintained in the fields where they were always symmetrical, since only deviations j_s and J_s are to be recommended for fits, for the sake of homogeneity. However, a few symmetrical deviations j and one symmetrical deviation J have been maintained in grades 6 and 7.

ISO SYSTEM OF LIMITS AND FITS

PART I: GENERAL, TOLERANCES AND DEVIATIONS *

1. GENERAL — SYMBOLS — DEFINITIONS

1.1 Scope of the ISO System

The ISO System of Limits and Fits relates to tolerances on plain parts or components and to the fits corresponding to their assembly.

For the sake of simplicity, and in view of the particular importance of cylindrical parts with circular section, only these are referred to explicitly. It should be clearly understood however that recommendations for this type of component apply equally well to other plain parts or components; in particular, the general term "hole" or "shaft" can be taken as referring to the space containing or contained by two parallel faces (or tangent planes) of any part, such as the width of a slot, the thickness of a key, etc.

1.2 Reference temperature

As indicated by ISO Recommendation R 1,** the standard reference temperature is 20°C for industrial measurements and, consequently, for dimensions defined by the System.

1.3 Tolerances of parts

Due mainly to the inevitable inaccuracy of manufacturing methods, a part cannot be made precisely to a given dimension but, in order to meet its purpose, it is sufficient that it should be made so as to lie within two permissible limits of size, the difference of which is the *tolerance*.

For the sake of convenience, a *basic size* is ascribed to the part and each of the two limits is defined by its *deviation* from this basic size. The magnitude and sign of the deviation are obtained by subtracting the basic size from the limit in question.

* This First Part relates only to the essential bases of the System, giving the prescribed limits of parts; it excludes all matters of inspection or metrology, which will be dealt with in Part II of the System, covered by another ISO Recommendation, at present under preparation.

** ISO Recommendation R 1, *Standard Reference Temperature for Industrial Length Measurements*.

Figure 1, which illustrates these definitions, is in practice replaced by a schematic diagram similar to Figure 2 for the sake of simplicity. In this simplified schematic diagram, the axis of the part, which is not represented, always lies, by convention, below the diagram. (In the example illustrated, the two deviations of the shaft are negative and those of the hole positive.)

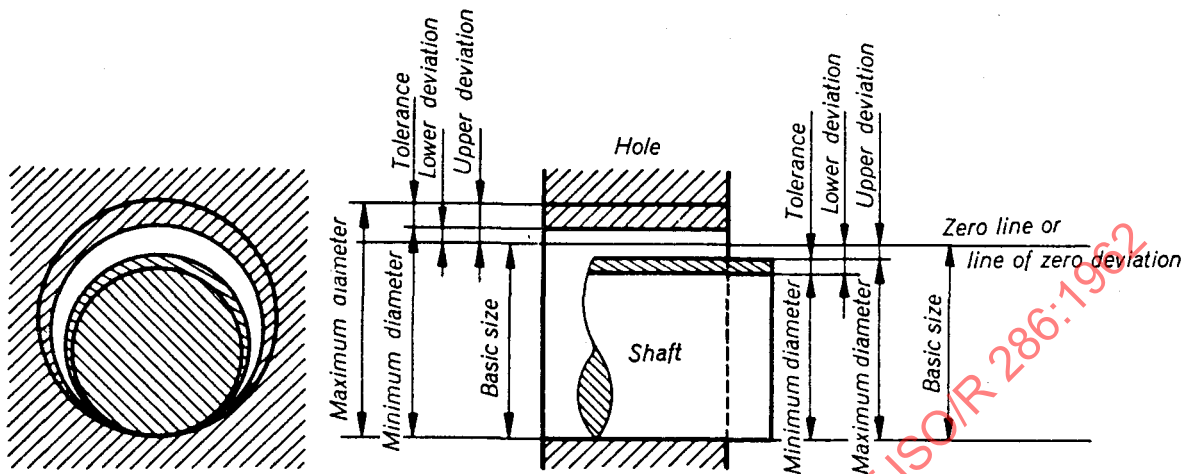


FIG. 1

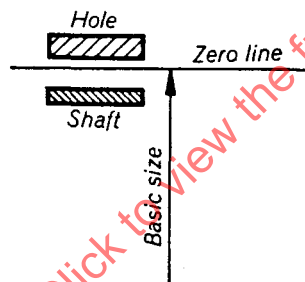


FIG. 2

1.3.1 Notation

The following notation is used in this document: *

Upper deviation of a hole	ES
Lower deviation of a hole	EI
Upper deviation of a shaft	es
Lower deviation of a shaft	ei

1.4 Fits

When two parts are to be assembled, the relation resulting from the difference between their sizes before assembly is called a *fit*.

Depending upon the respective positions of the tolerance zones of the hole or the shaft, the fit may be

- a *clearance fit*,
- a *transition fit* (i.e. such that the assembly may have either a clearance or an interference), or
- an *interference fit*.

Figure 1 above shows a clearance fit, and Figure 3, page 7, shows the schematic diagram of tolerance zones in various cases.

* However, it will be left to each country to adopt a notation more in accordance with its own language.

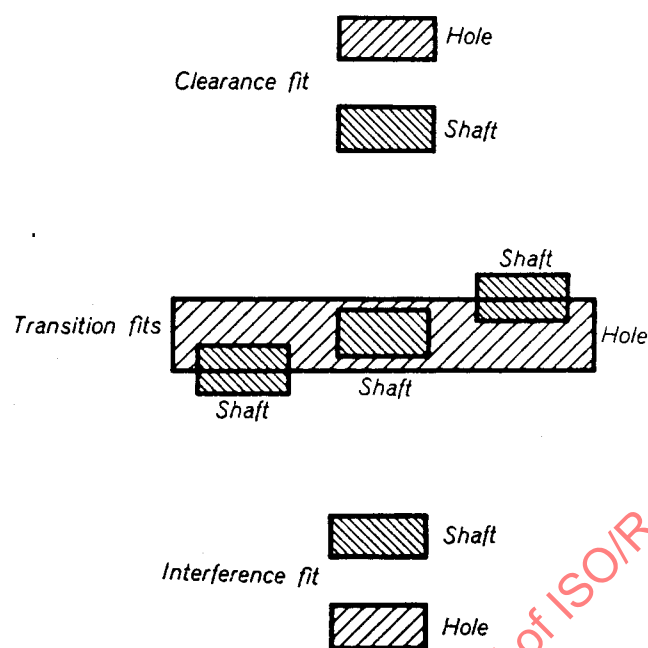


FIG. 3

Two of the most commonly used methods of applying the ISO System are the hole-basis system and the shaft-basis system (defined under No. 1.6.38 and No. 1.6.39 in clause 1.6, "Vocabulary"), which are shown in Figure 4 below.

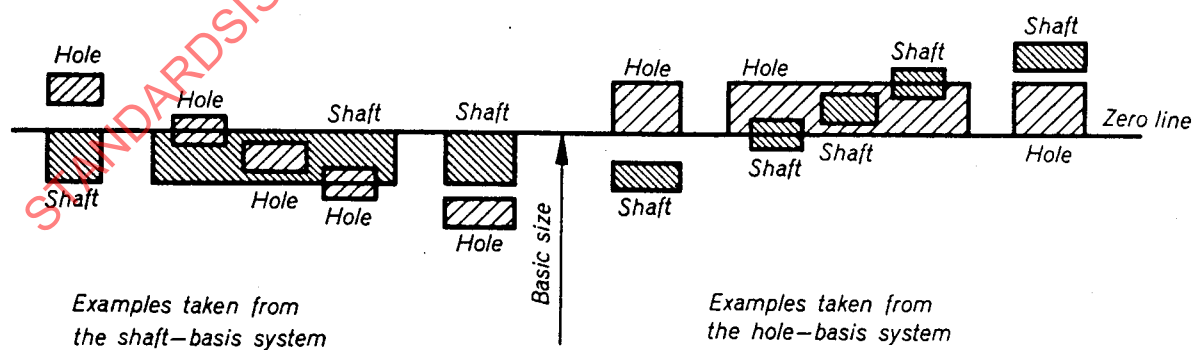


FIG. 4

1.5 Symbols for tolerances and deviations and symbols for fits

In order to satisfy the usual requirements both of individual parts and of fits, the System provides, for any given basic size, a whole range of tolerances together with a whole range of deviations defining the position of these tolerances with respect to the line of zero deviation, called the *zero line*.

The *tolerance*, the value of which is a function of the basic size, is designated by a number symbol, called the *grade*.

The *position of the tolerance zone* with respect to the zero line, which is a function of the basic size, is indicated by a letter symbol (in some cases, two letters), a capital letter for holes, a small letter for shafts (see Fig. 5).

The toleranced size is thus defined by its basic value followed by a "*symbol*" composed of a letter (in some cases, two letters) and a number.

Example: 45 g7.

A fit is indicated by the basic size common to both components, followed by symbol corresponding to each component, the hole being quoted first.

Example: 45 H8/g7 (possibly 45 H8-g7 or 45 $\frac{H8}{g7}$).

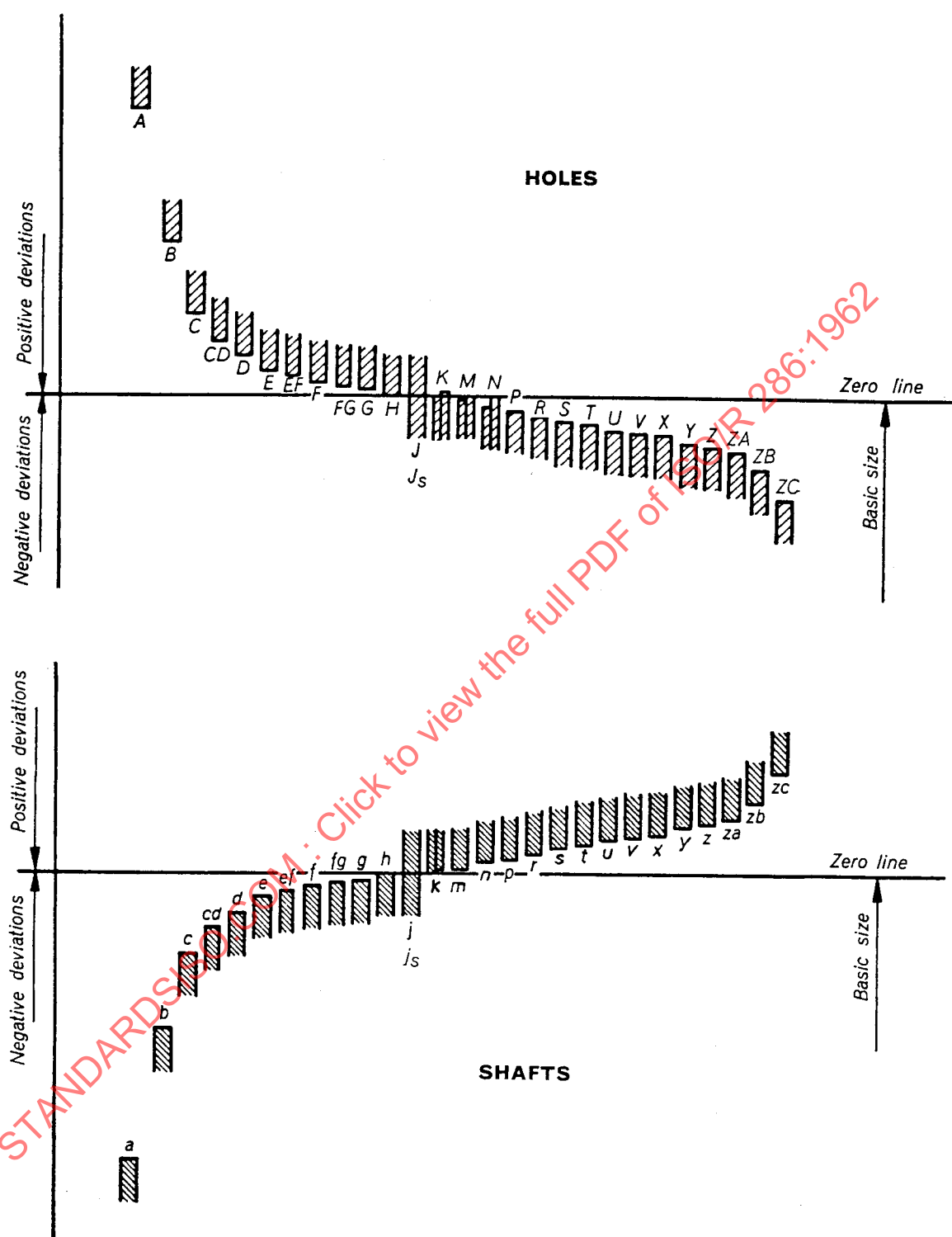
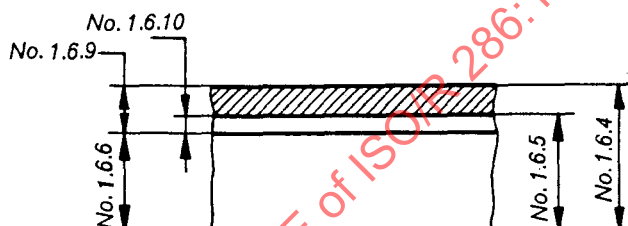


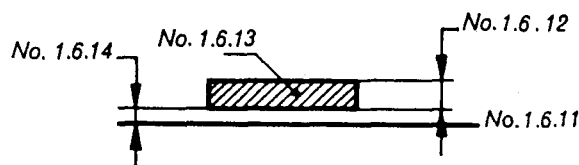
FIG. 5.—Respective positions of the various tolerance zones
for a given diameter step

1.6 Vocabulary *

- 1.6.1 *Size*.**—Number expressing in a particular unit the numerical value of a length. (In French, the size is named *cote*, when it is inscribed on a drawing.)
- 1.6.2 *Actual size (of a part)*.—Size as practically obtained (value which may be obtained by measurement; see Part II of ISO System of Limits and Fits).
- 1.6.3 *Limits of size*.—The two extreme permissible sizes of a part between which the actual size should lie, the limits of size being included.
- 1.6.4 *Maximum limit of size*.—The greater of the two limits of size.
- 1.6.5 *Minimum limit of size*.—The smaller of the two limits of size.
- 1.6.6 *Basic size*.—Size by reference to which the limits of size are fixed.
- 1.6.7 *Deviation*.—Algebraical difference between a size (actual, maximum, etc.) and the corresponding basic size.
- 1.6.8 *Actual deviation*.—Algebraical difference between the actual size and the corresponding basic size.
- 1.6.9 *Upper deviation*.—Algebraical difference between the maximum limit of size and the corresponding basic size.
- 1.6.10 *Lower deviation*.—Algebraical difference between the minimum limit of size and the corresponding basic size.



- 1.6.11 *Zero line*.—In a graphical representation of limits and fits, straight line to which the deviations are referred. The zero line is the line of zero deviation and represents the basic size.



By convention, when the zero line is drawn horizontally, positive deviations are shown above and negative deviations below it.

* It should be emphasized that some terms in the present vocabulary are defined, for the purposes of the ISO System of Limits and Fits, in a more restricted sense than that in common use.

** In particular, the word *size* is defined here as "size of a length" ("dimension linéaire" in French), and the corresponding French term "dimension" which, in current speech, has two meanings, corresponding respectively to the English terms "dimension" and "size", is here to be taken in the second sense only, viz. that of a numerical value.

- 1.6.12 Tolerance.**—Difference between the maximum limit of size and the minimum limit of size (or, in other words, algebraical difference between the upper deviation and the lower deviation).

The tolerance is an absolute value without sign.

- 1.6.13 Tolerance zone.**—In a graphical representation of tolerances, zone comprised between the two lines representing the limits of the tolerance and defined by its magnitude (tolerance) and by its position in relation to the zero line.

- 1.6.14 Fundamental deviation.**—That one of the two deviations which is conventionally chosen to define the position of the tolerance zone in relation to the zero line.

- 1.6.15 Grade of tolerance.**—In a standardized system of limits and fits, group of tolerances considered as corresponding to the same level of accuracy for all basic sizes.

- 1.6.16 Standard tolerance.**—In a standardized system of limits and fits, any tolerance belonging to the system.

- 1.6.17 Standard tolerance unit.**—In the ISO System of Limits and Fits, factor expressed only in terms of the basic size and used as a basis for the determination of the standard tolerances of the System. (Each tolerance is equal to the product of the value of the standard tolerance unit, for the considered basic size, by a coefficient corresponding to each grade of tolerance.)

- 1.6.18 Shaft.**—Term used by convention to designate all external features of a part, including parts which are not cylindrical.

- 1.6.19 Hole.**—Term used by convention to designate all internal features of a part, including parts which are not cylindrical.

- 1.6.20 Basic shaft.**—In the ISO System of Limits and Fits, shaft the upper deviation of which is zero.

More generally, shaft chosen as a basis for a shaft-basis system of fits (see No. 1.6.38).



- 1.6.21 Basic hole.**—In the ISO System of Limits and Fits, hole the lower deviation of which is zero.

More generally, hole chosen as a basis for a hole-basis system of fits (see No. 1.6.39).



- 1.6.22 Go limit.**—Designation applied to that of the two limits of size which corresponds to the maximum material condition, i.e.:

the upper limit of a shaft,
the lower limit of a hole.

(When limit gauges are used, this is the limit of size checked by the GO gauge.)

1.6.23 Not go limit.—Designation applied to that of the two limits of size which corresponds to the minimum material condition, i.e.:

the lower limit of a shaft,
the upper limit of a hole.

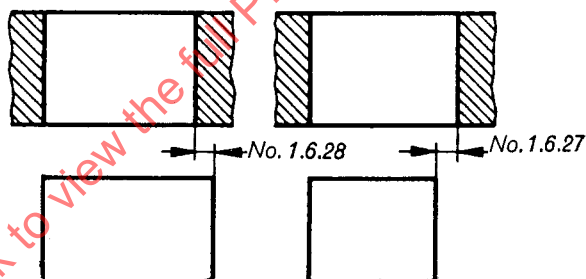
(When limit gauges are used, this is the limit of size checked by the NOT GO gauge.)

1.6.24 Fit.—Relationship resulting from the difference, before assembly, between the sizes of the two parts which are to be assembled.

1.6.25 Basic size (of a fit).—Common value of the basic size of the two parts of a fit.

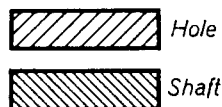
1.6.26 Variation of fit.—Arithmetical sum of the tolerances of the two mating parts of a fit.

1.6.27 Clearance.—Difference between the sizes of the hole and the shaft, before assembly, when this difference is positive.

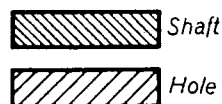


1.6.28 Interference.—Magnitude of the difference between the sizes of the hole and the shaft, before assembly, when this difference is negative.

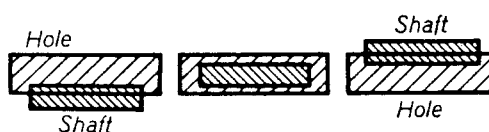
1.6.29 Clearance fit.—Fit which always provides a clearance. (The tolerance zone of the hole is entirely above that of the shaft.)



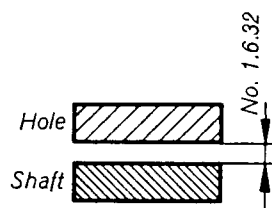
1.6.30 Interference fit.—Fit which always provides an interference. (The tolerance zone of the hole is entirely below that of the shaft.)



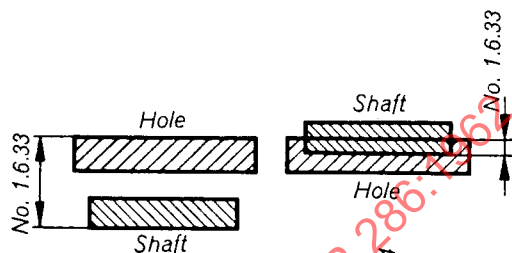
1.6.31 Transition fit.—Fit which may provide either a clearance or an interference. (The tolerance zones of the hole and the shaft overlap.)



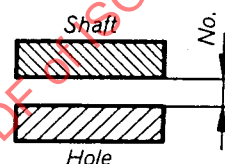
- 1.6.32 Minimum clearance.**—In a clearance fit, difference between the minimum size of the hole and the maximum size of the shaft.



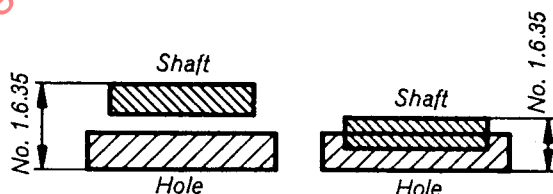
- 1.6.33 Maximum clearance.**—In a clearance or a transition fit, difference between the maximum size of the hole and the minimum size of the shaft.



- 1.6.34 Minimum interference.**—In an interference fit, magnitude of the (negative) difference between the maximum size of the hole and the minimum size of the shaft, before assembly.



- 1.6.35 Maximum interference.**—In an interference or a transition fit, magnitude of the (negative) difference between the minimum size of the hole and the maximum size of the shaft, before assembly.



- 1.6.36 Limit system.**—System of standardized tolerances and deviations.

- 1.6.37 Fit system.**—System of fits comprising shafts and holes belonging to a limit system.

- 1.6.38 Shaft-basis system of fits.**—System of fits in which the different clearances and interferences are obtained in associating various holes with a single shaft (or, possibly, with shafts of different grades, but having the same fundamental deviation).

In the ISO System, the basic shaft is the shaft the upper deviation of which is zero.

- 1.6.39 Hole-basis system of fits.**—System of fits in which the different clearances and interferences are obtained in associating various shafts with a single hole (or, possibly, with holes of different grades, but having always the same fundamental deviation).

In the ISO System, the basic hole is the hole the lower deviation of which is zero.

2. TOLERANCES AND DEVIATIONS FOR SIZES UP TO 500 mm (19.69 in)

2.1 Formulae for tolerances and deviations

2.1.1 Nominal diameter steps for metric and inch values

For the sake of simplicity, the formulae given in clauses 2.1.2 and 2.1.3 for the calculation of standard tolerances and fundamental deviations are applied to suit the diameter steps shown in Table 1 below; the results have been computed on the basis of the geometrical mean D of the extreme diameters of each step and apply to all diameters of this step.

For the whole of the step up to 3 mm (or 0.12 in), the average diameter is taken as the geometrical mean of 1 and 3 mm (or 0.04 and 0.12 in).

TABLE 1. — Nominal diameter steps

Nominal diameter steps							
Main steps				Intermediate steps *			
Millimetres		Inches		Millimetres		Inches	
above	up to	above	up to	above	up to	above	up to
—	3	—	0.12				
3	6	0.12	0.24				
6	10	0.24	0.40				
10	18	0.40	0.71	10	14	0.40	0.56
				14	18	0.56	0.71
18	30	0.71	1.19	18	24	0.71	0.95
				24	30	0.95	1.19
30	50	1.19	1.97	30	40	1.19	1.58
				40	50	1.58	1.97
50	80	1.97	3.15	50	65	1.97	2.56
				65	80	2.56	3.15
80	120	3.15	4.73	80	100	3.15	3.94
				100	120	3.94	4.73
120	180	4.73	7.09	120	140	4.73	5.52
				140	160	5.52	6.30
				160	180	6.30	7.09
180	250	7.09	9.85	180	200	7.09	7.88
				200	225	7.88	8.86
				225	250	8.86	9.85
250	315	9.85	12.41	250	280	9.85	11.03
				280	315	11.03	12.41
315	400	12.41	15.75	315	355	12.41	13.98
				355	400	13.98	15.75
400	500	15.75	19.69	400	450	15.75	17.72
				450	500	17.72	19.69

* These are used, in certain cases, when considered as necessary, for the deviations a to c and r to zc or A to C and R to ZC.

2.1.2 Standard tolerances

Eighteen grades of tolerance are provided, each corresponding to one of the tolerances, known as the standard tolerances and called IT 01, IT 0, IT 1 to IT 16, the numerical values of which are given, for each nominal diameter step, in Table 7, page 22.

2.1.2.1 FOR GRADES 5 TO 16, the values are determined from the tolerance unit i , as follows:

when i is expressed in microns for D expressed in millimetres,

$$i = 0.45 \sqrt[3]{D} + 0.001 D^*$$

when i is expressed in 0.001 in for D expressed in inches,

$$i = 0.052 \sqrt[3]{D} + 0.001 D$$

The values of the standard tolerances corresponding to grades 5 to 16 are given in Table 2 below, in terms of the tolerance unit i :

TABLE 2. — Values of standard tolerances corresponding to grades 5 to 16

	IT 5	IT 6	IT 7	IT 8	IT 9	IT 10	IT 11	IT 12	IT 13	IT 14	IT 15	IT 16
Values	7 i	10 i	16 i	25 i	40 i	64 i	100 i	160 i	250 i	400 i	640 i	1000 i

NOTE.—Above IT 6, the tolerance is multiplied by 10 at each fifth step. ** This rule applies also, if necessary, beyond IT 16.

2.1.2.2 FOR GRADES BELOW 5, the values are calculated as follows:

TABLE 3. — Values of standard tolerances corresponding to grades 01, 0 and 1

	IT 01	IT 0	IT 1
Values in microns for D in millimetres	0.3 + 0.008 D	0.5 + 0.012 D	0.8 + 0.020 D
Values in 0.001 in for D in inches	0.012 + 0.008 D	0.02 + 0.012 D	0.03 + 0.020 D

NOTE.—The values IT 2 to IT 4 have been scaled approximately geometrically between the values of IT 1 and IT 5 (see Table 7, page 22).

* This formula has been empirically calculated on the basis of former national standards and taking account of the fact that, for the same manufacturing conditions, the relationship between the values of the manufacturing errors and the diameter is approximately a parabolic function.

** But for one exception : the value 7.5 is rounded off to 8 for grade 6 in the diameter step above 3 up to 6 mm.

2.1.3 Fundamental deviations

Based on experiments, formulae had been accepted for the ISA System and admitted as satisfactory; these formulae, indicated in clauses 2.1.3.1 and 2.1.3.2, permit the calculation of the fundamental deviation for each case.

2.1.3.1 SHAFTS

For each letter symbol defining the position of the tolerance zone, the magnitude and sign of one of the two deviations, which is known as the fundamental deviation (upper deviation e_s or lower deviation e_i) (see Fig. 1, page 6), are determined by means of the formulae in Table 4, page 18.

The other deviation is derived from the first one, using the magnitude of the standard tolerance IT , by means of the following algebraic relationship:

$$\begin{aligned} e_i &= e_s - IT \quad \text{or} \\ e_s &= e_i + IT \end{aligned}$$

It will be noted that

- (1) except in the case of shafts j and j_s , for which, strictly speaking, there is no fundamental deviation, the value of the deviation shown in Table 4 is independent of the given grade (even if the formula includes a term involving IT);
- (2) the fundamental deviation given by the formulae in the Table is, in principle, that corresponding to the limit closest to the zero line, in other words,

the upper deviation e_s for shafts a to h and
the lower deviation e_i for shafts j to zc .

2.1.3.2 HOLES

For each letter symbol, defining the position of the tolerance zone, the magnitude and sign of the fundamental deviation (lower deviation EI for holes A to H and upper deviation ES for holes J to ZC), are derived from the fundamental deviation e_s or e_i of the shaft with the same letter, according to the rules given below: *

The other deviation is derived from the first one, using the magnitude of the tolerance IT , by means of the following algebraic relationship:

$$\begin{aligned} ES &= EI + IT \quad \text{or} \\ EI &= ES - IT \end{aligned}$$

* Those rules have been determined for the establishment of the ISA System so that,

- (a) for holes complying with the general rule,
the limit corresponding to the fundamental deviation of a hole is exactly symmetrical, in relation to the zero line, to the limit corresponding to the fundamental deviation of the shaft with the same letter;
- (b) for holes complying with the special rule,
two comparable fits, with basic hole and basic shaft, in which a hole of a given grade is associated with a shaft of the next finer grade (e.g. $H7/p6$ and $P7/h6$), have exactly the same clearances or interferences (see Fig. 6, page 17).

(1) *General rule*

$EI = -es$	for A to H
$ES = -ei$	for J to ZC

This rule is applicable to all deviations, except

- (a) those to which the special rule given below applies,
- (b) holes N for grades 9 to 16, above 3 mm (or 0.12 in), for which the fundamental deviation $ES = 0$.

(2) *Special rule*

$ES = -ei + \Delta$ where $\Delta =$ difference $IT_n - IT_{n-1}$ between the fundamental tolerance of the grade in question and that of the next finer grade
--

This rule is applicable, for diameter steps above 3 mm (or 0.12 in), to

J, K, M and N	up to IT 8 inclusive,
P to ZC	up to IT 7 inclusive.

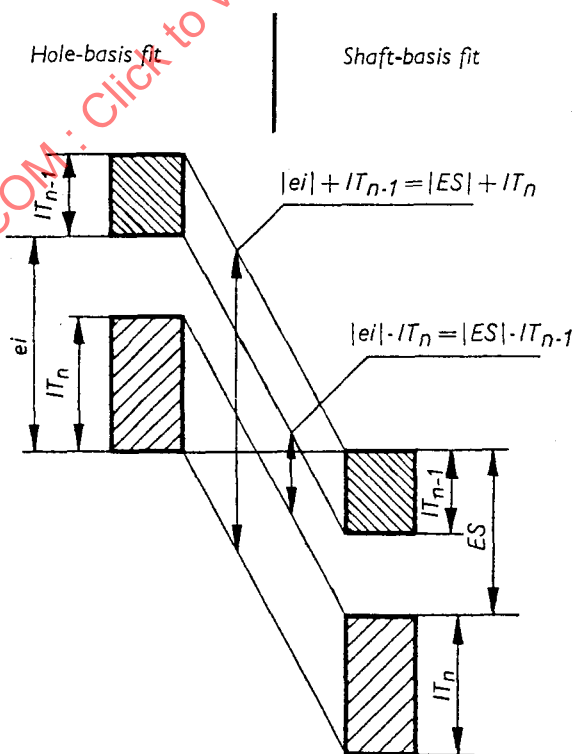


FIG. 6

TABLE 4. — Formulae for fundamental shaft deviations

Upper deviation e_s			Lower deviation e_i		
	Values in microns for D in millimetres	Values in 0.001 in for D in inches		Values in microns for D in millimetres	Values in 0.001 in for D in inches
a	$= -(265 + 1.3 D)$ for $D \leq 120$	$= -(10.5 + 1.3 D)$ for $D \leq 4.73$	j 5 to j 8	No formula	
	$= - 3.5 D$ for $D > 120$	$= - 3.5 D$ for $D > 4.73$	k 4 to k 7	$= + 0.6 \sqrt[3]{D}$	$= + 0.07 \sqrt[3]{D}$
b	$\simeq -(140 + 0.85 D)$ for $D \leq 160$	$= -(5.5 + 0.85 D)$ for $D \leq 6.3$	k for grades ≤ 3 and ≥ 8	$= 0$	
	$\simeq - 1.8 D$ for $D > 160$	$= - 1.8 D$ for $D > 6.3$		$= + (IT7 - IT6)$	
c	$= - 52 D^{0.2}$ for $D \leq 40$	$= - 3.9 D^{0.2}$ for $D \leq 1.58$	n	$= + 5 D^{0.34}$	$= + 0.59 D^{0.34}$
	$= -(95 + 0.8 D)$ for $D > 40$	$= -(3.75 + 0.8 D)$ for $D > 1.58$	p	$= + IT7 + 0$ to 5	$= + IT7 + 0$ to 0.3
cd	$=$ Geometric mean of values e_s for c and d		r	$=$ Geometric mean of values e_i for p and s	
			s	$= + IT8 + 1$ to 4 for $D \leq 50$	$= + IT8 + 0$ to 0.2 for $D \leq 1.97$
d	$= - 16 D^{0.44}$	$= - 2.62 D^{0.44}$		$= + IT7 + 0.4 D$ for $D > 50$	$= + IT7 + 0.4 D$ for $D > 1.97$
e	$= - 11 D^{0.41}$	$= - 1.63 D^{0.41}$	t	$= + IT7 + 0.63 D$	
ef	$=$ Geometric mean of values e_s for e and f		u	$= + IT7 + D$	
			v	$= + IT7 + 1.25 D$	
f	$= - 5.5 D^{0.41}$	$= - 0.82 D^{0.41}$	x	$= + IT7 + 1.6 D$	
fg	$=$ Geometric mean of values e_s for f and g		y	$= + IT7 + 2 D$	
			z	$= + IT7 + 2.5 D$	
g	$= - 2.5 D^{0.34}$	$= - 0.3 D^{0.34}$	za	$= + IT8 + 3.15 D$	
h	$= 0$		zb	$= + IT9 + 4 D$	
			zc	$= + IT10 + 5 D$	
For js: the two deviations are equal to $\pm \frac{IT}{2}$					

2.1.4 Rules for rounding off

2.1.4.1 METRIC VALUES

The values which result, in each diameter step, from the use of the formulae given in clause 2.1.2 for the standard tolerances of grades 11 and finer, and those given in Table 4, page 18, for fundamental shaft deviations, are rounded according to the following rules:

TABLE 5. — Roundings of metric values

		VALUES IN MICRONS										
Values above		5	45	60	100	200	300	560	600	800	1000	2000
Values up to		45	60	100	200	300	560	600	800	1000	2000	—
Rounding in multiples of	for standard tolerances for grades 11 and finer	1	1	1	5	10	10					
	for deviations es from a to g	1	2	5	5	10	10	20	20	20	50	
	for deviations ei from k to zc	1	1	1	2	2	5	5	10	20	50	100

NOTES

- Values resulting from the sum or the difference of two values, which are both already rounded, should not be rounded again.
- For shafts j_s and holes J_s } Special rounding-off rules are indicated in the footnotes to Tables 8 and 9, pages 23 to 26.
- For the small values, in particular, it is sometimes necessary to depart from these rules and even from the application of the formulae, mainly to ensure a better scaling. The numerical values retained in the System are shown in numerical Tables 7, page 22, and 8 and 9, pages 23 to 26.

2.1.4.2 INCH VALUES

Each inch value for standard tolerances and fundamental deviations of shafts and holes, converted from the corresponding metric value, is rounded off to the nearest value extracted from the following Table 6.

In some cases, it is necessary to depart from this procedure to ensure a better scaling (see clause 2.4).

TABLE 6.—Roundings of inch values

VALUES IN 0.001 in

0.005	0.5	7.0	90
0.006	0.6	8.0	100
0.008	0.7	9.0	120
0.01	0.8	10	140
0.012	0.9	12	160
0.015	1.0	14	180
0.02	1.2	16	200
0.025	1.4	18	220
0.03	1.6	20	250
0.04	1.8	22	etc.
0.05	2.0	25	
0.06	2.2	28	
0.08	2.5	30	
0.1	2.8	35	
0.12	3.0	40	
0.15	3.5	45	
0.2	4.0	50	
0.25	4.5	60	
0.3	5.0	70	
0.4	6.0	80	

2.2 Numerical values

Tables 7, page 22, and 8 and 9, pages 23 to 26, present the essential numerical data relating to the limits of parts for the whole System up to 500 mm.

These numerical data should be taken as authoritative for the application of the System, without referring to rules or formulae (see clause 2.1), from which they are calculated.

2.2.1 Standard IT tolerances

Table 7, page 22, shows, for each diameter step, the values in metric units and in inch units of the standard tolerance IT for grades 01 and 0 and 1 to 16.

2.2.2 Fundamental shaft deviations

Table 8, pages 23—24, gives, for each diameter step, the values in metric units and in inch units of the fundamental shaft deviation:

upper deviation es for shafts with symbols a to h ,
lower deviation ei for shafts with symbols j to zc .

The other deviation is derived from the fundamental deviation, as indicated in clause 2.1.3.1, by subtracting or adding, as the case may be, the value of the standard tolerance IT as given in Table 7, page 22, for the grade in question.

For shafts js , there is no fundamental deviation; the two deviations js are calculated only in terms of IT , as noted in the Table.

2.2.3 Hole deviations

Fundamental hole deviations derive directly from shaft deviations, as indicated in clause 2.1.3.2.

However, for more convenience, Table 9, pages 25—26, for each hole symbol and each diameter step, gives, according to the various grades, the fundamental hole deviations.

The other deviation is derived from the fundamental deviation, as indicated in clause 2.1.3.2, by subtracting or adding, as the case may be, the value of the standard tolerance IT , as given in Table 7, page 22, for the grade in question.

NOTES

1. Fundamental deviations for some symbols are not given directly by the Tables.
2. The two limit deviations J_s should be determined in terms of IT , as indicated in Table 9, pages 25—26.
3. The values of the fundamental deviations for holes

K, M, N for fine grades up to 8 inclusive, and
 P to ZC for fine grades up to 7 inclusive,

should be obtained, for sizes above 3 mm, as indicated respectively in each table:

in metric values,

by adding algebraically the value stated in the column of the corresponding symbol for the given step, and a Δ value given itself in columns on the right-hand side of the Table. The value Δ is equal to the difference $IT_n - IT_{n-1}$ of the special rule (see clause 2.1.3.2);

in inch values,

by conversion, as indicated in clause 2.1.4.2, from the corresponding metric values of Table 9, pages 25—26; for the rounded-off values actually accepted, see in the Appendix the practical tables of commonly used shafts and holes for general purposes.

TABLE 7. — Numerical values of standard tolerances

1. Metric values

Grade		01	0	1	2	3	4	5	6	7	8	9	10	11	12	13	14*	15*	16*
Standard tolerances in microns ($1 \mu = 0.001 \text{ mm}$)	for diameter steps in millimetres																		
	≤ 3	0.3	0.5	0.8	1.2	2	3	4	6	10	14	25	40	60	100	140	250	400	600
	> 3 to 6	0.4	0.6	1	1.5	2.5	4	5	8	12	18	30	48	75	120	180	300	480	750
	> 6 to 10	0.4	0.6	1	1.5	2.5	4	6	9	15	22	36	58	90	150	220	360	580	900
	> 10 to 18	0.5	0.8	1.2	2	3	5	8	11	18	27	43	70	110	180	270	430	700	1100
	> 18 to 30	0.6	1	1.5	2.5	4	6	9	13	21	33	52	84	130	210	330	520	840	1300
	> 30 to 50	0.6	1	1.5	2.5	4	7	11	16	25	39	62	100	160	250	390	620	1000	1600
	> 50 to 80	0.8	1.2	2	3	5	8	13	19	30	46	74	120	190	300	460	740	1200	1900
	> 80 to 120	1	1.5	2.5	4	6	10	15	22	35	54	87	140	220	350	540	870	1400	2200
	> 120 to 180	1.2	2	3.5	5	8	12	18	25	40	63	100	160	250	400	630	1000	1600	2500
	> 180 to 250	2	3	4.5	7	10	14	20	29	46	72	115	185	290	460	720	1150	1850	2900
	> 250 to 315	2.5	4	6	8	12	16	23	32	52	81	130	210	320	520	810	1300	2100	3200
	> 315 to 400	3	5	7	9	13	18	25	36	57	89	140	230	360	570	890	1400	2300	3600
	> 400 to 500	4	6	8	10	15	20	27	40	63	97	155	250	400	630	970	1550	2500	4000

* Up to 1 mm, grades 14 to 16 are not provided.

NOTE. — Numerical values amended from the former ISA System are framed in a bold line.

2. Inch values

Grade		01	0	1	2	3	4	5	6	7	8	9	10	11	12	13	14*	15*	16*
Standard tolerances in 0.001 in	for diameter steps in inches																		
	≤ 0.12	0.012	0.02	0.03	0.05	0.08	0.12	0.15	0.25	0.4	0.6	1.0	1.6	2.5	4.0	6.0	10.0	16.0	25.0
	> 0.12 to 0.24	0.015	0.025	0.04	0.06	0.10	0.15	0.2	0.3	0.5	0.7	1.2	1.8	3.0	5.0	7.0	12.0	18.0	30.0
	> 0.24 to 0.40	0.015	0.025	0.04	0.06	0.10	0.15	0.25	0.4	0.6	0.9	1.4	2.2	3.5	6.0	9.0	14.0	22.0	35.0
	> 0.40 to 0.71	0.02	0.03	0.05	0.08	0.12	0.2	0.3	0.4	0.7	1.0	1.6	2.8	4.0	7.0	10.0	16.0	28.0	40.0
	> 0.71 to 1.19	0.025	0.04	0.06	0.10	0.15	0.25	0.4	0.5	0.8	1.2	2.0	3.5	5.0	8.0	12.0	20.0	35.0	50.0
	> 1.19 to 1.97	0.025	0.04	0.06	0.10	0.15	0.3	0.4	0.6	1.0	1.6	2.5	4.0	6.0	10.0	16.0	25.0	40.0	60.0
	> 1.97 to 3.15	0.03	0.05	0.08	0.12	0.2	0.3	0.5	0.7	1.2	1.8	3.0	4.5	7.0	12.0	18.0	30.0	45.0	70.0
	> 3.15 to 4.73	0.04	0.06	0.1	0.15	0.25	0.4	0.6	0.9	1.4	2.2	3.5	5.0	9.0	14.0	22.0	35.0	50.0	90.0
	> 4.73 to 7.09	0.05	0.08	0.12	0.2	0.3	0.5	0.7	1.0	1.6	2.5	4.0	6.0	10.0	16.0	25.0	40.0	60.0	100.0
	> 7.09 to 9.85	0.08	0.12	0.2	0.3	0.4	0.6	0.8	1.2	1.8	2.8	4.5	7.0	12.0	18.0	28.0	45.0	70.0	120.0
	> 9.85 to 12.41	0.10	0.15	0.25	0.3	0.5	0.6	0.9	1.2	2.0	3.0	5.0	8.0	12.0	20.0	30.0	50.0	80.0	120.0
	> 12.41 to 15.75	0.12	0.2	0.3	0.4	0.5	0.7	1.0	1.4	2.2	3.5	6.0	9.0	14.0	22.0	35.0	60.0	90.0	140.0
	> 15.75 to 19.69	0.15	0.25	0.3	0.4	0.6	0.8	1.0	1.6	2.5	4.0	6.0	10.0	16.0	25.0	40.0	60.0	100.0	160.0

* Up to 0.04 in, grades 14 to 16 are not provided.

TABLE 8. — Numerical values of fundamental de

1. Metric values

Fundamental deviation		Upper deviation es															
Symbol	Letter	a *	b *	c	cd	d	e	ef	f	fg	g	h	i _s **	j			k
	Grade	All grades											5-6	7	8	4 à 7	
Fundamental deviations in microns (1μ = 0.001 mm)	* <3	-270	-140	-60	-34	-20	-14	-10	-6	-4	-2	0	IT Deviations = $\pm \frac{IT}{2}$	-2	-4	-6	0
	>3 to 6	-270	-140	-70	-46	-30	-20	-14	-10	-6	-4	0		-2	-4	—	+1
	>6 to 10	-280	-150	-80	-56	-40	-25	-18	-13	-8	-5	0		-2	-5	—	+1
	>10 to 14	-290	-150	-95	—	-50	-32	—	-16	—	-6	0		-3	-6	—	+1
	>14 to 18													-4	-8	—	+2
	>18 to 24	-300	-160	-110	—	-65	-40	—	-20	—	-7	0		-5	-10	—	+2
	>24 to 30	-310	-170	-120	—	-80	-50	—	-25	—	-9	0		-7	-12	—	+2
	>30 to 40	-320	-180	-130	—	-100	-60	—	-30	—	-10	0		-9	-15	—	+3
	>40 to 50	-340	-190	-140	—	-120	-72	—	-36	—	-12	0		-11	-18	—	+3
	>50 to 65	-360	-200	-150	—	-145	-85	—	-43	—	-14	0		-13	-21	—	+4
	>65 to 80	-380	-220	-170	—	-170	-100	—	-50	—	-15	0		-16	-26	—	+4
	>80 to 100	-410	-240	-180	—	-190	-110	—	-56	—	-17	0		-18	-28	—	+4
	>100 to 120	-460	-260	-200	—	-210	-125	—	-62	—	-18	0		-20	-32	—	+5
	>120 to 140	-520	-280	-210	—	-230	-135	—	-68	—	-20	0		-20	-32	—	+5
	>140 to 160	-580	-310	-230	—	-230	-135	—	-68	—	-20	0		-20	-32	—	+5
	>160 to 180	-660	-340	-240	—	-230	-135	—	-68	—	-20	0		-20	-32	—	+5
	>180 to 200	-740	-380	-260	—	-230	-135	—	-68	—	-20	0		-20	-32	—	+5
	>200 to 225	-820	-420	-280	—	-230	-135	—	-68	—	-20	0		-20	-32	—	+5
	>225 to 250	-920	-480	-300	—	-230	-135	—	-68	—	-20	0		-20	-32	—	+5
	>250 to 280	-1 050	-540	-330	—	-230	-135	—	-68	—	-20	0		-20	-32	—	+5
	>280 to 315	-1 200	-600	-360	—	-230	-135	—	-68	—	-20	0		-20	-32	—	+5
	>315 to 355	-1 350	-680	-400	—	-230	-135	—	-68	—	-20	0		-20	-32	—	+5
	>355 to 400	-1 500	-760	-440	—	-230	-135	—	-68	—	-20	0		-20	-32	—	+5
	>400 to 450	-1 650	-840	-480	—	-230	-135	—	-68	—	-20	0		-20	-32	—	+5
	>450 to 500	-1 650	-840	-480	—	-230	-135	—	-68	—	-20	0		-20	-32	—	+5

* The deviations a and b are not provided for diameters up to 1 mm.

** For j_s in the particular grades 7 to 11, the two symmetrical deviations $\pm \frac{IT}{2}$ may possibly be rounded in national standards if the IT value in microns is an odd value.

NOTE. — Numerical values amended from the former ISA System are framed in a bold line.

2. Inch values

Fundamental deviation		Upper deviation es															
Symbol	Letter	a *	b *	c	cd	d	e	ef	f	fg	g	h	j _s	j			k
	Grade	All grades												5-6	7	8	4 à 7
Fundamental deviations in 0.001 in for diameter steps in inches	* <0.12	-10	-5	-2.5	1.6	-1.0	-0.6	-0.4	-0.3	-0.2	-0.1	0	IT (rounded to the nearest value extracted from Table 6) Deviations = ± $\frac{IT}{2}$	-0.1	-0.15	-0.25*	0
	>0.12 to 0.24	-10	-5	-2.8	-1.8	-1.2	-0.8	-0.6	-0.4	-0.25	-0.15	0		-0.1	-0.15	—	+0.1
	>0.24 to 0.40	-10	-6	-3.0	-2.2	-1.6	-1.0	-0.7	-0.5	-0.3	-0.2	0		-0.1	-0.2	—	+0.1
	>0.40 to 0.56	-12	-6	-3.5	—	-2.0	-1.2	—	-0.6	—	-0.25	0		-0.1	-0.2	—	+0.1
	>0.56 to 0.71	-12	-6	-4.5	—	-2.5	-1.6	—	-0.8	—	-0.3	0		-0.2	-0.3	—	+0.1
	>0.71 to 0.95	-12	-7	-5.0	—	-3.0	-2.0	—	-1.0	—	-0.4	0		-0.2	-0.4	—	+0.1
	>0.95 to 1.19	-12	-7	-5.0	—	-3.0	-2.0	—	-1.0	—	-0.4	0		-0.2	-0.4	—	+0.1
	>1.19 to 1.58	-14	-8	-6.0	—	-4.0	-2.5	—	-1.2	—	-0.4	0		-0.3	-0.5	—	+0.1
	>1.58 to 1.97	-14	-8	-6.0	—	-4.0	-2.5	—	-1.2	—	-0.4	0		-0.3	-0.5	—	+0.1
	>1.97 to 2.56	-16	-9	-7.0	—	-5.0	-3.0	—	-1.4	—	-0.5	0		-0.4	-0.6	—	+0.1
	>2.56 to 3.15	-16	-9	-7.0	—	-5.0	-3.0	—	-1.4	—	-0.5	0		-0.4	-0.6	—	+0.1
	>3.15 to 3.94	-20	-12	-8.0	—	-6.0	-3.5	—	-1.6	—	-0.6	0		-0.4	-0.7	—	+0.1
	>3.94 to 4.73	-20	-12	-8.0	—	-6.0	-3.5	—	-1.6	—	-0.6	0		-0.4	-0.7	—	+0.1
	>4.73 to 5.52	-30	-16	-10.0	—	-7.0	-4.0	—	-2.0	—	-0.6	0		-0.5	-0.8	—	+0.2
	>5.52 to 6.30	-30	-16	-10.0	—	-7.0	-4.0	—	-2.0	—	-0.6	0		-0.5	-0.8	—	+0.2
	>6.30 to 7.09	-40	-20	-12.0	—	-7.0	-4.5	—	-2.2	—	-0.7	0		-0.6	-1.0	—	+0.2
	>7.09 to 7.88	-40	-20	-12.0	—	-7.0	-4.5	—	-2.2	—	-0.7	0		-0.6	-1.0	—	+0.2
	>7.88 to 8.86	-50	-25	-14.0	—	-8.0	-5.0	—	-2.5	—	-0.7	0		-0.7	-1.0	—	+0.2
	>8.86 to 9.85	-50	-25	-14.0	—	-8.0	-5.0	—	-2.5	—	-0.7	0		-0.7	-1.0	—	+0.2
	>9.85 to 11.03	-60	-30	-16.0	—	-9.0	-5.0	—	-2.8	—	-0.8	0		-0.7	-1.2	—	+0.2
>11.03 to 12.41	-60	-30	-16.0	—	-9.0	-5.0	—	-2.8	—	-0.8	0	-0.7	-1.2	—	+0.2		
>12.41 to 13.98																	
>13.98 to 15.75																	
>15.75 to 17.72																	
>17.72 to 19.69																	

* The deviations a and b are not provided for diameters up to 0.04 in.

** j 8 is not recommended in the inch system, where j_s 8 should be preferred.

(1) 23-24

1. Metric values

Lower deviation ei																		
j			k		m	n	p	r	s	t	u	v	x	y	z	za	zb	zc
5-6	7	8	4 à 7	$\frac{\sqrt{3}}{7}$	All grades													
-2	-4	-6	0	0	+2	+4	+6	+10	+14	—	+18	—	+20	—	+26	+32	+40	+60
-2	-4	—	+1	0	+4	+8	+12	+15	+19	—	+23	—	+28	—	+35	+42	+50	+80
-2	-5	—	+1	0	+6	+10	+15	+19	+23	—	+28	—	+34	—	+42	+52	+67	+97
-3	-6	—	+1	0	+7	+12	+18	+23	+28	—	+33	—	+40	—	+50	+64	+90	+130
												+39	+45	—	+60	+77	+108	+150
-4	-8	—	+2	0	+8	+15	+22	+28	+35	—	+41	+47	+54	+63	+73	+98	+136	+188
										+41	+48	+55	+64	+75	+88	+118	+160	+218
-5	-10	—	+2	0	+9	+17	+26	+34	+43	+48	+60	+68	+80	+94	+112	+148	+200	+274
										+54	+70	+81	+97	+114	+136	+180	+242	+325
-7	-12	—	+2	0	+11	+20	+32	+41	+53	+66	+87	+102	+122	+144	+172	+226	+300	+405
								+43	+59	+75	+102	+120	+146	+174	+210	+274	+360	+480
-9	-15	—	+3	0	+13	+23	+37	+51	+71	+91	+124	+146	+178	+214	+258	+335	+445	+585
								+54	+79	+104	+144	+172	+210	+254	+310	+400	+525	+690
								+63	+92	+122	+170	+202	+248	+300	+365	+470	+620	+800
-11	-18	—	+3	0	+15	+27	+43	+65	+100	+134	+190	+228	+280	+340	+415	+535	+700	+900
								+68	+108	+146	+210	+252	+310	+380	+465	+600	+780	+1000
								+77	+122	+166	+236	+284	+350	+425	+520	+670	+880	+1150
-13	-21	—	+4	0	+17	+31	+50	+80	+130	+180	+258	+310	+385	+470	+575	+740	+960	+1250
								+84	+140	+196	+284	+340	+425	+520	+640	+820	+1050	+1350
								+94	+158	+218	+315	+385	+475	+580	+710	+920	+1200	+1550
-16	-26	—	+4	0	+20	+34	+56	+98	+170	+240	+350	+425	+525	+650	+790	+1000	+1300	+1700
								+108	+190	+268	+390	+475	+590	+730	+900	+1150	+1500	+1900
-18	-28	—	+4	0	+21	+37	+62	+114	+208	+294	+435	+530	+660	+820	+1000	+1300	+1650	+2100
								+126	+232	+330	+490	+595	+740	+920	+1100	+1450	+1850	+2400
-20	-32	—	+5	0	+23	+40	+68	+132	+252	+360	+540	+660	+820	+1000	+1250	+1600	+2100	+2600

IT value in microns is an odd value, by replacing it by the even value immediately below.

2. Inch values

Lower deviation ei																		
j			k		m	n	p	r	s	t	u	v	x	y	z	za	zb	zc
5-6	7	8	4 à 7	$\frac{\sqrt{3}}{7}$	All grades													
-0.1	-0.15	-0.25	0	0	+0.1	+0.15	+0.25	+0.4	+0.6	—	+0.7	—	+0.9	—	+1.2	+1.4	+1.6	+2.5
-0.1	-0.15	—	+0.1	0	+0.15	+0.3	+0.5	+0.6	+0.7	—	+0.9	—	+1.2	—	+1.4	+1.6	+2	+3
-0.1	-0.2	—	+0.1	0	+0.25	+0.4	+0.6	+0.8	+1.0	—	+1.2	—	+1.4	—	+1.6	+2.0	+2.5	+4
-0.1	-0.2	—	+0.1	0	+0.3	+0.5	+0.7	+1.0	+1.2	—	+1.4	—	+1.6	—	+2.0	+2.5	+3.5	+5
												+1.6	+1.8	—	+2.5	+3.0	+4	+6
-0.2	-0.3	—	+0.1	0	+0.3	+0.6	+0.8	+1.2	+1.4	—	+1.6	+1.8	+2.2	+2.5	+2.8	+4.0	+5	+7
										+1.6	+1.8	+2.2	+2.5	+3.0	+3.5	+4.5	+6	+9
-0.2	-0.4	—	+0.1	0	+0.4	+0.7	+1.0	+1.4	+1.8	+2.0	+2.5	+2.8	+3.0	+3.5	+4.5	+6	+8	+10
										+2.2	+2.8	+3.0	+4.0	+4.5	+5.0	+7	+10	+12
-0.3	-0.5	—	+0.1	0	+0.5	+0.8	+1.4	+1.6	+2.0	+2.5	+3.5	+4.0	+5.0	+6.0	+7.0	+9	+12	+16
										+2.2	+3.0	+4.0	+5.0	+6.0	+7.0	+8.0	+10	+14
-0.4	-0.6	—	+0.1	0	+0.5	+1.0	+1.6	+2.0	+2.8	+3.5	+5.0	+6.0	+7.0	+8.0	+10.0	+14	+18	+22
										+3.0	+4.0	+6.0	+7.0	+8.0	+10.0	+12.0	+16	+20
										+3.5	+5.0	+7.0	+8.0	+10.0	+12.0	+14.0	+18	+25
-0.4	-0.7	—	+0.1	0	+0.6	+1.2	+1.8	+2.5	+4.0	+5.0	+7.0	+9.0	+12.0	+14.0	+16.0	+22	+28	+35
										+4.5	+6.0	+8.0	+10.0	+12.0	+14.0	+18.0	+25	+30
										+5.0	+7.0	+9.0	+12.0	+14.0	+16.0	+20.0	+28	+35
-0.5	-0.8	—	+0.2	0	+0.6	+1.4	+2.0	+3.0	+5.0	+7.0	+10.0	+12.0	+16.0	+18.0	+22.0	+30	+40	+50
										+6.0	+8.0	+12.0	+14.0	+16.0	+20.0	+25.0	+30	+40
										+6.0	+9.0	+12.0	+16.0	+18.0	+22.0	+28.0	+35	+45
-0.6	-1.0	—	+0.2	0	+0.8	+1.4	+2.2	+3.5	+7.0	+9.0	+14.0	+16.0	+20.0	+25.0	+30.0	+40	+50	+70
										+7.0	+10.0	+16.0	+18.0	+22.0	+28.0	+35.0	+45	+60
-0.7	-1.0	—	+0.2	0	+0.8	+1.6	+2.5	+4.5	+8.0	+12.0	+18.0	+20.0	+25.0	+30.0	+40.0	+50	+60	+80
										+9.0	+12.0	+20.0	+22.0	+28.0	+35.0	+45.0	+60	+70
-0.7	-1.2	—	+0.2	0	+0.9	+1.8	+2.8	+5.0	+10.0	+14.0	+22.0	+25.0	+30.0	+40.0	+50.0	+60	+80	+100

1. Metric values

*** Spe
**** In
Ex.

2. Inch values

• The deviations A and B in all grades, and N in grades >8, are not provided for diameters up to 0.04 in.

1. Metric values

Upper deviation ES																	Δ in microns ****								
M			N			P to ZC	P	R	S	T	U	V	X	Y	Z	ZA	ZB	ZC							
> 8	≤ 8 ***	> 8	≤ 8	> 8 *	≤ 7	> 7												3	4	5	6	7	8		
0	-2	-2	-4	-4	Same deviation as for grades > 7 increased by Δ	-6	-10	-14	—	-18	—	-20	—	-26	-32	-40	-60	$\Delta = 0$							
—	-4 + Δ	-4	-8 + Δ	0		-12	-15	-19	—	-23	—	-28	—	-35	-42	-50	-80	1	1,5	1	3	4	6		
—	-6 + Δ	-6	-10 + Δ	0		-15	-19	-23	—	-28	—	-34	—	-42	-52	-67	-97	1	1,5	2	3	6	7		
—	-7 + Δ	-7	-12 + Δ	0		-18	-23	-28	—	-33	—	-40	—	-50	-64	-90	-130	1	2	3	3	7	9		
—	-8 + Δ	-8	-15 + Δ	0		-22	-28	-35	—	-41	-47	-54	-63	-73	-98	-136	-188	1,5	2	3	4	8	12		
—	-9 + Δ	-9	-17 + Δ	0		-26	-34	-43	—	-48	-60	-68	-80	-94	-112	-148	-200	-274	1,5	3	4	5	9	14	
—	-11 + Δ	-11	-20 + Δ	0		-32	-41	-53	-66	-87	-102	-122	-144	-172	-226	-300	-405	2	3	5	6	11	16		
—	-13 + Δ	-13	-23 + Δ	0		-37	-43	-59	-75	-102	-120	-146	-174	-210	-274	-360	-480	2	4	5	7	13	19		
—	-15 + Δ	-15	-27 + Δ	0		-43	-51	-71	-91	-124	-146	-178	-214	-258	-335	-445	-585	3	4	6	7	15	23		
—	-17 + Δ	-17	-31 + Δ	0		-50	-54	-79	-104	-144	-172	-210	-254	-310	-400	-525	-690	3	4	6	9	17	26		
—	-20 + Δ	-20	-34 + Δ	0		-56	-63	-92	-122	-170	-202	-248	-300	-365	-470	-620	-800	4	4	7	9	20	29		
—	-21 + Δ	-21	-37 + Δ	0		-62	-65	-100	-134	-190	-228	-280	-340	-415	-535	-700	-900	4	5	7	11	21	32		
—	-23 + Δ	-23	-40 + Δ	0		-68	-68	-108	-146	-210	-252	-310	-380	-465	-600	-780	-1000	5	5	7	13	23	34		
—	-24 + Δ	-24	-42 + Δ	0		-74	-74	-116	-158	-226	-272	-336	-416	-504	-648	-864	-1104	5	5	7	13	23	34		
—	-26 + Δ	-26	-46 + Δ	0		-80	-80	-124	-172	-244	-296	-368	-456	-552	-704	-928	-1184	5	5	7	13	23	34		
—	-28 + Δ	-28	-50 + Δ	0		-86	-86	-132	-184	-260	-316	-396	-496	-600	-768	-1008	-1296	5	5	7	13	23	34		
—	-30 + Δ	-30	-54 + Δ	0		-92	-92	-140	-196	-276	-336	-424	-528	-640	-816	-1056	-1344	5	5	7	13	23	34		
—	-32 + Δ	-32	-58 + Δ	0		-98	-98	-148	-208	-292	-356	-448	-556	-672	-856	-1096	-1392	5	5	7	13	23	34		
—	-34 + Δ	-34	-62 + Δ	0		-104	-104	-156	-216	-304	-372	-472	-584	-704	-896	-1136	-1432	5	5	7	13	23	34		
—	-36 + Δ	-36	-66 + Δ	0		-110	-110	-164	-228	-320	-392	-500	-616	-744	-944	-1184	-1480	5	5	7	13	23	34		
—	-38 + Δ	-38	-70 + Δ	0		-116	-116	-172	-240	-336	-412	-528	-656	-792	-1000	-1240	-1540	5	5	7	13	23	34		
—	-40 + Δ	-40	-74 + Δ	0		-122	-122	-180	-252	-352	-432	-552	-688	-832	-1040	-1280	-1580	5	5	7	13	23	34		
—	-42 + Δ	-42	-78 + Δ	0	-128	-128	-188	-264	-368	-452	-576	-720	-872	-1080	-1320	-1620	5	5	7	13	23	34			
—	-44 + Δ	-44	-82 + Δ	0	-134	-134	-196	-276	-384	-472	-600	-752	-904	-1112	-1352	-1652	5	5	7	13	23	34			
—	-46 + Δ	-46	-86 + Δ	0	-140	-140	-204	-288	-400	-496	-632	-792	-952	-1160	-1400	-1700	5	5	7	13	23	34			
—	-48 + Δ	-48	-90 + Δ	0	-146	-146	-212	-300	-416	-516	-656	-824	-992	-1200	-1440	-1740	5	5	7	13	23	34			
—	-50 + Δ	-50	-94 + Δ	0	-152	-152	-220	-312	-432	-536	-680	-848	-1016	-1224	-1464	-1764	5	5	7	13	23	34			
—	-52 + Δ	-52	-98 + Δ	0	-158	-158	-228	-324	-448	-556	-704	-876	-1044	-1252	-1492	-1792	5	5	7	13	23	34			
—	-54 + Δ	-54	-102 + Δ	0	-164	-164	-236	-336	-464	-576	-728	-904	-1072	-1280	-1520	-1820	5	5	7	13	23	34			
—	-56 + Δ	-56	-106 + Δ	0	-170	-170	-244	-348	-480	-596	-752	-936	-1104	-1312	-1552	-1852	5	5	7	13	23	34			
—	-58 + Δ	-58	-110 + Δ	0	-176	-176	-252	-360	-504	-624	-784	-976	-1144	-1352	-1592	-1892	5	5	7	13	23	34			
—	-60 + Δ	-60	-114 + Δ	0	-182	-182	-260	-372	-520	-644	-808	-1000	-1168	-1376	-1616	-1916	5	5	7	13	23	34			
—	-62 + Δ	-62	-118 + Δ	0	-188	-188	-268	-384	-536	-664	-832	-1032	-1200	-1408	-1648	-1948	5	5	7	13	23	34			
—	-64 + Δ	-64	-122 + Δ	0	-194	-194	-276	-396	-552	-680	-856	-1064	-1232	-1440	-1680	-1980	5	5	7	13	23	34			
—	-66 + Δ	-66	-126 + Δ	0	-200	-200	-284	-408	-568	-704	-880	-1096	-1264	-1472	-1712	-2012	5	5	7	13	23	34			
—	-68 + Δ	-68	-130 + Δ	0	-206	-206	-292	-420	-584	-720	-904	-1120	-1288	-1496	-1736	-2036	5	5	7	13	23	34			
—	-70 + Δ	-70	-134 + Δ	0	-212	-212	-300	-432	-600	-744	-936	-1160	-1328	-1536	-1776	-2076	5	5	7	13	23	34			
—	-72 + Δ	-72	-138 + Δ	0	-218	-218	-308	-444	-616	-760	-960	-1184	-1352	-1560	-1800	-2100	5	5	7	13	23	34			
—	-74 + Δ	-74	-142 + Δ	0	-224	-224	-316	-456	-632	-776	-984	-1208	-1376	-1584	-1824	-2124	5	5	7	13	23	34			
—	-76 + Δ	-76	-146 + Δ	0	-230	-230	-324	-468	-648	-792	-1000	-1224	-1392	-1600	-1840	-2140	5	5	7	13	23	34			
—	-78 + Δ	-78	-150 + Δ	0	-236	-236	-332	-480	-664	-808	-1024	-1248	-1416	-1624	-1864	-2164	5	5	7	13	23	34			
—	-80 + Δ	-80	-154 + Δ	0	-242	-242	-340	-504	-692	-840	-1056	-1280	-1448	-1656	-1896	-2196	5	5	7	13	23	34			
—	-82 + Δ	-82	-158 + Δ	0	-248	-248	-348	-516	-712	-864	-1080	-1304	-1472	-1680	-1920	-2220	5	5	7	13	23	34			
—	-84 + Δ	-84	-162 + Δ	0	-254	-254	-356	-528	-736	-896	-1112	-1336	-1504	-1712	-1952	-2252	5	5	7	13	23	34			
—	-86 + Δ	-86	-166 + Δ	0	-260	-260	-364	-540	-752	-912	-1128	-1352	-1520	-1728	-1968	-2268	5	5	7	13	23	34			
—	-88 + Δ	-88	-170 + Δ	0	-266	-266	-372	-552	-768	-936	-1152	-1376	-1544	-1752	-1992	-2292	5	5	7	13	23	34			
—	-90 + Δ	-90	-174 + Δ	0	-272	-272	-380	-564	-784	-952	-1168	-1392	-1560	-1768	-2008	-2308	5	5	7	13	23	34			
—	-92 + Δ	-92	-178 + Δ	0	-278	-278	-388	-576	-800	-968	-1184	-1408	-1576	-1784	-2024	-2324	5	5	7	13	23	34			
—	-94 + Δ	-94	-182 + Δ	0	-284	-284	-396	-588	-816	-984	-1200	-1424	-1592	-1800	-2040	-2340	5	5	7	13	23	34			
—	-96 + Δ	-96	-186 + Δ	0	-290	-290	-404	-600	-832	-1000	-1216	-1440	-1608	-1816	-2056	-2356	5	5	7	13	23	34			
—	-98 + Δ	-98	-190 + Δ	0	-296	-296	-412	-612	-848	-1016	-1232	-1456	-1624	-1832	-2072	-2372	5	5	7	13	23	34			
—	-100 + Δ	-100	-194 + Δ	0	-302	-302	-420	-624	-864	-1032	-1248	-1472	-1640	-1848	-2088	-2388	5	5	7	13	23	34			
—	-102 + Δ	-102	-198 + Δ	0	-308	-308	-428	-636	-880	-1048	-1264	-1488	-1656	-1864	-2104	-2404	5	5	7	13	23	34			
—	-104 + Δ	-104	-202 + Δ	0	-314	-314	-436	-648	-904	-1072	-1288	-1512	-1680	-1888	-2128	-2428	5	5	7	13	23	34			
—	-106 + Δ	-106	-206 + Δ	0	-320	-320	-444	-660	-920	-1088	-1304	-1528	-1696	-1904	-2144	-2444	5	5	7	13	23	34			
—	-108 + Δ	-108	-210 + Δ	0	-326	-326	-452	-672	-944	-1112	-1328	-1552	-1720	-1928	-2168	-2468	5	5	7	13	23	34			
—	-110 + Δ	-110	-214 + Δ	0	-332	-332	-460	-684	-968	-1136	-1352	-1576	-1744	-1952	-2192	-2492	5	5	7	13	23	34			
—	-112 + Δ	-112	-218 + Δ	0	-338	-338	-468	-696	-992	-1160	-1376	-1600	-1768	-1976	-2216	-2516	5	5	7	13	23	34			
—	-114 + Δ	-114	-222 + Δ	0	-344	-344	-476	-708	-1016	-1184	-1400	-1624	-1792	-2000	-2240	-2540	5	5	7	13	23	34			
—	-116 + Δ	-116	-226 + Δ	0	-350	-350	-484	-720	-1040	-1208	-1424	-1648	-1816	-2024	-2264	-2564	5	5	7	13	23	34			
—	-118 + Δ	-118	-230 + Δ	0	-356	-356	-492	-732	-1064	-1232	-1448	-1672	-1840	-2048	-2288	-2588	5	5	7	13	23	34			
—	-120 + Δ	-120	-234 + Δ	0	-362	-362	-500	-744	-1088	-1256	-1472	-1696	-1864	-2072	-2312	-2612	5	5	7	13	23	34			
—	-122 + Δ	-122	-238 + Δ	0	-368	-368	-508	-756	-1112	-1280	-1496	-1720	-1888	-2096	-2336	-2636	5	5	7	13	23	34			
—	-124 + Δ	-124	-242 + Δ	0	-374	-374	-516	-768	-1136	-1304	-1520	-1744	-1912	-2120	-2360	-2660	5	5	7	13	23	34			
—	-126 + Δ	-126	-246 + Δ	0																					

*** Special case: for M6, ES = -9 from 250 to 315 (instead of -11).

**** In determining K, M, N, up to grade 8 and P to ZC up to grade 7, take the Δ values from the columns on the right:
Ex.: for P7 from 18 to 30: $\Delta = 8$ hence ES = -14.

2. Inch values

Upper deviation ES																								
J		K		M		N		P to ZC	P	R	S	T	U	V	X	Y	Z	ZA	ZB	ZC				
7	8	≤ 8	> 8	≤ 8	> 8	≤ 8 *	> 8	≤ 7	> 7															
0.15	+0.25	0	0	-0.1	-0.1	-0.15	-0.15	Obtained by converting values in millimetres	-0.25	-0.4	-0.6	—	-0.7	—	-0.9	—	-1.2	-1.4	-1.6	-2.5				
0.25	+0.4	—	—	—	-0.15	0	0		-0.5	-0.6	-0.7	—	-0.9	—	-1.2	—	-1.4	-1.6	-2.0	-3.0				
0.3	+0.5	—	—	—	-0.25	0	0		-0.6	-0.8	-1.0	—	-1.2	—	-1.4	—	-1.6	-2.0	-2.5	-4.0				
0.4	+0.5	—	—	—	-0.3	0	0		-0.7	-1.0	-1.2	—	-1.4	—	-1.6	—	-2.0	-2.5	-3.5	-5				
0.5	+0.7	—	—	—	-0.3	0	0		-0.8	-1.2	-1.4	—	-1.6	-1.8	-2.2	-2.5	-2.8	-4.0	-5	-7				
0.6	+1.0	—	—	—	-0.4	0	0		-1.0	-1.4	-1.8	—	-2.0	-2.5	-2.8	-3.0	-3.5	-4.5	-6	-9				
0.8	+1.1	—	—	—	-0.5	0	0		-1.4	-1.6	—	-2.0	-2.5	-3.5	-4.0	-5.0	-6.0	-7	-9	-12				
0.9	+1.4	—	—	—	-0.5	0	0		-1.6	-2.0	—	-2.2	-3.0	-4.0	-5.0	-6.0	-7.0	-8	-10	-14				
1.0	+1.6	—	—	—	-0.6	0	0		-1.8	-2.5	—	-3.5	-5.0	-7.0	-8.0	-10.0	-12	-16	-20	-28				
1.1	+1.8	—	—	—	-0.6	0	0		-2.0	-3.0	—	-4.0	-5.0	-7.0	-8.0	-10.0	-12.0	-14	-18	-25				
1.3	+2.0	—	—	—	-0.8	0	0		-2.2	-3.5	—	-5.0	-7.0	-9.0	-10.0	-12.0	-14.0	-16	-22	-30				
1.5	+2.3	—	—	—	-0.8	0	0		-2.5	-4.5	—	-6.0	-9.0	-14.0	-16.0	-20.0	-25.0	-30	-40	-50				
1.6	+2.7	—	—	—	-0.9	0	0		-2.8	-5.0	—	-7.0	-10.0	-16.0	-18.0	-22.0	-28.0	-35	-45	-60				
									-3.0	-5.0	-7.0	-9.0	-12.0	-16.0	-20.0	-25.0	-30.0	-40	-50	-70				
									-3.5	-6.0	-8.0	-10.0	-14.0	-18.0	-22.0	-28.0	-35	-45	-60	-80				
									-4.0	-7.0	-10.0	-14.0	-18.0	-22.0	-28.0	-35	-45	-60	-80	-100				
									-4.5	-8.0	-12.0	-16.0	-20.0	-25.0	-30.0	-40	-50	-60	-80	-100				
									-5.0	-9.0	-14.0	-18.0	-22.0	-28.0	-35.0	-45	-60	-70	-90	-100				
									-6.0	-10.0	-16.0	-20.0	-25.0	-30.0	-40	-50	-60	-80	-100	-100				

2.3 Commonly used shafts and holes

The practical tables, contained in the Appendix to this ISO Recommendation, give the calculated metric and inch values of the two limit deviations, deriving from the indications of the previous clauses, for some shafts and holes in the fields mentioned hereafter:

General purposes,
Fine mechanisms and horology.

2.3.1 *General purposes*

Tables for general purposes are given in the Appendix: tables summarizing the contents are shown on page 38, and upper and lower deviations, in metric and in inch values, for commonly used shafts and holes are given in the tables on pages 39—40 to 57—58 of this Appendix.

Numerical values corresponding to the symbols for shafts and holes are given, in most cases, for the whole range of diameters up to 500 mm (19.69 in) and, in other cases, only for a more restricted field.

This selection may now be regarded as representing the most general practice, taking particular account of existing national standards.*

2.3.2 *Fine mechanisms and horology*

This part gives, for fine mechanisms and horology,

a selection of shafts, and
a selection of holes,

which show the metric and inch values for the shafts and holes which are considered necessary in this field.

2.4 Justificatory note on the millimetre-inch correspondence

The following is a list of the changes made, or methods used, in the conversion from metric into inch values.

1. The limits of the diameter steps are converted from the metric values and rounded to two decimal places. Almost all commonly used diameters thus fall well within the extreme limits of the diameter steps, without coinciding with these extreme limits.

* Future studies will enable a selection to be made among the symbols for shafts and holes thus selected and, in particular, will permit the elimination of those which, in certain diameter steps, might constitute a virtual duplication of adjoining symbols, or would comprise deviations and tolerance zones not readily compatible.

Attention is, however, to be drawn to the case of the diameters 0.40, 0.95 and 15.75, which coincide with the extreme values of the diameter steps: difficulties might indeed arise in the relatively unlikely event of one of the parts of a fit being made in one system of measurement and the mating part in the other system, due to the change in the values of tolerances and deviations at these diameters (see last paragraph of Introductory Note, page 3).

2. Standard tolerances and fundamental deviations are given in converted values, rounded to the nearest value in Table 6, as explained in the text. The resulting differences exceed a negligible percentage only in some of the small values.
3. In the case of certain holes A, B, C, and shafts a, b, c, the intermediate diameter steps are not used, because this is pointless when rounded values are used. The diameter steps for these holes and shafts are thus the same as for D and d.
4. In the case of D and d, the value of the fundamental deviation of diameter step 3.15 to 4.73 is rounded arbitrarily from the metric value of 120μ to 0.005 in, instead of 0.0045 in, to ensure a better scaling.
5. For the same reasons, the values of X and x in the diameter step 15.75 to 17.72 in are rounded arbitrarily (deviation $740 \mu = 0.0291$ in, rounded to 0.028 in, not 0.030 in).
6. In a few cases (mainly holes), deviations correctly calculated and expressed in units of 0.000 05 in are arbitrarily rounded to 0.0001 in to make them more suitable for normal use.

In no case is the difference greater than 0.000 05 in (1.25μ).

3. TOLERANCES AND DEVIATIONS FOR SIZES ABOVE 500 mm UP TO 3150 mm (19.69 to 125 in) *

3.1 Formulae for tolerances and deviations

3.1.1 Nominal diameter steps for metric and inch values

For the sake of simplicity, the formulae given in clauses 3.1.2 and 3.1.3 for the calculation of standard tolerances and fundamental deviations are applied to suit the nominal diameter steps shown in Table 10 below; the results have been computed on the geometrical mean D of the extreme diameters of each step, and apply to all diameters of this step.

TABLE 10. — Nominal diameter steps

Nominal diameter steps							
Main steps				Intermediate steps **			
Millimetres		Inches		Millimetres		Inches	
above	up to	above	up to	above	up to	above	up to
500	630	19.69	24.81	500	560	19.69	22.05
				560	630	22.05	24.81
630	800	24.81	31.50	630	710	24.81	27.96
				710	800	27.96	31.50
800	1000	31.50	39.38	800	900	31.50	35.44
				900	1000	35.44	39.38
1000	1250	39.38	49.22	1000	1120	39.38	44.10
				1120	1250	44.10	49.22
1250	1600	49.22	63.00	1250	1400	49.22	55.12
				1400	1600	55.12	63.00
1600	2000	63.00	78.75	1600	1800	63.00	70.87
				1800	2000	70.87	78.75
2000	2500	78.75	98.43	2000	2240	78.75	88.19
				2240	2500	88.19	98.43
2500	3150	98.43	124.02	2500	2800	98.43	110.24
				2800	3150	110.24	125.02

* Section 3 is given only as a provisional ISO Recommendation.

** For deviations r to u and R to U.

3.1.2 Tolerances

In order that commonly used tolerance grades for sizes below 500 mm may be employed analogically with diameters above 500 mm, eleven grades, 6 to 16, are provided, each corresponding to one of the standard tolerances called IT 6 to IT 16, the numerical values of which are given, for each nominal diameter step, in Table 15, page 33.

For these grades, the values are determined from the tolerance unit I , as follows:

when I is expressed in microns for D expressed in millimetres,

$$I = 0.004 D + 2.1$$

when I is expressed in 0.001 in for D expressed in inches,

$$I = 0.004 D + 0.083$$

The values of the standard tolerances corresponding to grades 6 to 16 are given in Table 11 below in terms of the tolerance unit I :

TABLE 11. — Values of the standard tolerances corresponding to grades 6 to 16

	IT 6	IT 7	IT 8	IT 9	IT 10	IT 11	IT 12	IT 13	IT 14	IT 15	IT 16
Values	10 I	16 I	25 I	40 I	64 I	100 I	160 I	250 I	400 I	640 I	1000 I

NOTE. — The tolerance is multiplied by 10 at each fifth step. This rule applies also, if necessary, beyond IT 16.

3.1.3 Deviations

Formulae are established to enable the magnitude and sign of upper and lower deviations for shafts and holes to be determined for each symbol—letter and number—selected by ISO.

For each letter symbol, defining the position of the tolerance zone, the magnitude and sign of one of the two deviations, known as the fundamental deviation (upper deviations es and ES or lower deviations ei and EI), (see Fig. 1, page 6), are determined by means of the formulae in Table 12, page 31.

The other deviation is derived from the first one, using the magnitude of the tolerance IT , by means of the following algebraic relationships:

$$ei = es - IT$$

$$EI = ES - IT$$

$$es = ei + IT$$

$$ES = EI + IT$$

It will be noted that

- (1) except in the case of shafts and holes js J_s , the value of the deviation shown in the Table is independent of the given grade;
- (2) the fundamental deviation given by the formulae in this Table is in principle that corresponding to the limit closest to the zero line, in other words

the upper deviation es for shafts d to h , and
the lower deviation ei for shafts k to u ,

or

the lower deviation EI for holes D to H , and
the upper deviation ES for holes P to U ;

- (3) the variety of letter symbols defining the position of the tolerance zones is not so great as for sizes up to 500 mm.

The values for these deviations, rounded according to the instructions in clause 3.1.4, are given in Table 16, page 35.

TABLE 12. — Formulae for fundamental shaft and hole deviations

Shafts			Formulae for deviations		Holes		
			Values in microns for D in millimetres	Values in 0.001 in for D in inches			
d	es	—	16 $D^{0.44}$	2.62 $D^{0.44}$	+	EI	D
e	es	—	11 $D^{0.41}$	1.63 $D^{0.41}$	+	EI	E
f	es	—	5.5 $D^{0.41}$	0.82 $D^{0.41}$	+	EI	F
(g)	es	—	2.5 $D^{0.34}$	0.3 $D^{0.34}$	+	EI	(G)
h	es	—	0		+	EI	H
j_s	ei	—	0.5 IT_n		+	ES	J_s
k	ei	+	0		—	ES	K
m	ei	+	0.024 $D + 12.6$	0.024 $D + 0.5$	—	ES	M
n	ei	+	0.04 $D + 21$	0.04 $D + 0.83$	—	ES	N
p	ei	+	0.072 $D + 37.8$	0.072 $D + 1.50$	—	ES	P*
r	ei	+	Geometric mean of values ei for p and s or ES for P and S		—	ES	R*
s	ei	+	$IT 7 + 0.4 D$		—	ES	S*
t	ei	+	$IT 7 + 0.63 D$		—	ES	T*
u	ei	+	$IT 7 + D$		—	ES	U*

* Pending the establishment of an ISO Recommendation giving directives for the application of the ISO System of Limits and Fits, it is assumed that associated shafts and holes are of the same grade (contrary to what is allowed for the dimensions up to 500 mm (19.69 in)).

3.1.4 Rules for rounding off

3.1.4.1 METRIC VALUES

The values which result, in each diameter step, from the use of the formulae given in clause 3.1.2 for the standard tolerances, and those given in Table 12 for fundamental shaft and hole deviations, are rounded off according to the following rules:

TABLE 13. — Roundings of metric values

VALUES IN MICRONS

Values above	—	60	100	200	500	1000	2000	...	...	20×10^n	50×10^n	100×10^n
Values up to	60	100	200	500	1000	2000	5000	...	...	50×10^n	100×10^n	200×10^n
Rounding in multiples of	1	2	5	10	20	50	100	...	...	1×10^n	2×10^n	5×10^n

NOTE. — As an exception to these rules, some values are rounded in a different way, to ensure a better scaling.

3.1.4.2 Inch values

Each inch value for standard tolerances and fundamental deviations of shafts and holes, converted from the corresponding metric value, is expressed as the nearest value extracted from Table 6, page 20.

3.2 Determination of limit deviations for each shaft or hole symbol

Tables established on the basis of the rules and formulae in clause 3.1 and in Table 12, page 31, allow calculating both limit deviations corresponding to any symbol (letter and number) of the System. These tables appear on pages 32 to 35 for both metric and inch values.

Many of these deviations will probably not be necessary. The following Table 14 shows, as an example for study, a selection of shafts and holes used in certain industries.

TABLE 14. — Limit deviations for a selection of shafts and holes

Letters	A	B	C	D	E	F	G	H	J _s	K	M	N	P	R	S	T	U	V	X	Y	Z
	a	b	c	d	e	f	g	h	j _s	k	m	n	p	r	s	t	u	v	x	y	z
Grades	6						+	+	+	+	+	+	+	+	+						
	7						+	+	+	+				+	+	+	+	+	+	+	+
	8				+	+		+	+	+											
	9				+	+		+	+												
	10			+				+	+												
	11							+	+												
	12							+	+												
	13							+	+												
	14							+	+												
	15							+	+												
	16							+	+												

NOTE. — In the present state of metrology, it is recommended that shafts and holes for fits of parts in grades 6 or 7 be made in the same shop, and that the measurement of fits in those grades be carried out with the greatest care.

3.2.1 Standard tolerances

The numerical values of the standard tolerances are given in Table 15 below, for each grade 6 to 16, in each diameter step. For easier reading, these values are expressed, in the metric table,

in microns for grades 6 to 11, and

in millimetres for grades 12 to 16.

TABLE 15. — Numerical values of standard tolerances

1. Metric values

Grades		6	7	8	9	10	11	12	13	14	15	16
		Values in microns						Values in millimetres				
Standard tolerances in microns ($1 \mu = 0.001 \text{ mm}$) for diameter steps in millimetres	> 500 to 630	44	70	110	175	280	440	0.7	1.1	1.75	2.8	4.4
	> 630 to 800	50	80	125	200	320	500	0.8	1.25	2.0	3.2	5.0
	> 800 to 1000	56	90	140	230	360	560	0.9	1.4	2.3	3.6	5.6
	> 1000 to 1250	66	105	165	260	420	660	1.05	1.65	2.6	4.2	6.6
	> 1250 to 1600	78	125	195	310	500	780	1.25	1.95	3.1	5.0	7.8
	> 1600 to 2000	92	150	230	370	600	920	1.5	2.3	3.7	6.0	9.2
	> 2000 to 2500	110	175	280	440	700	1100	1.75	2.8	4.4	7.0	11.0
	> 2500 to 3150	135	210	330	540	860	1350	2.1	3.3	5.4	8.6	13.5

2. Inch values

Grades		6	7	8	9	10	11	12	13	14	15	16
		Values in 0.001 in										
Standard tolerances in 0.001 in for diameter steps in inches	> 19.69 to 24.81	1.8	2.8	4.5	7	12	18	28	45	70	120	180
	> 24.81 to 31.50	2.0	3.0	5	8	12	20	30	50	80	120	200
	> 31.50 to 39.38	2.2	3.5	6	9	14	22	35	60	90	140	220
	> 39.38 to 49.22	2.5	4	7	10	16	25	40	70	100	160	250
	> 49.22 to 63.00	3.0	5	8	12	20	30	50	80	120	200	300
	> 63.00 to 78.75	3.5	6	9	14	25	35	60	90	140	250	350
	> 78.75 to 98.43	4.0	7	10	18	28	40	70	100	180	280	400
	> 98.43 to 124.02	5.0	8	12	22	35	50	80	120	220	350	500

3.2.2 Fundamental shaft and hole deviations

Table 16, page 35, for shafts and holes, gives, in the conditions indicated below, the numerical values for each of the two deviations of each symbol for each diameter step.

Shafts

One of the two deviations (upper deviation es for shafts d to h , and lower deviation ei for shafts js to u) is given directly in Table 16.

The other deviation is derived by subtracting or adding, as the case may be, the IT value of the standard tolerance as given in clause 3.2.1 for the grade in question.

The only exceptions are shafts js , for which the two deviations are calculated only in terms of IT, as indicated in the footnote to Table 16.

Holes

Hole deviations, symmetrical, with regard to the zero line, to those of the shafts, are given in a similar way in Table 16.

3.2.3 Important recommendations

Due to the significance of errors of measurement, shafts and holes for fits are not recommended at the present time in grades finer than 7. Attention is also drawn to the difficulty of tooling parts in grade 7 itself.

Moreover, the manufacturer should take the necessary precautions to cover all the errors of the checking instruments and of the measuring method (errors for which the numerical values are not as yet given), in order to remain within the limiting dimensions.

TABLE 16. — Numerical values of shaft and hole deviations

es — ES = upper deviation ei — EI = lower deviation IT = Standard tolerance

1. Metric values

Shafts	Sym-bols	Deviations	Letter	d	e	f	(g)	h	j _s	k	m	n	p	r	s	t	u	
			Grade	6 to 16														
			In the table	es						*	ei							
			Calculated	ei = es - IT							es = ei + IT							
			Sign	-	-	-	-			+	+	+	+	+	+	+	+	
Values of deviations in microns (1 μ = 0.001 mm)	for diameter steps in millimetres	> 500 to 560													150	280	400	600
		> 560 to 630	260	145	76	22	0		0	26	44	78			155	310	450	660
		> 630 to 710													175	340	500	740
		> 710 to 800	290	160	80	24	0		0	30	50	88			185	380	560	840
		> 800 to 900													210	430	620	940
		> 900 to 1000	320	170	86	26	0		0	34	56	100			220	470	680	1050
		> 1000 to 1120													250	520	780	1150
		> 1120 to 1250	350	195	98	28	0		0	40	66	120			260	580	840	1300
		> 1250 to 1400													300	640	960	1450
		> 1400 to 1600	390	220	110	30	0		0	48	78	140			330	720	1050	1600
		> 1600 to 1800													370	820	1200	1850
		> 1800 to 2000	430	240	120	32	0		0	58	92	170			400	920	1350	2000
		> 2000 to 2240													440	1000	1500	2300
		> 2240 to 2500	480	260	130	34	0		0	68	110	195			460	1100	1650	2500
		> 2500 to 2800													550	1250	1900	2900
		> 2800 to 3150	520	290	145	38	0		0	76	135	240			580	1400	2100	3200
Holes	Sym-bols	Deviations	Sign	+	+	+	+			-	-	-	-	-	-	-	-	
		Calculated	ES = EI + IT						*	EI = ES - IT								
		In the table	EI							ES								
		Grade	6 to 16															
		Letter	D	E	F	(G)	H	J _s	K	M	N	P	R	S	T	U		

* For j_s and J_s , each of the upper and lower deviations is equal to IT/2.

2. Inch values

Shafts	Sym-bols	Letter	d	e	f	(g)	h	j _s	k	m	n	p	r	s	t	u	
		Grade	6 to 16														
	Devia-tions	In the table	es						*	ei							
		Calculated	ei = es - IT							es = ei + IT							
		Sign	-	-	-	-				+	+	+	+	+	+	+	+
Values of deviations in 0.001 in for diameter steps in inches		> 19.69 to 22.05	10	6	3	0.9	0		0	1	1.8	3	6	12	16	25	
		> 22.05 to 24.81											6	12	18	25	
		> 24.81 to 27.96	12	6	3	0.9	0		0	1.2	2	3.5	7	14	20	30	
		> 27.96 to 31.50											7	14	22	35	
		> 31.50 to 35.44											8	16	25	35	
		> 35.44 to 39.38	12	7	3.5	1.0	0		0	1.4	2.2	4	9	18	28	40	
		> 39.38 to 44.10											10	20	30	45	
		> 44.10 to 49.22	14	8	4	1.0	0		0	1.6	2.5	4.5	10	22	35	50	
		> 49.22 to 55.12											12	25	40	60	
		> 55.12 to 63.00	16	9	4.5	1.2	0		0	1.8	3	6	12	28	40	60	
		> 63.00 to 70.87											14	30	45	70	
		> 70.87 to 78.75	16	9	4.5	1.2	0		0	2.2	3.5	7	16	35	50	80	
		> 78.75 to 88.19											18	40	60	90	
		> 88.19 to 98.43	18	10	5	1.4	0		0	2.5	4.5	8	18	45	60	100	
		> 98.43 to 110.24											22	50	70	110	
		> 110.24 to 124.02	20	12	6	1.4	0		0	3	5	9	22	60	80	120	
Holes	Devia-tions	Sign	+	+	+	+			-	-	-	-	-	-	-	-	
		Calculated	ES = EI + IT						*	EI = ES - IT							
		In the table	EI							ES							
	Sym-bols	Grade	6 to 16														
		Letter	D	E	F	(G)	H	J _s	K	M	N	P	R	S	T	U	

* For j_s and J_s , each of the upper and lower deviations is equal to IT/2, rounded, if necessary, to the value immediately above it, extracted from Table 6.

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APPENDIX

COMMONLY USED SHAFTS AND HOLES

FOR GENERAL PURPOSES UP TO 500 mm (19.69 in)

FOR FINE MECHANISMS AND HOROLOGY UP TO 18 mm (0.71 in)

SUMMARY

General purposes

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Fine mechanisms and horology

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GENERAL PURPOSES *

SYNOPTIC TABLE OF PARTS FOR FITS
WHOSE DEVIATIONS ARE SHOWN IN THE FOLLOWING TABLES

SHAFTS

Letter	a	b	c	d	e	f	g	h	j	j _s	k	m	n	p	r	s	t	u	v	x	y	z	za	zb	zc
1								+		+															
2								+		+															
3								+		+															
4						+	+	+		+	+	+	+	+	+	+									
5				+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+					
6				+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	
7				+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	
8		+	+	+	+	+		+		+								+		+			+	+	
9	+	+	+	+	+	+		+		+															
10				+				+		+															
11	+	+	+	+				+		+															
12								+		+															
13								+		+															
14								+		+															
15								+		+															
16								+		+															

HOLES

Letter	A	B	C	D	E	F	G	H	J	j _s	K	M	N	P	R	S	T	U	V	X	Y	Z	ZA	ZB	ZC
1								+		+															
2								+		+															
3								+		+															
4								+		+															
5					+	+	+	+		+	+	+	+	+	+	+									
6				+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+					
7				+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	
8		+	+	+	+	+		+	+	+	+	+	+	+	+							+	+	+	+
9	+	+	+	+	+	+		+		+			+	+									+	+	+
10				+	+			+		+			+												
11	+	+	+	+				+		+			+												
12								+		+															
13								+		+															
14								+		+															
15								+		+															
16								+		+															

* The symbols retained are those for shafts and holes which might be considered as the most commonly used (taking account, in particular, of existing national standards) either in the whole range of diameter steps up to 500 mm (19.69 in) or, for some of the diameter steps, in a more limited field (see tables).

GENERAL PURPOSE COMMONLY USED SHAFTS

es = upper deviation
ei = lower deviation

1. Metric values

Symbol	Letter	a *			b *				c					
	Grade	9 and 11	9	11	8 - 9 and 11	8	9	11	8 - 9 and 11	8	9	11	5 to 11	
Deviations		es	ei		es	ei			es	ei			es	
Values of deviations in microns (1 μ = 0.001 mm)	for diameter steps in millimetres													
	≤ 3	-270	-295	-330	-140	-154	-165	-200	-60	-74	-85	-120	-20	
	>3 to 6	-270	-300	-345	-140	-158	-170	-215	-70	-88	-100	-145	-30	
	>6 to 10	-280	-316	-370	-150	-172	-186	-240	-80	-102	-116	-170	-40	
	>10 to 18	-290	-333	-400	-150	-177	-193	-260	-95	-122	-138	-205	-50	
	>18 to 30	-300	-352	-430	-160	-193	-212	-290	-110	-143	-162	-240	-65	
	>30 to 40	-310	-372	-470	-170	-209	-232	-330	-120	-159	-182	-280	-80	
	>40 to 50	-320	-382	-480	-180	-219	-242	-340	-130	-169	-192	-290	-90	
	>50 to 65	-340	-414	-530	-190	-236	-264	-380	-140	-186	-214	-330	-100	
	>65 to 80	-360	-434	-550	-200	-246	-274	-390	-150	-196	-224	-340	-110	
	>80 to 100	-380	-467	-600	-220	-274	-307	-440	-170	-224	-257	-390	-120	
	>100 to 120	-410	-497	-630	-240	-294	-327	-460	-180	-234	-267	-400	-130	
	>120 to 140	-460	-560	-710	-260	-323	-360	-510	-200	-263	-300	-450	-140	
	>140 to 160	-520	-620	-770	-280	-343	-380	-530	-210	-273	-310	-460	-145	
	>160 to 180	-580	-680	-830	-310	-373	-410	-560	-230	-293	-330	-480	-155	
	>180 to 200	-660	-775	-950	-340	-412	-455	-630	-240	-312	-355	-530	-165	
	>200 to 225	-740	-855	-1030	-380	-452	-495	-670	-260	-332	-375	-550	-170	
	>225 to 250	-820	-935	-1110	-420	-492	-535	-710	-280	-352	-395	-570	-180	
	>250 to 280	-920	-1050	-1240	-480	-561	-610	-800	-300	-381	-430	-620	-190	
	>280 to 315	-1050	-1180	-1370	-540	-621	-670	-860	-330	-411	-460	-650	-200	
	>315 to 355	-1200	-1340	-1560	-600	-689	-740	-960	-360	-449	-500	-720	-210	
	>355 to 400	-1350	-1490	-1710	-680	-769	-820	-1040	-400	-489	-540	-760	-220	
	>400 to 450	-1500	-1655	-1900	-760	-857	-915	-1160	-440	-537	-595	-840	-230	
	>450 to 500	-1650	-1805	-2050	-840	-937	-995	-1240	-480	-577	-635	-880	-240	

Numerical values amended from the former ISA System are framed in a bold line.

* The deviations a and b are not provided for diameters up to 1 mm.

2. Inch values

Symbol	Lettre	a *			b *				c					
	Grade	9 and 11	9	11	8 - 9 and 11	8	9	11	8 - 9 and 11	8	9	11	5 to 11	
Deviations		es	ei		es	ei			es	ei			es	
Values of deviations in 0.001 in	for diameter steps in inches													
	≤ 0.12	-10	-11	-12.5	-5	-5.6	-6	-7.5	-2.5	-3.1	-3.5	-5	-1	
	>0.12 to 0.24	-10	-11.2	-13	-5	-5.7	-6.2	-8	-2.8	-3.5	-4	-5.8	-1.2	
	>0.24 to 0.40	-10	-11.4	-13.5	-6	-6.9	-7.4	-9.5	-3	-3.9	-4.4	-6.5	-1.6	
	>0.40 to 0.71	-12	-13.6	-16	-6	-7	-7.6	-10	-3.5	-4.5	-5.1	-7.5	-2	
	>0.71 to 1.19	-12	-14	-17	-6	-7.2	-8	-11	-4.5	-5.7	-6.5	-9.5	-2.5	
	>1.19 to 1.58	-12	-14.5	-18	-7	-8.6	-9.5	-13	-5	-6.6	-7.5	-11	-3	
	>1.58 to 1.97	-12	-14.5	-18	-7	-8.6	-9.5	-13	-5	-6.6	-7.5	-11	-3	
	>1.97 to 2.56	-14	-17	-21	-8	-9.8	-11	-15	-6	-7.8	-9	-13	-4	
	>2.56 to 3.15	-14	-17	-21	-8	-9.8	-11	-15	-6	-7.8	-9	-13	-4	
	>3.15 to 3.94	-16	-19.5	-25	-9	-11.2	-12.5	-18	-7	-9.2	-10.5	-16	-5	
	>3.94 to 4.73	-16	-19.5	-25	-9	-11.2	-12.5	-18	-7	-9.2	-10.5	-16	-5	
	>4.73 to 5.52	-20	-24	-30	-12	-14.5	-16	-22	-8	-10.5	-12	-18	-6	
	>5.52 to 6.30	-20	-24	-30	-12	-14.5	-16	-22	-8	-10.5	-12	-18	-6	
	>6.30 to 7.09	-20	-24	-30	-12	-14.5	-16	-22	-8	-10.5	-12	-18	-6	
	>7.09 to 7.88	-30	-34.5	-42	-16	-18.8	-20.5	-28	-10	-12.8	-14.5	-22	-7	
	>7.88 to 8.86	-30	-34.5	-42	-16	-18.8	-20.5	-28	-10	-12.8	-14.5	-22	-7	
	>8.86 to 9.85	-30	-34.5	-42	-16	-18.8	-20.5	-28	-10	-12.8	-14.5	-22	-7	
	>9.85 to 11.03	-40	-45	-52	-20	-23	-25	-32	-12	-15	-17	-24	-7	
	>11.03 to 12.41	-40	-45	-52	-20	-23	-25	-32	-12	-15	-17	-24	-7	
	>12.41 to 13.98	-50	-56	-64	-25	-28.5	-31	-39	-14	-17.5	-20	-28	-8	
	>13.98 to 15.75	-50	-56	-64	-25	-28.5	-31	-39	-14	-17.5	-20	-28	-8	
	>15.75 to 17.72	-60	-66	-76	-30	-34	-36	-46	-16	-20	-22	-32	-9	
	>17.72 to 19.69	-60	-66	-76	-30	-34	-36	-46	-16	-20	-22	-32	-9	

* The deviations a and b are not provided for diameters up to 0.04 in.

(1) 39-40

GENERAL PURPOSES COMMONLY USED SHAFTS

GENERAL PURPOSES

1. Metric values

Shafts a to e

c			d								e					
	9	11	5 to 11	5	6	7	8	9	10	11	5 to 9	5	6	7	8	9
ei			es	ei							es	ei				
74	-85	-120	-20	-24	-26	-30	-34	-45	-60	-80	-14	-18	-20	-24	-28	-39
88	-100	-145	-30	-35	-38	-42	-48	-60	-78	-105	-20	-25	-28	-32	-38	-50
102	-116	-170	-40	-46	-49	-55	-62	-76	-98	-130	-25	-31	-34	-40	-47	-61
122	-138	-205	-50	-58	-61	-68	-77	-93	-120	-160	-32	-40	-43	-50	-59	-75
143	-162	-240	-65	-74	-78	-86	-98	-117	-149	-195	-40	-49	-53	-61	-73	-92
169	-182	-280	-80	-91	-96	-105	-119	-142	-180	-240	-50	-61	-66	-75	-89	-112
189	-192	-290														
216	-214	-330														
246	-224	-340	-100	-113	-119	-130	-146	-174	-220	-290	-60	-73	-79	-90	-106	-134
284	-257	-390	-120	-135	-142	-155	-174	-207	-260	-340	-72	-87	-94	-107	-126	-159
324	-267	-400														
363	-300	-450														
403	-310	-460	-145	-163	-170	-185	-208	-245	-305	-395	-85	-103	-110	-125	-148	-185
443	-330	-480	-170	-190	-199	-216	-242	-285	-355	-460	-100	-120	-129	-146	-172	-215
482	-355	-530														
522	-375	-550														
562	-395	-570	-190	-213	-222	-242	-271	-320	-400	-510	-110	-133	-142	-162	-191	-240
601	-430	-620														
641	-460	-650														
689	-500	-720	-210	-235	-246	-267	-299	-350	-440	-570	-125	-150	-161	-182	-214	-265
729	-540	-760														
767	-595	-840														
807	-635	-880	-230	-257	-270	-293	-327	-385	-480	-630	-135	-162	-175	-198	-232	-290

2. Inch values

c			d								e					
	9	11	5 to 11	5	6	7	8	9	10	11	5 to 9	5	6	7	8	9
ei			es	ei							es	ei				
1.1	-3.5	-5	-1	-1.15	-1.25	-1.4	-1.6	-2	-2.6	-3.5	-0.6	-0.75	-0.85	-1	-1.2	-1.6
1.5	-4	-5.8	-1.2	-1.4	-1.5	-1.7	-1.9	-2.4	-3	-4.2	-0.8	-1	-1.1	-1.3	-1.5	-2
1.9	-4.4	-6.5	-1.6	-1.85	-2	-2.2	-2.5	-3	-3.8	-5.1	-1	-1.25	-1.4	-1.6	-1.9	-2.4
2.5	-5.1	-7.5	-2	-2.3	-2.4	-2.7	-3	-3.6	-4.8	-6	-1.2	-1.5	-1.6	-1.9	-2.2	-2.8
3.1	-6.5	-9.5	-2.5	-2.9	-3	-3.3	-3.7	-4.5	-6	-7.5	-1.6	-2	-2.1	-2.4	-2.8	-3.6
3.6	-7.5	-11	-3	-3.4	-3.6	-4	-4.6	-5.5	-7	-9	-2	-2.4	-2.6	-3	-3.6	-4.5
4.8	-9	-13	-4	-4.5	-4.7	-5.2	-5.8	-7	-8.5	-11	-2.5	-3	-3.2	-3.7	-4.3	-5.5
6.2	-10.5	-16	-5	-5.6	-5.9	-6.4	-7.2	-8.5	-10	-14	-3	-3.6	-3.9	-4.4	-5.2	-6.5
7.5	-12	-18	-6	-6.7	-7	-7.6	-8.5	-10	-12	-16	-3.5	-4.2	-4.5	-5.1	-6	-7.5
8.8	-14.5	-22	-7	-7.8	-8.2	-8.8	-9.8	-11.5	-14	-19	-4	-4.8	-5.2	-5.8	-6.8	-8.5
10	-17	-24	-7	-7.9	-8.2	-9	-10	-12	-15	-19	-4.5	-5.4	-5.7	-6.5	-7.5	-9.5
12.5	-20	-28	-8	-9	-9.4	-10.2	-11.5	-14	-17	-22	-5	-6	-6.4	-7.2	-8.5	-11
15	-22	-32	-9	-10	-10.6	-11.5	-13	-15	-19	-25	-5	-6	-6.6	-7.5	-9	-11

es = upper deviation
ei = lower deviation

1. Metric values

Symbol	Letter	f							g												
	Grade	4 to 9	4	5	6	7	8	9	4 to 7	4	5	6	7	1 to 16	1	2	3	4	5		
Deviations		es	ei							es	ei					es					
Values of deviations in microns (1 μ = 0.001 mm)	* ≤ 3	-6	-9	-10	-12	-16	-20	-31	-2	-5	-6	-8	-12	0	-0.8	-1.2	-2	-3	-		
	>3 to 6	-10	-14	-15	-18	-22	-28	-40	-4	-8	-9	-12	-16	0	-1	-1.5	-2.5	-4	-		
	>6 to 10	-13	-17	-19	-22	-28	-35	-49	-5	-9	-11	-14	-20	0	-1	-1.5	-2.5	-4	-		
	>10 to 18	-16	-21	-24	-27	-34	-43	-59	-6	-11	-14	-17	-24	0	-1.2	-2	-3	-5	-		
	>18 to 30	-20	-26	-29	-33	-41	-53	-72	-7	-13	-16	-20	-28	0	-1.5	-2.5	-4	-6	-		
	>30 to 50	-25	-32	-36	-41	-50	-64	-87	-9	-16	-20	-25	-34	0	-1.5	-2.5	-4	-7	-1		
	>50 to 80	-30	-38	-43	-49	-60	-76	-104	-10	-18	-23	-29	-40	0	-2	-3	-5	-8	-1		
	>80 to 120	-36	-46	-51	-58	-71	-90	-123	-12	-22	-27	-34	-47	0	-2.5	-4	-6	-10	-1		
	>120 to 180	-43	-55	-61	-68	-83	-106	-143	-14	-26	-32	-39	-54	0	-3.5	-5	-8	-12	-1		
	>180 to 250	-50	-64	-70	-79	-96	-122	-165	-15	-29	-35	-44	-61	0	-4.5	-7	-10	-14	-2		
	>250 to 315	-56	-72	-79	-88	-108	-137	-186	-17	-33	-40	-49	-69	0	-6	-8	-12	-16	-2		
	>315 to 400	-62	-80	-87	-98	-119	-151	-202	-18	-36	-43	-54	-75	0	-7	-9	-13	-18	-2		
>400 to 500	-68	-88	-95	-108	-131	-165	-223	-20	-40	-47	-60	-83	0	-8	-10	-15	-20	-2			

* Up to 1 mm, the grades 14 to 16 are not given.

Numerical values amended from the former ISA System are framed in a bold line.

2. Inch values

Symbol	Letter	f							g												
	Grade	4 to 9	4	5	6	7	8	9	4 to 7	4	5	6	7	1 to 16	1	2	3	4	5		
Deviations		es	ei							es	ei					es					
Values of deviations in 0.001 in for diameter steps in inches	* <0.12	-0.3	-0.42	-0.45	-0.55	-0.7	-0.9	-1.3	-0.1	-0.22	-0.25	-0.35	-0.5	0	-0.03	-0.05	-0.08	-0.12	-0.2		
	>0.12 to 0.24	-0.4	-0.55	-0.6	-0.7	-0.9	-1.1	-1.6	-0.15	-0.3	-0.35	-0.45	-0.65	0	-0.04	-0.06	-0.10	-0.15	-0.3		
	>0.24 to 0.40	-0.5	-0.65	-0.75	-0.9	-1.1	-1.4	-1.9	-0.2	-0.35	-0.45	-0.6	-0.8	0	-0.04	-0.06	-0.10	-0.15	-0.3		
	>0.40 to 0.71	-0.6	-0.8	-0.9	-1	-1.3	-1.6	-2.2	-0.25	-0.45	-0.55	-0.65	-0.95	0	-0.05	-0.08	-0.12	-0.2	-0.4		
	>0.71 to 1.19	-0.8	-1.05	-1.2	-1.3	-1.6	-2	-2.8	-0.3	-0.55	-0.7	-0.8	-1.1	0	-0.06	-0.10	-0.15	-0.25	-0.5		
	>1.19 to 1.97	-1	-1.3	-1.4	-1.6	-2	-2.6	-3.5	-0.4	-0.7	-0.8	-1	-1.4	0	-0.06	-0.10	-0.15	-0.3	-0.6		
	>1.97 to 3.15	-1.2	-1.5	-1.7	-1.9	-2.4	-3	-4.2	-0.4	-0.7	-0.9	-1.1	-1.6	0	-0.08	-0.12	-0.20	-0.3	-0.8		
	>3.15 to 4.73	-1.4	-1.8	-2	-2.3	-2.8	-3.6	-4.9	-0.5	-0.9	-1.1	-1.4	-1.9	0	-0.1	-0.15	-0.25	-0.4	-1		
	>4.73 to 7.09	-1.6	-2.1	-2.3	-2.6	-3.2	-4.1	-5.6	-0.6	-1.1	-1.3	-1.6	-2.2	0	-0.12	-0.2	-0.3	-0.5	-1.2		
	>7.09 to 9.85	-2	-2.6	-2.8	-3.2	-3.8	-4.8	-6.5	-0.6	-1.2	-1.4	-1.8	-2.4	0	-0.20	-0.3	-0.4	-0.6	-1.5		
	>9.85 to 12.41	-2.2	-2.8	-3.1	-3.4	-4.2	-5.2	-7.2	-0.7	-1.3	-1.6	-1.9	-2.7	0	-0.25	-0.3	-0.5	-0.6	-1.8		
	>12.41 to 15.75	-2.5	-3.2	-3.5	-3.9	-4.7	-6	-8.5	-0.7	-1.4	-1.7	-2.1	-2.9	0	-0.3	-0.4	-0.5	-0.7	-2		
	>15.75 to 19.69	-2.8	-3.6	-3.8	-4.4	-5.3	-6.8	-8.8	-0.8	-1.6	-1.8	-2.4	-3.3	0	-0.3	-0.4	-0.6	-0.8	-2.5		

* Up to 0.04 in, the grades 14 to 16 are not given.

(1) 41-42

1. Metric values

Shafts f to j

h																j					
1	2	3	4	5	6	7	8	9	10	11	12	13	14*	15*	16*	5		6		7	
ei																es	ei	es	ei	es	ei
0.8	-1.2	-2	-3	-4	-6	-10	-14	-25	-40	-60	-100	-140	-250	-400	-600	+2	-2	+4	-2	+6	-4
1	-1.5	-2.5	-4	-5	-8	-12	-18	-30	-48	-75	-120	-180	-300	-480	-750	+3	-2	+6	-2	+8	-4
1.1	-1.5	-2.5	-4	-6	-9	-15	-22	-36	-58	-90	-150	-220	-360	-580	-900	+4	-2	+7	-2	+10	-5
1.2	-2	-3	-5	-8	-11	-18	-27	-43	-70	-110	-180	-270	-430	-700	-1100	+5	-3	+8	-3	+12	-6
1.5	-2.5	-4	-6	-9	-13	-21	-33	-52	-84	-130	-210	-330	-520	-840	-1300	+5	-4	+9	-4	+13	-8
1.5	-2.5	-4	-7	-11	-16	-25	-39	-62	-100	-160	-250	-390	-620	-1000	-1600	+6	-5	+11	-5	+15	-10
2	-3	-5	-8	-13	-19	-30	-46	-74	-120	-190	-300	-460	-740	-1200	-1900	+6	-7	+12	-7	+18	-12
2.5	-4	-6	-10	-15	-22	-35	-54	-87	-140	-220	-350	-540	-870	-1400	-2200	+6	-9	+13	-9	+20	-15
3.5	-5	-8	-12	-18	-25	-40	-63	-100	-160	-250	-400	-630	-1000	-1600	-2500	+7	-11	+14	-11	+22	-18
4.5	-7	-10	-14	-20	-29	-46	-72	-115	-185	-290	-460	-720	-1150	-1850	-2900	+7	-13	+16	-13	+25	-21
5	-8	-12	-16	-23	-32	-52	-81	-130	-210	-320	-520	-810	-1300	-2100	-3200	+7	-16	+16	-16	+26	-26
7	-9	-13	-18	-25	-36	-57	-89	-140	-230	-360	-570	-890	-1400	-2300	-3600	+7	-18	+18	-18	+29	-28
8	-10	-15	-20	-27	-40	-63	-97	-155	-250	-400	-630	-970	-1550	-2500	-4000	+7	-20	+20	-20	+31	-32

2. Inch values

h																j					
1	2	3	4	5	6	7	8	9	10	11	12	13	14*	15*	16*	5		6		7	
ei																es	ei	es	ei	es	ei
0.03	-0.05	-0.08	-0.12	-0.15	-0.25	-0.4	-0.6	-1	-1.6	-2.5	-4	-6	-10	-16	-25	+0.05	-0.1	+0.15	-0.1	+0.25	-0.15
0.04	-0.06	-0.10	-0.15	-0.2	-0.3	-0.5	-0.7	-1.2	-1.8	-3	-5	-7	-12	-18	-30	+0.1	-0.1	+0.2	-0.1	+0.35	-0.15
0.04	-0.06	-0.10	-0.15	-0.25	-0.4	-0.6	-0.9	-1.4	-2.2	-3.5	-6	-9	-14	-22	-35	+0.15	-0.1	+0.3	-0.1	+0.4	-0.2
0.05	-0.08	-0.12	-0.2	-0.3	-0.4	-0.7	-1	-1.6	-2.8	-4	-7	-10	-16	-28	-40	+0.2	-0.1	+0.3	-0.1	+0.5	-0.2
0.06	-0.10	-0.15	-0.25	-0.4	-0.5	-0.8	-1.2	-2	-3.5	-5	-8	-12	-20	-35	-50	+0.2	-0.2	+0.3	-0.2	+0.5	-0.3
0.06	-0.10	-0.15	-0.3	-0.4	-0.6	-1	-1.6	-2.5	-4	-6	-10	-16	-25	-40	-60	+0.2	-0.2	+0.4	-0.2	+0.6	-0.4
0.08	-0.12	-0.20	-0.3	-0.5	-0.7	-1.2	-1.8	-3	-4.5	-7	-12	-18	-30	-45	-70	+0.2	-0.3	+0.4	-0.3	+0.7	-0.5
0.1	-0.15	-0.25	-0.4	-0.6	-0.9	-1.4	-2.2	-3.5	-5	-9	-14	-22	-35	-50	-90	+0.2	-0.4	+0.5	-0.4	+0.8	-0.6
0.12	-0.2	-0.3	-0.5	-0.7	-1	-1.6	-2.5	-4	-6	-10	-16	-25	-40	-60	-100	+0.3	-0.4	+0.6	-0.4	+0.9	-0.7
0.20	-0.3	-0.4	-0.6	-0.8	-1.2	-1.8	-2.8	-4.5	-7	-12	-18	-28	-45	-70	-120	+0.3	-0.5	+0.7	-0.5	+1	-0.8
0.25	-0.3	-0.5	-0.6	-0.9	-1.2	-2	-3	-5	-8	-12	-20	-30	-50	-80	-120	+0.3	-0.6	+0.7	-0.6	+1	-1
0.3	-0.4	-0.5	-0.7	-1	-1.4	-2.2	-3.5	-6	-9	-14	-22	-35	-60	-90	-140	+0.3	-0.7	+0.7	-0.7	+1.2	-1
0.3	-0.4	-0.6	-0.8	-1	-1.6	-2.5	-4	-6	-10	-16	-25	-40	-60	-100	-160	+0.3	-0.7	+0.9	-0.7	+1.3	-1.2

es = upper deviation
ei = lower deviation

1. Metric values

Symbol	Letter																
	Grade	1		2		3		4		5		6		7		8	
Deviations		es	ei	es	ei	es	ei	es	ei	es	ei	es	ei	es	ei	es	ei
Values of deviations in microns ($1 \mu = 0.001 \text{ mm}$)	for diameter steps in millimetres																
	* ≤ 3	+0.4	-0.4	+0.6	-0.6	+1	-1	+1.5	-1.5	+2	-2	+3	-3	+5	-5	+7	-7
	>3 to 6	+0.5	-0.5	+0.75	-0.75	+1.25	-1.25	+2	-2	+2.5	-2.5	+4	-4	+6	-6	+9	-9
	>6 to 10	+0.5	-0.5	+0.75	-0.75	+1.25	-1.25	+2	-2	+3	-3	+4.5	-4.5	+7.5	-7.5	+11	-11
	>10 to 18	+0.6	-0.6	+1	-1	+1.5	-1.5	+2.5	-2.5	+4	-4	+5.5	-5.5	+9	-9	+13.5	-13.5
	>18 to 30	+0.75	-0.75	+1.25	-1.25	+2	-2	+3	-3	+4.5	-4.5	+6.5	-6.5	+10.5	-10.5	+16.5	-16.5
	>30 to 50	+0.75	-0.75	+1.25	-1.25	+2	-2	+3.5	-3.5	+5.5	-5.5	+8	-8	+12.5	-12.5	+19.5	-19.5
	>50 to 80	+1	-1	+1.5	-1.5	+2.5	-2.5	+4	-4	+6.5	-6.5	+9.5	-9.5	+15	-15	+23	-23
	>80 to 120	+1.25	-1.25	+2	-2	+3	-3	+5	-5	+7.5	-7.5	+11	-11	+17.5	-17.5	+27	-27
	>120 to 180	+1.75	-1.75	+2.5	-2.5	+4	-4	+6	-6	+9	-9	+12.5	-12.5	+20	-20	+31.5	-31.5
	>180 to 250	+2.25	-2.25	+3.5	-3.5	+5	-5	+7	-7	+10	-10	+14.5	-14.5	+23	-23	+36	-36
	>250 to 315	+3	-3	+4	-4	+6	-6	+8	-8	+11.5	-11.5	+16	-16	+26	-26	+40.5	-40.5
	>315 to 400	+3.5	-3.5	+4.5	-4.5	+6.5	-6.5	+9	-9	+12.5	-12.5	+18	-18	+28.5	-28.5	+44.5	-44.5
	>400 to 500	+4	-4	+5	-5	+7.5	-7.5	+10	-10	+13.5	-13.5	+20	-20	+31.5	-31.5	+48.5	-48.5

* Up to 1 mm, the grades 14 to 16 are not given.

2. Inch values

Symbol	Letter																
	Grade	1		2		3		4		5		6		7		8	
Deviations		es	ei	es	ei	es	ei	es	ei	es	ei	es	ei	es	ei	es	ei
Values of deviations in 0.001 in	for diameter steps in inches																
	* ≤ 0.12	+0.015	-0.015	+0.025	-0.025	+0.04	-0.04	+0.06	-0.06	+0.08	-0.08	+0.12	-0.12	+0.2	-0.2	+0.3	-0.3
	>0.12 to 0.24	+0.02	-0.02	+0.03	-0.03	+0.05	-0.05	+0.08	-0.08	+0.1	-0.1	+0.15	-0.15	+0.25	-0.25	+0.35	-0.35
	>0.24 to 0.40	+0.02	-0.02	+0.03	-0.03	+0.05	-0.05	+0.08	-0.08	+0.12	-0.12	+0.2	-0.2	+0.3	-0.3	+0.45	-0.45
	>0.40 to 0.71	+0.025	-0.025	+0.04	-0.04	+0.06	-0.06	+0.1	-0.1	+0.15	-0.15	+0.2	-0.2	+0.35	-0.35	+0.5	-0.5
	>0.71 to 1.19	+0.03	-0.03	+0.05	-0.05	+0.08	-0.08	+0.12	-0.12	+0.2	-0.2	+0.25	-0.25	+0.4	-0.4	+0.6	-0.6
	>1.19 to 1.97	+0.03	-0.03	+0.05	-0.05	+0.08	-0.08	+0.15	-0.15	+0.2	-0.2	+0.3	-0.3	+0.5	-0.5	+0.8	-0.8
	>1.97 to 3.15	+0.04	-0.04	+0.06	-0.06	+0.1	-0.1	+0.15	-0.15	+0.25	-0.25	+0.3	-0.3	+0.6	-0.6	+0.9	-0.9
	>3.15 to 4.73	+0.05	-0.05	+0.08	-0.08	+0.12	-0.12	+0.2	-0.2	+0.3	-0.3	+0.4	-0.4	+0.7	-0.7	+1	-1
	>4.73 to 7.09	+0.06	-0.06	+0.1	-0.1	+0.15	-0.15	+0.25	-0.25	+0.3	-0.3	+0.5	-0.5	+0.8	-0.8	+1.2	-1.2
	>7.09 to 9.85	+0.1	-0.1	+0.15	-0.15	+0.2	-0.2	+0.3	-0.3	+0.4	-0.4	+0.6	-0.6	+0.9	-0.9	+1.4	-1.4
	>9.85 to 12.41	+0.12	-0.12	+0.15	-0.15	+0.25	-0.25	+0.3	-0.3	+0.4	-0.4	+0.6	-0.6	+1	-1	+1.6	-1.6
	>12.41 to 15.75	+0.15	-0.15	+0.2	-0.2	+0.25	-0.25	+0.3	-0.3	+0.5	-0.5	+0.7	-0.7	+1	-1	+1.8	-1.8
	>15.75 to 19.69	+0.15	-0.15	+0.2	-0.2	+0.3	-0.3	+0.4	-0.4	+0.5	-0.5	+0.8	-0.8	+1.2	-1.2	+2	-2

* Up to 0.04 in, the grades 14 to 16 are not given.

(1) 43-44

1. Metric values

Shafts js

js																			
7		8		9		10		11		12		13		14*		15*		16*	
es	ei	es	ei	es	ei	es	ei	es	ei	es	ei	es	ei	es	ei	es	ei	es	ei
+5	-5	+7	-7	+12.5	-12.5	+20	-20	+30	-30	+50	-50	+70	-70	+125	-125	+200	-200	+300	-300
+6	-6	+9	-9	+15	-15	+24	-24	+37.5	-37.5	+60	-60	+90	-90	+150	-150	+240	-240	+375	-375
+7.5	-7.5	+11	-11	+18	-18	+29	-29	+45	-45	+75	-75	+110	-110	+180	-180	+290	-290	+450	-450
+9	-9	+13.5	-13.5	+21.5	-21.5	+35	-35	+55	-55	+90	-90	+135	-135	+215	-215	+350	-350	+550	-550
+10.5	-10.5	+16.5	-16.5	+26	-26	+42	-42	+65	-65	+105	-105	+165	-165	+260	-260	+420	-420	+650	-650
+12.5	-12.5	+19.5	-19.5	+31	-31	+50	-50	+80	-80	+125	-125	+195	-195	+310	-310	+500	-500	+800	-800
+15	-15	+23	-23	+37	-37	+60	-60	+95	-95	+150	-150	+230	-230	+370	-370	+600	-600	+950	-950
+17.5	-17.5	+27	-27	+43.5	-43.5	+70	-70	+110	-110	+175	-175	+270	-270	+435	-435	+700	-700	+1100	-1100
+20	-20	+31.5	-31.5	+50	-50	+80	-80	+125	-125	+200	-200	+315	-315	+500	-500	+800	-800	+1250	-1250
+23	-23	+36	-36	+57.5	-57.5	+92.5	-92.5	+145	-145	+230	-230	+360	-360	+575	-575	+925	-925	+1450	-1450
+26	-26	+40.5	-40.5	+65	-65	+105	-105	+160	-160	+260	-260	+405	-405	+650	-650	+1050	-1050	+1600	-1600
+28.5	-28.5	+44.5	-44.5	+70	-70	+115	-115	+180	-180	+285	-285	+445	-445	+700	-700	+1150	-1150	+1800	-1800
+31.5	-31.5	+48.5	-48.5	+77.5	-77.5	+125	-125	+200	-200	+315	-315	+485	-485	+775	-775	+1250	-1250	+2000	-2000

2. Inch values

js																			
7		8		9		10		11		12		13		14*		15*		16*	
es	ei	es	ei	es	ei	es	ei	es	ei	es	ei	es	ei	es	ei	es	ei	es	ei
-0.2	-0.2	+0.3	-0.3	+0.5	-0.5	+0.8	-0.8	+1.2	-1.2	+2	-2	+3	-3	+5	-5	+8	-8	+12	-12
-0.25	-0.25	+0.35	-0.35	+0.6	-0.6	+0.9	-0.9	+1.6	-1.6	+2.5	-2.5	+3.5	-3.5	+6	-6	+9	-9	+16	-16
-0.3	-0.3	+0.45	-0.45	+0.7	-0.7	+1.1	-1.1	+1.8	-1.8	+3	-3	+4.5	-4.5	+7	-7	+10	-10	+18	-18
-0.35	-0.35	+0.5	-0.5	+0.8	-0.8	+1.4	-1.4	+2	-2	+3.5	-3.5	+5	-5	+8	-8	+14	-14	+20	-20
-0.4	-0.4	+0.6	-0.6	+1	-1	+1.8	-1.8	+2.5	-2.5	+4	-4	+6	-6	+10	-10	+18	-18	+25	-25
-0.5	-0.5	+0.8	-0.8	+1.2	-1.2	+2	-2	+3	-3	+5	-5	+8	-8	+12	-12	+20	-20	+30	-30
-0.6	-0.6	+0.9	-0.9	+1.6	-1.6	+2.2	-2.2	+3.5	-3.5	+6	-6	+9	-9	+14	-14	+22	-22	+35	-35
-0.7	-0.7	+1	-1	+1.8	-1.8	+2.5	-2.5	+4.5	-4.5	+7	-7	+10	-10	+18	-18	+25	-25	+45	-45
-0.8	-0.8	+1.2	-1.2	+2	-2	+3	-3	+5	-5	+8	-8	+12	-12	+20	-20	+30	-30	+50	-50
-0.9	-0.9	+1.4	-1.4	+2.2	-2.2	+3.5	-3.5	+6	-6	+9	-9	+14	-14	+22	-22	+35	-35	+60	-60
-1	-1	+1.6	-1.6	+2.5	-2.5	+4	-4	+6	-6	+10	-10	+16	-16	+25	-25	+40	-40	+60	-60
-1	-1	+1.8	-1.8	+3	-3	+4.5	-4.5	+7	-7	+10	-10	+18	-18	+30	-30	+45	-45	+70	-70
-1.2	-1.2	+2	-2	+3	-3	+5	-5	+8	-8	+12	-12	+20	-20	+30	-30	+50	-50	+80	-80

es = upper deviation
ei = lower deviation

1. Metric values

Symbol	Letter	k					m *					n					p		
	Grade	4	5	6	7	4 to 7	4	5	6	7	4 to 7	4	5	6	7	4 to 7	4	5	6
Deviations		es					ei					es					es		
Values of deviations in microns ($1 \mu = 0.001 \text{ mm}$)	for diameter steps in millimetres																		
	≤ 3	+3	+4	+6	+10	0	+5	+6	+8	—	+2	+7	+8	+10	+14	+4	+9	+10	+12
	>3 to 6	+5	+6	+9	+13	+1	+8	+9	+12	+16	+4	+12	+13	+16	+20	+8	+16	+17	+20
	>6 to 10	+5	+7	+10	+16	+1	+10	+12	+15	+21	+6	+14	+16	+19	+25	+10	+19	+21	+25
	>10 to 14	+6	+9	+12	+19	+1	+12	+15	+18	+25	+7	+17	+20	+23	+30	+12	+23	+26	+30
	>14 to 18	+8	+11	+15	+23	+2	+14	+17	+21	+29	+8	+21	+24	+28	+36	+15	+28	+31	+36
	>18 to 24	+9	+13	+18	+27	+2	+16	+20	+25	+34	+9	+24	+28	+33	+42	+17	+33	+37	+42
	>24 to 30	+10	+15	+21	+32	+2	+19	+24	+30	+41	+11	+28	+33	+39	+50	+20	+40	+45	+50
	>30 to 40	+13	+18	+25	+38	+3	+23	+28	+35	+48	+13	+33	+38	+45	+58	+23	+47	+52	+58
	>40 to 50	+15	+21	+28	+43	+3	+27	+33	+40	+55	+15	+39	+45	+52	+67	+27	+55	+61	+67
	>50 to 65	+18	+24	+33	+50	+4	+31	+37	+46	+63	+17	+45	+51	+60	+77	+31	+64	+70	+77
	>65 to 80	+20	+27	+36	+56	+4	+36	+43	+52	+72	+20	+50	+57	+66	+86	+34	+72	+79	+86
	>80 to 100	+22	+29	+40	+61	+4	+39	+46	+57	+78	+21	+55	+62	+73	+94	+37	+80	+87	+94
	>100 to 120	+25	+32	+45	+68	+5	+43	+50	+63	+86	+23	+60	+67	+80	+103	+40	+88	+95	+103
	>120 to 140																		
	>140 to 160																		
	>160 to 180																		
	>180 to 200																		
	>200 to 225																		
	>225 to 250																		
	>250 to 280																		
	>280 to 315																		
	>315 to 355																		
	>355 to 400																		
	>400 to 450																		
	>450 to 500																		

Numerical values amended from the former ISA System are framed in a bold line.

2. Inch values

Symbol	Letter	k					m *					n					p		
	Grade	4	5	6	7	4 to 7	4	5	6	7	4 to 7	4	5	6	7	4 to 7	4	5	6
Deviations		es					ei					es					es		
Values of deviations in 0.001 in	for diameter steps in inches																		
	≤ 0.12	+0.12	+0.15	+0.25	+0.4	+0	+0.22	+0.25	+0.35	—	+0.1	+0.27	+0.3	+0.4	+0.55	+0.15	+0.37	+0.4	+0.5
	>0.12 to 0.24	+0.25	+0.3	+0.4	+0.6	+0.1	+0.3	+0.35	+0.45	+0.65	+0.15	+0.45	+0.5	+0.6	+0.8	+0.3	+0.65	+0.7	+0.8
	>0.24 to 0.40	+0.25	+0.35	+0.5	+0.7	+0.1	+0.4	+0.5	+0.65	+0.85	+0.25	+0.55	+0.65	+0.8	+1	+0.4	+0.75	+0.85	+1
	>0.40 to 0.56	+0.3	+0.4	+0.5	+0.8	+0.1	+0.5	+0.6	+0.7	+1	+0.3	+0.7	+0.8	+0.9	+1.2	+0.5	+0.9	+1	+1.2
	>0.56 to 0.71	+0.35	+0.5	+0.6	+0.9	+0.1	+0.55	+0.7	+0.8	+1.1	+0.3	+0.85	+1	+1.1	+1.4	+0.6	+1.05	+1.2	+1.5
	>0.71 to 0.95	+0.4	+0.5	+0.7	+1.1	+0.1	+0.7	+0.8	+1	+1.4	+0.4	+1	+1.1	+1.3	+1.7	+0.7	+1.3	+1.4	+1.7
	>0.95 to 1.19	+0.4	+0.6	+0.8	+1.3	+0.1	+0.8	+1	+1.2	+1.7	+0.5	+1.1	+1.3	+1.5	+2	+0.8	+1.7	+1.9	+2.2
	>1.19 to 1.58	+0.5	+0.7	+1	+1.5	+0.1	+0.9	+1.1	+1.4	+1.9	+0.5	+1.4	+1.6	+1.9	+2.4	+1	+2	+2.2	+2.5
	>1.58 to 1.97	+0.6	+0.8	+1.1	+1.7	+0.1	+1.1	+1.3	+1.6	+2.2	+0.6	+1.7	+1.9	+2.2	+2.8	+1.2	+2.3	+2.5	+2.8
	>1.97 to 2.56	+0.8	+1	+1.4	+2	+0.2	+1.2	+1.4	+1.8	+2.4	+0.6	+2	+2.2	+2.6	+3.2	+1.4	+2.6	+2.8	+3
	>2.56 to 3.15	+0.8	+1.1	+1.4	+2.2	+0.2	+1.4	+1.7	+2	+2.8	+0.8	+2	+2.3	+2.6	+3.4	+1.4	+2.8	+3.1	+3
	>3.15 to 3.94	+0.9	+1.2	+1.6	+2.4	+0.2	+1.5	+1.8	+2.2	+3	+0.8	+2.3	+2.6	+3	+3.8	+1.6	+3.2	+3.5	+3
	>3.94 to 4.73	+1	+1.2	+1.8	+2.7	+0.2	+1.7	+1.9	+2.5	+3.4	+0.9	+2.6	+2.8	+3.4	+4.3	+1.8	+3.6	+3.8	+4
	>4.73 to 5.52																		
	>5.52 to 6.30																		
	>6.30 to 7.09																		
	>7.09 to 7.88																		
	>7.88 to 8.86																		
	>8.86 to 9.85																		
	>9.85 to 11.03																		
	>11.03 to 12.41																		
	>12.41 to 13.98																		
	>13.98 to 15.75																		
	>15.75 to 17.72																		
	>17.72 to 19.69																		

* For the missing m7 deviation, the n7 deviation should be substituted.

** When t5 to t7 deviations are missing, u5 to u7 deviations should be substituted for them.

(1) 45-46

1. Metric values

Shafts k to t

		p					r					s					t **			
7	4 to 7	4	5	6	7	4 to 7	4	5	6	7	4 to 7	4	5	6	7	4 to 7	5	6	7	5 to 7
	ei	es				ei	es				ei	es				ei	es			ei
+14	+4	+9	+10	+12	+16	+6	+13	+14	+16	+20	+10	+17	+18	+20	+24	+14	—	—	—	—
+20	+8	+16	+17	+20	+24	+12	+19	+20	+23	+27	+15	+23	+24	+27	+31	+19	—	—	—	—
+25	+10	+19	+21	+24	+30	+15	+23	+25	+28	+34	+19	+27	+29	+32	+38	+23	—	—	—	—
+30	+12	+23	+26	+29	+36	+18	+28	+31	+34	+41	+23	+33	+36	+39	+46	+28	—	—	—	—
+36	+15	+28	+31	+35	+43	+22	+34	+37	+41	+49	+28	+41	+44	+48	+56	+35	—	—	—	—
																	+50	+54	+62	+41
+42	+17	+33	+37	+42	+51	+26	+41	+45	+50	+59	+34	+50	+54	+59	+68	+43	+59	+64	+73	+48
																	+65	+70	+79	+54
+50	+20	+40	+45	+51	+62	+32	+49	+54	+60	+71	+41	+61	+66	+72	+83	+53	+79	+85	+96	+66
							+51	+56	+62	+73	+43	+67	+72	+78	+89	+59	+88	+94	+105	+75
+58	+23	+47	+52	+59	+72	+37	+61	+66	+73	+86	+51	+81	+86	+93	+106	+71	+106	+113	+126	+91
							+64	+69	+76	+89	+54	+89	+94	+101	+114	+79	+119	+126	+139	+104
							+75	+81	+88	+103	+63	+104	+110	+117	+132	+92	+140	+147	+162	+122
+67	+27	+55	+61	+68	+83	+43	+77	+83	+90	+105	+65	+112	+118	+125	+140	+100	+152	+159	+174	+134
							+80	+86	+93	+108	+68	+120	+126	+133	+148	+108	+164	+171	+186	+146
							+91	+97	+106	+123	+77	+136	+142	+151	+168	+122	+186	+195	+212	+166
+77	+31	+64	+70	+79	+96	+50	+94	+100	+109	+126	+80	+144	+150	+159	+176	+130	+200	+209	+226	+180
							+98	+104	+113	+130	+84	+154	+160	+169	+186	+140	+216	+225	+242	+196
+86	+34	+72	+79	+88	+108	+56	+110	+117	+126	+146	+94	+174	+181	+190	+210	+158	+241	+250	+270	+218
							+114	+121	+130	+150	+98	+186	+193	+202	+222	+170	+263	+272	+292	+240
							+126	+133	+144	+165	+108	+208	+215	+226	+247	+190	+293	+304	+325	+268
+94	+37	+80	+87	+98	+119	+62	+132	+139	+150	+171	+114	+226	+233	+244	+265	+208	+319	+330	+351	+294
							+146	+153	+166	+189	+126	+252	+259	+272	+295	+232	+357	+370	+393	+330
+103	+40	+88	+95	+108	+131	+68	+152	+159	+172	+195	+132	+272	+279	+292	+315	+252	+387	+400	+423	+360

2. Inch values

		p					r					s					t **			
7	4 to 7	4	5	6	7	4 to 7	4	5	6	7	4 to 7	4	5	6	7	4 to 7	5	6	7	5 to 7
	ei	es				ei	es				ei	es				ei	es			ei
+0.55	+0.15	+0.37	+0.4	+0.5	+0.65	+0.25	+0.52	+0.55	+0.65	+0.8	+0.4	+0.72	+0.75	+0.85	+1	+0.6	—	—	—	—
+0.8	+0.3	+0.65	+0.7	+0.8	+1	+0.5	+0.75	+0.8	+0.9	+1.1	+0.6	+0.85	+0.9	+1	+1.2	+0.7	—	—	—	—
+1	+0.4	+0.75	+0.85	+1	+1.2	+0.6	+0.95	+1.05	+1.2	+1.4	+0.8	+1.15	+1.25	+1.4	+1.6	+1	—	—	—	—
+1.2	+0.5	+0.9	+1	+1.1	+1.4	+0.7	+1.2	+1.3	+1.4	+1.7	+1	+1.4	+1.5	+1.7	+1.9	+1.2	—	—	—	—
																	—	—	—	—
+1.4	+0.6	+1.05	+1.2	+1.3	+1.6	+0.8	+1.45	+1.6	+1.7	+2	+1.2	+1.65	+1.8	+1.9	+2.2	+1.4	+2	+2.1	+2.4	+1.6
																	+2.4	+2.6	+3	+2
+1.7	+0.7	+1.3	+1.4	+1.6	+2	+1	+1.7	+1.8	+2	+2.4	+1.4	+2.1	+2.2	+2.4	+2.8	+1.8	+2.6	+2.8	+3.2	+2.2
+2	+0.8	+1.7	+1.9	+2.1	+2.6	+1.4	+1.9	+2.1	+2.3	+2.8	+1.6	+2.3	+2.5	+2.7	+3.2	+2	+3	+3.2	+3.7	+2.5
												+2.5	+2.7	+2.9	+3.4	+2.2	+3.5	+3.7	+4.2	+3
+2.4	+1	+2	+2.2	+2.5	+3	+1.6	+2.4	+2.6	+2.9	+3.4	+2	+3.1	+3.4	+3.7	+4.2	+2.8	+4.1	+4.4	+4.9	+3.5
												+3.3	+3.6	+3.9	+4.4	+3	+4.6	+4.9	+5.4	+4
												+3.9	+4.2	+4.5	+5.1	+3.5	+5.7	+6	+6.6	+5
+2.8	+1.2	+2.3	+2.5	+2.8	+3.4	+1.8	+3	+3.2	+3.5	+4.1	+2.5	+4.4	+4.7	+5	+5.6	+4	+5.7	+6	+6.6	+5
												+5	+5.2	+5.5	+6.1	+4.5	+6.7	+7	+7.6	+6
												+5.5	+5.8	+6.2	+6.8	+5	+7.8	+8.2	+8.8	+7
+3.2	+1.4	+2.6	+2.8	+3.2	+3.8	+2	+3.6	+3.8	+4.2	+4.8	+3	+5.6	+5.8	+6.2	+6.8	+5	+7.8	+8.2	+8.8	+7
												+6.6	+6.8	+7.2	+7.8	+6	+8.8	+9.2	+9.8	+8
												+6.6	+6.9	+7.2	+8	+6	+9.9	+10.2	+11	+9
+3.4	+1.4	+2.8	+3.1	+3.4	+4.2	+2.2	+4.1	+4.4	+4.7	+5.5	+3.5	+7.6	+7.9	+8.2	+9	+7	+9.9	+10.2	+11	+9
+3.8	+1.6	+3.2	+3.5	+3.9	+4.7	+2.5	+5.2	+5.5	+5.9	+6.7	+4.5	+7.7	+8	+8.4	+9.2	+7	+11	+11.4	+12.2	+10
												+8.7	+9	+9.4	+10.2	+8	+13	+13.4	+14.2	+12
												+9.8	+10	+10.6	+11.5	+9	+13	+13.6	+14.5	+12
+4.3	+1.8	+3.6	+3.8	+4.4	+5.3	+2.8	+5.8	+6	+6.6	+7.5	+5	+10.8	+11	+11.6	+12.5	+10	+15	+15.6	+16.5	+14

es = upper deviation
ei = lower deviation

1. Metric values

Symbol	Letter	u					v *				X				
	Grade	5	6	7	8	5 to 8	5	6	7	5 to 7	5	6	7	8	5 to 8
Deviations		es				ei	es			ei	es				ei
Values of deviations in microns (1 μ = 0.001 mm)	<3	+22	+24	+28	+32	+18	—	—	—	—	+24	+26	+30	+34	+20
	>3 to 6	+28	+31	+35	+41	+23	—	—	—	—	+33	+36	+40	+46	+28
	>6 to 10	+34	+37	+43	+50	+28	—	—	—	—	+40	+43	+49	+56	+34
	>10 to 14						—	—	—	—	+48	+51	+58	+67	+40
	>14 to 18	+41	+44	+51	+60	+33	+47	+50	+57	+39	+53	+56	+63	+72	+45
	>18 to 24	+50	+54	+62	+74	+41	+56	+60	+68	+47	+63	+67	+75	+87	+54
	>24 to 30	+57	+61	+69	+81	+48	+64	+68	+76	+55	+73	+77	+85	+97	+64
	>30 to 40	+71	+76	+85	+99	+60	+79	+84	+93	+68	+91	+96	+105	+119	+80
	>40 to 50	+81	+86	+95	+109	+70	+92	+97	+106	+81	+108	+113	+122	+136	+97
	>50 to 65	+100	+106	+117	+133	+87	+115	+121	+132	+102	+135	+141	+152	+168	+122
	>65 to 80	+115	+121	+132	+148	+102	+133	+139	+150	+120	+159	+165	+176	+192	+146
	>80 to 100	+139	+146	+159	+178	+124	+161	+168	+181	+146	+193	+200	+213	+232	+178
	>100 to 120	+159	+166	+179	+198	+144	+187	+194	+207	+172	+225	+232	+245	+264	+210
	>120 to 140	+188	+195	+210	+233	+170	+220	+227	+242	+202	+266	+273	+288	+311	+248
	>140 to 160	+208	+215	+230	+253	+190	+246	+253	+268	+228	+298	+305	+320	+343	+280
	>160 to 180	+228	+235	+250	+273	+210	+270	+277	+292	+252	+328	+335	+350	+373	+310
	>180 to 200	+256	+265	+282	+308	+236	+304	+313	+330	+284	+370	+379	+396	+422	+350
	>200 to 225	+278	+287	+304	+330	+258	+330	+339	+356	+310	+405	+414	+431	+457	+385
	>225 to 250	+304	+313	+330	+356	+284	+360	+369	+386	+340	+445	+454	+471	+497	+425
	>250 to 280	+338	+347	+367	+396	+315	+408	+417	+437	+385	+498	+507	+527	+556	+475
	>280 to 315	+373	+382	+402	+431	+350	+448	+457	+477	+425	+548	+557	+577	+606	+525
	>315 to 355	+415	+426	+447	+479	+390	+500	+511	+532	+475	+615	+626	+647	+679	+590
	>355 to 400	+460	+471	+492	+524	+435	+555	+566	+587	+530	+685	+696	+717	+749	+660
	>400 to 450	+517	+530	+553	+587	+490	+622	+635	+658	+595	+767	+780	+803	+837	+740
	>450 to 500	+567	+580	+603	+637	+540	+687	+700	+723	+660	+847	+860	+883	+917	+820

Numerical values amended from the former ISA System are framed in a bold line.

2. Inch values

Symbol	Letter	u					v *				X				
	Grade	5	6	7	8	5 to 8	5	6	7	5 to 7	5	6	7	8	5 to 8
Deviations		es				ei	es			ei	es				ei
Values of deviations in 0.001 in	<0.12	+0.9	+0.95	+1.1	+1.3	+0.7	—	—	—	—	+1.1	+1.15	+1.3	+1.5	+0.9
	>0.12 to 0.24	+1.1	+1.2	+1.4	+1.6	+0.9	—	—	—	—	+1.4	+1.5	+1.7	+1.9	+1.2
	>0.24 to 0.40	+1.45	+1.6	+1.8	+2.1	+1.2	—	—	—	—	+1.65	+1.8	+2	+2.3	+1.4
	>0.40 to 0.56						—	—	—	—	+1.9	+2	+2.3	+2.6	+1.6
	>0.56 to 0.71	+1.7	+1.8	+2.1	+2.4	+1.4	+1.9	+2	+2.3	+1.6	+2.1	+2.2	+2.5	+2.8	+1.8
	>0.71 to 0.95	+2	+2.1	+2.4	+2.8	+1.6	+2.2	+2.3	+2.6	+1.8	+2.6	+2.7	+3	+3.4	+2.2
	>0.95 to 1.19	+2.2	+2.3	+2.6	+3	+1.8	+2.6	+2.7	+3	+2.2	+2.9	+3	+3.3	+3.7	+2.5
	>1.19 to 1.58	+2.9	+3.1	+3.5	+4.1	+2.5	+3.2	+3.4	+3.8	+2.8	+3.4	+3.6	+4	+4.6	+3
	>1.58 to 1.97	+3.2	+3.4	+3.8	+4.4	+2.8	+3.4	+3.6	+4	+3	+4.4	+4.6	+5	+5.6	+4
	>1.97 to 2.56	+4	+4.2	+4.7	+5.3	+3.5	+4.5	+4.7	+5.2	+4	+5.5	+5.7	+6.2	+6.8	+5
	>2.56 to 3.15	+4.5	+4.7	+5.2	+5.8	+4	+5.5	+5.7	+6.2	+5	+6.5	+6.7	+7.2	+7.8	+6
	>3.15 to 3.94	+5.6	+5.9	+6.4	+7.2	+5	+6.6	+6.9	+7.4	+6	+7.6	+7.9	+8.4	+9.2	+7
	>3.94 to 4.73	+6.6	+6.9	+7.4	+8.2	+6	+7.6	+7.9	+8.4	+7	+8.6	+8.9	+9.4	+10.2	+8
	>4.73 to 5.52	+7.7	+8	+8.6	+9.5	+7	+8.7	+9	+9.6	+8	+10.7	+11	+11.6	+12.5	+10
	>5.52 to 6.30	+7.7	+8	+8.6	+9.5	+7	+9.7	+10	+10.6	+9	+12.7	+13	+13.6	+14.5	+12
	>6.30 to 7.09	+8.7	+9	+9.6	+10.5	+8	+10.7	+11	+11.6	+10					
	>7.09 to 7.88	+9.8	+10.2	+10.8	+11.8	+9	+12.8	+13.2	+13.8	+12	+14.8	+15.2	+15.8	+16.8	+14
	>7.88 to 8.86	+10.8	+11.2	+11.8	+12.8	+10					+16.8	+17.2	+17.8	+18.8	+16
	>8.86 to 9.85	+12.8	+13.2	+13.8	+14.8	+12	+14.8	+15.2	+15.8	+14					
	>9.85 to 11.03	+12.9	+13.2	+14	+15	+12	+16.9	+17.2	+18	+16	+18.9	+19.2	+20	+21	+18
	>11.03 to 12.41	+14.9	+15.2	+16	+17	+14					+20.9	+21.2	+22	+23	+20
	>12.41 to 13.98	+17	+17.4	+18.2	+19.5	+16	+19	+19.4	+20.2	+18	+23	+23.4	+24.2	+25.5	+22
	>13.98 to 15.75	+19	+19.4	+20.2	+21.5	+18	+21	+21.4	+22.2	+20	+26	+26.4	+27.2	+28.5	+25
	>15.75 to 17.72	+21	+21.6	+22.5	+24	+20	+23	+23.6	+24.5	+22	+29	+29.6	+30.5	+32	+28
	>17.72 to 19.69	+23	+23.6	+24.5	+26	+22	+26	+26.6	+27.5	+25	+31	+31.6	+32.5	+34	+30

* When v5 to v7 deviations are missing, x5 to x7 deviations should be substituted for them.

** When y6 and y7 deviations are missing, z6 and z7 deviations should be substituted for them.

1. Metric values

Shafts U to ZC

X				y **			Z			za			zb			zc		
6	7	8	5 to 8	6	7	6 and 7	6	7	6 and 7	6	7	6 and 7	7	8	7 and 8	7	8	7 and 8
es			ei	es		ei	es		ei	es		ei	es		ei	es		ei
+26	+30	+34	+20	—	—	—	+32	+36	+26	+38	+42	+32	+50	+54	+40	+70	+74	+60
+36	+40	+46	+28	—	—	—	+43	+47	+35	+50	+54	+42	+62	+68	+50	+92	+98	+80
+43	+49	+56	+34	—	—	—	+51	+57	+42	+61	+67	+52	+82	+89	+67	+112	+119	+97
+51	+58	+67	+40	—	—	—	+61	+68	+50									
+56	+63	+72	+45	—	—	—	+71	+78	+60									
+67	+75	+87	+54	+76	+84	+63	+86	+94	+73									
+77	+85	+97	+64	+88	+96	+75	+101	+109	+88									
+96	+105	+119	+80	+110	+119	+94	+128	+137	+112									
+113	+122	+136	+97	+130	+139	+114	+152	+161	+136									
+141	+152	+168	+122	+163	+174	+144	+191	+202	+172									
+165	+176	+192	+146	+193	+204	+174	+229	+240	+210									
+200	+213	+232	+178	+236	+249	+214	+280	+293	+258									
+232	+245	+264	+210	+276	+289	+254	+332	+345	+310									
+273	+288	+311	+248	+325	+340	+300	+390	+405	+365									
+305	+320	+343	+280	+365	+380	+340	+440	+455	+415									
+335	+350	+373	+310	+405	+420	+380	+490	+505	+465									
+379	+396	+422	+350	+454	+471	+425	+549	+566	+520									
+414	+431	+457	+385	+499	+516	+470	+604	+621	+575									
+454	+471	+497	+425	+549	+566	+520	+669	+686	+640									
+507	+527	+556	+475	+612	+632	+580	+742	+762	+710									
+557	+577	+606	+525	+682	+702	+650	+822	+842	+790									
+626	+647	+679	+590	+766	+787	+730	+936	+957	+900									
+696	+717	+749	+660	+856	+877	+820	+1036	+1057	+1000									
+780	+803	+837	+740	+960	+983	+920	+1140	+1163	+1100									
+860	+883	+917	+820	+1040	+1063	+1000	+1290	+1313	+1250									

2. Inch values

X				y **			Z			za			zb			zc		
6	7	8	5 to 8	6	7	6 and 7	6	7	6 and 7	6	7	6 and 7	7	8	7 and 8	7	8	7 and 8
es			ei	es		ei	es		ei	es		ei	es		ei	es		ei
+1.15	+1.3	+1.5	+0.9	—	—	—	+1.45	+1.6	+1.2	+1.65	+1.8	+1.4	+2	+2.2	+1.6	+2.9	+3.1	+2.5
+1.5	+1.7	+1.9	+1.2	—	—	—	+1.7	+1.9	+1.4	+1.9	+2.1	+1.6	+2.5	+2.7	+2	+3.5	+3.7	+3
+1.8	+2	+2.3	+1.4	—	—	—	+2	+2.2	+1.6	+2.4	+2.6	+2	+3.1	+3.4	+2.5	+4.6	+4.9	+4
+2	+2.3	+2.6	+1.6	—	—	—	+2.4	+2.7	+2									
+2.2	+2.5	+2.8	+1.8	—	—	—	+2.9	+3.2	+2.5									
+2.7	+3	+3.4	+2.2	+3	+3.3	+2.5	+3.3	+3.6	+2.8									
+3	+3.3	+3.7	+2.5	+3.5	+3.8	+3	+4	+4.3	+3.5									
+3.6	+4	+4.6	+3	+4.1	+4.5	+3.5	+5.1	+5.5	+4.5									
+4.6	+5	+5.6	+4	+5.1	+5.5	+4.5	+5.6	+6	+5									
+5.7	+6.2	+6.8	+5	+6.7	+7.2	+6	+7.7	+8.2	+7									
+6.7	+7.2	+7.8	+6	+7.7	+8.2	+7	+8.7	+9.2	+8									
+7.9	+8.4	+9.2	+7	+8.9	+9.4	+8	+10.9	+11.4	+10									
+8.9	+9.4	+10.2	+8	+10.9	+11.4	+10	+12.9	+13.4	+12									
+1	+11.6	+12.5	+10	+13	+13.6	+12	+15	+15.6	+14									
+3	+13.6	+14.5	+12	+15	+15.6	+14	+17	+17.6	+16									
							+19	+19.6	+18									
+5.2	+15.8	+16.8	+14	+17.2	+17.8	+16	+21.2	+21.8	+20									
+7.2	+17.8	+18.8	+16	+19.2	+19.8	+18	+23.2	+23.8	+22									
				+21.2	+21.8	+20	+26.2	+26.8	+25									
+9.2	+20	+21	+18	+23.2	+24	+22	+29.2	+30	+28									
+1.2	+22	+23	+20	+26.2	+27	+25	+31.2	+32	+30									
+3.4	+24.2	+25.5	+22	+29.4	+30.2	+28	+36.4	+37.2	+35									
+6.4	+27.2	+28.5	+25	+31.4	+32.2	+30	+41.4	+42.2	+40									
+9.6	+30.5	+32	+28	+36.6	+37.5	+35	+46.6	+47.5	+45									
+1.6	+32.5	+34	+30	+41.6	+42.5	+40	+51.6	+52.5	+50									

GENERAL PURPOSE COMMONLY USED HOLES

ES = upper deviation
EI = lower deviation

1. Metric values

Symbol	Letter	A			B				C				6
	Grade	9	11	9 and 11	8	9	11	8-9 and 11	8	9	11	8-9 and 11	
Deviations		ES		EI	ES		EI	ES		EI	ES		EI
Values of deviations in microns ($1 \mu = 0.001 \text{ mm}$)	≤ 3	+295	+330	+270	+154	+165	+200	+140	+74	+85	+120	+60	+26
	>3 to 6	+300	+345	+270	+158	+170	+215	+140	+88	+100	+145	+70	+38
	>6 to 10	+316	+370	+280	+172	+186	+240	+150	+102	+116	+170	+80	+49
	>10 to 18	+333	+400	+290	+177	+193	+260	+150	+122	+138	+205	+95	+61
	>18 to 30	+352	+430	+300	+193	+212	+290	+160	+143	+162	+240	+110	+78
	>30 to 40	+372	+470	+310	+209	+232	+330	+170	+159	+182	+280	+120	+96
	>40 to 50	+382	+480	+320	+219	+242	+340	+180	+169	+192	+290	+130	+119
	>50 to 65	+414	+530	+340	+236	+264	+380	+190	+186	+214	+330	+140	+142
	>65 to 80	+434	+550	+360	+246	+274	+390	+200	+196	+224	+340	+150	+170
	>80 to 100	+467	+600	+380	+274	+307	+440	+220	+224	+257	+390	+170	+199
	>100 to 120	+497	+630	+410	+294	+327	+460	+240	+234	+267	+400	+180	+222
	>120 to 140	+560	+710	+460	+323	+360	+510	+260	+263	+300	+450	+200	+246
	>140 to 160	+620	+770	+520	+343	+380	+530	+280	+273	+310	+460	+210	+270
	>160 to 180	+680	+830	+580	+373	+410	+560	+310	+293	+330	+480	+230	+299
	>180 to 200	+775	+950	+660	+412	+455	+630	+340	+312	+355	+530	+240	+330
	>200 to 225	+855	+1030	+740	+452	+495	+670	+380	+332	+375	+550	+260	+360
	>225 to 250	+935	+1110	+820	+492	+535	+710	+420	+352	+395	+570	+280	+400
	>250 to 280	+1050	+1240	+920	+561	+610	+800	+480	+381	+430	+620	+300	+440
	>280 to 315	+1180	+1370	+1050	+621	+670	+860	+540	+411	+460	+650	+330	+480
	>315 to 355	+1340	+1560	+1200	+689	+740	+960	+600	+449	+500	+720	+360	+510
	>355 to 400	+1490	+1710	+1350	+769	+820	+1040	+680	+489	+540	+760	+400	+560
	>400 to 450	+1655	+1900	+1500	+857	+915	+1160	+760	+537	+595	+840	+440	+610
	>450 to 500	+1805	+2050	+1650	+937	+995	+1240	+840	+577	+635	+880	+480	+660

Numerical values amended from the former ISA System are framed in a bold line.

2. Inch values

Symbol	Letter	A			B				C				6
	Grade	9	11	9 and 11	8	9	11	8-9 and 11	8	9	11	8-9 and 11	
Deviations		ES		EI	ES		EI	ES		EI	ES		EI
Values of deviations in 0.001 in	≤ 0.12	+11	+12.5	+10	+5.6	+6	+7.5	+5	+3.1	+3.5	+5	+2.5	+1.25
	>0.12 to 0.24	+11.2	+13	+10	+5.7	+6.2	+8	+5	+3.5	+4	+5.8	+2.8	+1.5
	>0.24 to 0.40	+11.4	+13.5	+10	+6.9	+7.4	+9.5	+6	+3.9	+4.4	+6.5	+3	+2
	>0.40 to 0.71	+13.6	+16	+12	+7	+7.6	+10	+6	+4.5	+5.1	+7.5	+3.5	+2.4
	>0.71 to 1.19	+14	+17	+12	+7.2	+8	+11	+6	+5.7	+6.5	+9.5	+4.5	+3
	>1.19 to 1.58	+14.5	+18	+12	+8.6	+9.5	+13	+7	+6.6	+7.5	+11	+5	+3.6
	>1.58 to 1.97	+17	+21	+14	+9.8	+11	+15	+8	+7.8	+9	+13	+6	+4.7
	>1.97 to 2.56	+17	+21	+14	+9.8	+11	+15	+8	+7.8	+9	+13	+6	+4.7
	>2.56 to 3.15	+19.5	+25	+16	+11.2	+12.5	+18	+9	+9.2	+10.5	+16	+7	+5.9
	>3.15 to 3.94	+19.5	+25	+16	+11.2	+12.5	+18	+9	+9.2	+10.5	+16	+7	+5.9
	>3.94 to 4.73	+24	+30	+20	+14.5	+16	+22	+12	+10.5	+12	+18	+8	+7
	>4.73 to 5.52	+24	+30	+20	+14.5	+16	+22	+12	+10.5	+12	+18	+8	+7
	>5.52 to 6.30	+24	+30	+20	+14.5	+16	+22	+12	+10.5	+12	+18	+8	+7
	>6.30 to 7.09	+24	+30	+20	+14.5	+16	+22	+12	+10.5	+12	+18	+8	+7
	>7.09 to 7.88	+34.5	+42	+30	+18.8	+20.5	+28	+16	+12.8	+14.5	+22	+10	+8.2
	>7.88 to 8.86	+34.5	+42	+30	+18.8	+20.5	+28	+16	+12.8	+14.5	+22	+10	+8.2
	>8.86 to 9.85	+45	+52	+40	+23	+25	+32	+20	+15	+17	+24	+12	+8.2
	>9.85 to 11.03	+45	+52	+40	+23	+25	+32	+20	+15	+17	+24	+12	+8.2
	>11.03 to 12.41	+56	+64	+50	+28.5	+31	+39	+25	+17.5	+20	+28	+14	+9.4
	>12.41 to 13.98	+56	+64	+50	+28.5	+31	+39	+25	+17.5	+20	+28	+14	+9.4
	>13.98 to 15.75	+56	+64	+50	+28.5	+31	+39	+25	+17.5	+20	+28	+14	+9.4
	>15.75 to 17.72	+66	+76	+60	+34	+36	+46	+30	+20	+22	+32	+16	+10.6
	>17.72 to 19.69	+66	+76	+60	+34	+36	+46	+30	+20	+22	+32	+16	+10.6

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GENERAL PURPOSES COMMONLY USED HOLES

GENERAL PURPOSES

1. Metric values

Holes A to E

C		D							E								
11	8-9 and 11	6	7	8	9	10	11	6 to 11	5	6	7	8	9	10	5 to 10		
	EI	ES							EI	ES							EI
+120	+60	+26	+30	+34	+45	+60	+80	+20	+18	+20	+24	+28	+39	+54	+14		
+145	+70	+38	+42	+48	+60	+78	+105	+30	+25	+28	+32	+38	+50	+68	+20		
+170	+80	+49	+55	+62	+76	+98	+130	+40	+31	+34	+40	+47	+61	+83	+25		
+205	+95	+61	+68	+77	+93	+120	+160	+50	+40	+43	+50	+59	+75	+102	+32		
+240	+110	+78	+86	+98	+117	+149	+195	+65	+49	+53	+61	+73	+92	+124	+40		
+280	+120	+96	+105	+119	+142	+180	+240	+80	+61	+66	+75	+89	+112	+150	+50		
+290	+130																
+330	+140	+119	+130	+146	+174	+220	+290	+100	+73	+79	+90	+106	+134	+180	+60		
+340	+150																
+390	+170	+142	+155	+174	+207	+260	+340	+120	+87	+94	+107	+126	+159	+212	+72		
+400	+180																
+450	+200	+170	+185	+208	+245	+305	+395	+145	+103	+110	+125	+148	+185	+245	+85		
+460	+210																
+480	+230	+199	+216	+242	+285	+355	+460	+170	+120	+129	+146	+172	+215	+285	+100		
+530	+240																
+550	+260	+222	+242	+271	+320	+400	+510	+190	+133	+142	+162	+191	+240	+320	+110		
+570	+280																
+620	+300	+246	+267	+299	+350	+440	+570	+210	+150	+161	+182	+214	+265	+355	+125		
+650	+330																
+720	+360	+270	+293	+327	+385	+480	+630	+230	+162	+175	+198	+232	+290	+385	+135		
+760	+400																
+840	+440																
+880	+480																

2. Inch values

C		D							E						
11	8-9 and 11	6	7	8	9	10	11	6 to 11	5	6	7	8	9	10	5 to 10
EI		ES							EI						
+5	+2.5	+1.25	+1.4	+1.6	+2	+2.6	+3.5	+1	+0.75	+0.85	+1	+1.2	+1.6	+2.2	+0.6
+5.8	+2.8	+1.5	+1.7	+1.9	+2.4	+3	+4.2	+1.2	+1	+1.1	+1.3	+1.5	+2	+2.6	+0.8
+6.5	+3	+2	+2.2	+2.5	+3	+3.8	+5.1	+1.6	+1.25	+1.4	+1.6	+1.9	+2.4	+3.2	+1
+7.5	+3.5	+2.4	+2.7	+3	+3.6	+4.8	+6	+2	+1.5	+1.6	+1.9	+2.2	+2.8	+4	+1.2
+9.5	+4.5	+3	+3.3	+3.7	+4.5	+6	+7.5	+2.5	+2	+2.1	+2.4	+2.8	+3.6	+5.1	+1.6
+11	+5	+3.6	+4	+4.6	+5.5	+7	+9	+3	+2.4	+2.6	+3	+3.6	+4.5	+6	+2
+13	+6	+4.7	+5.2	+5.8	+7	+8.5	+11	+4	+3	+3.2	+3.7	+4.3	+5.5	+7	+2.5
+16	+7	+5.9	+6.4	+7.2	+8.5	+10	+14	+5	+3.6	+3.9	+4.4	+5.2	+6.5	+8	+3
+18	+8	+7	+7.6	+8.5	+10	+12	+16	+6	+4.2	+4.5	+5.1	+6	+7.5	+9.5	+3.5
+22	+10	+8.2	+8.8	+9.8	+11.5	+14	+19	+7	+4.8	+5.2	+5.8	+6.8	+8.5	+11	+4
+24	+12	+8.2	+9	+10	+12	+15	+19	+7	+5.4	+5.7	+6.5	+7.5	+9.5	+12.5	+4.5
+28	+14	+9.4	+10.2	+11.5	+14	+17	+22	+8	+6	+6.4	+7.2	+8.5	+11	+14	+5
+32	+16	+10.6	+11.5	+13	+15	+19	+25	+9	+6	+6.6	+7.5	+9	+11	+15	+5

ES = upper deviation
EI = lower deviation

1. Metric values

Symbol	Letter	F						G											
	Grade	5	6	7	8	9	5 to 9	5	6	7	5 to 7	1	2	3	4	5	6	7	
Deviations		ES					EI	ES			EI								
Values of deviations in microns ($1 \mu = 0.001 \text{ mm}$)	for diameter steps in millimetres	* < 3	+10	+12	+16	+20	+31	+6	+6	+8	+12	+2	+0.8	+1.2	+2	+3	+4	+6	+10
		> 3 to 6	+15	+18	+22	+28	+40	+10	+9	+12	+16	+4	+1	+1.5	+2.5	+4	+5	+8	+12
		> 6 to 10	+19	+22	+28	+35	+49	+13	+11	+14	+20	+5	+1	+1.5	+2.5	+4	+6	+9	+15
		> 10 to 18	+24	+27	+34	+43	+59	+16	+14	+17	+24	+6	+1.2	+2	+3	+5	+8	+11	+18
		> 18 to 30	+29	+33	+41	+53	+72	+20	+16	+20	+28	+7	+1.5	+2.5	+4	+6	+9	+13	+21
		> 30 to 50	+36	+41	+50	+64	+87	+25	+20	+25	+34	+9	+1.5	+2.5	+4	+7	+11	+16	+25
		> 50 to 80	+43	+49	+60	+76	+104	+30	+23	+29	+40	+10	+2	+3	+5	+8	+13	+19	+30
		> 80 to 120	+51	+58	+71	+90	+123	+36	+27	+34	+47	+12	+2.5	+4	+6	+10	+15	+22	+35
		> 120 to 180	+61	+68	+83	+106	+143	+43	+32	+39	+54	+14	+3.5	+5	+8	+12	+18	+25	+40
		> 180 to 250	+70	+79	+96	+122	+165	+50	+35	+44	+61	+15	+4.5	+7	+10	+14	+20	+29	+46
		> 250 to 315	+79	+88	+108	+137	+186	+56	+40	+49	+69	+17	+6	+8	+12	+16	+23	+32	+52
		> 315 to 400	+87	+98	+119	+151	+202	+62	+43	+54	+75	+18	+7	+9	+13	+18	+25	+36	+57
	> 400 to 500	+95	+108	+131	+165	+223	+68	+47	+60	+83	+20	+8	+10	+15	+20	+27	+40	+63	

* Up to 1 mm, grades 14 to 16 are not provided.

Numerical values amended from the former ISA System are framed in a bold line.

2. Inch values

Symbol	Letter	F						G										
	Grade	5	6	7	8	9	5 to 9	5	6	7	5 to 7	1	2	3	4	5	6	7
Deviations		ES					EI	ES			EI							
Values of deviations in 0.001 in for diameter steps in inches	* < 0.12	+0.45	+0.55	+0.7	+0.9	+1.3	+0.3	+0.25	+0.35	+0.5	+0.1	+0.03	+0.05	+0.08	+0.12	+0.15	+0.25	+0.4
	> 0.12 to 0.24	+0.6	+0.7	+0.9	+1.1	+1.6	+0.4	+0.35	+0.45	+0.65	+0.15	+0.04	+0.06	+0.10	+0.15	+0.2	+0.3	+0.5
	> 0.24 to 0.40	+0.75	+0.9	+1.1	+1.4	+1.9	+0.5	+0.45	+0.6	+0.8	+0.2	+0.04	+0.06	+0.10	+0.15	+0.25	+0.4	+0.6
	> 0.40 to 0.71	+0.9	+1	+1.3	+1.6	+2.2	+0.6	+0.55	+0.65	+0.95	+0.25	+0.05	+0.08	+0.12	+0.2	+0.30	+0.4	+0.7
	> 0.71 to 1.19	+1.2	+1.3	+1.6	+2.0	+2.8	+0.8	+0.7	+0.8	+1.1	+0.3	+0.06	+0.10	+0.15	+0.25	+0.4	+0.5	+0.8
	> 1.19 to 1.97	+1.4	+1.6	+2	+2.6	+3.5	+1	+0.8	+1	+1.4	+0.4	+0.06	+0.10	+0.15	+0.3	+0.4	+0.6	+1
	> 1.97 to 3.15	+1.7	+1.9	+2.4	+3	+4.2	+1.2	+0.9	+1.1	+1.6	+0.4	+0.08	+0.12	+0.20	+0.3	+0.5	+0.7	+1.2
	> 3.15 to 4.73	+2	+2.3	+2.8	+3.6	+4.9	+1.4	+1.1	+1.4	+1.9	+0.5	+0.1	+0.15	+0.25	+0.4	+0.6	+0.9	+1.4
	> 4.73 to 7.09	+2.3	+2.6	+3.2	+4.1	+5.6	+1.6	+1.3	+1.6	+2.2	+0.6	+0.12	+0.2	+0.3	+0.5	+0.7	+1	+1.6
	> 7.09 to 9.85	+2.8	+3.2	+3.8	+4.8	+6.5	+2	+1.4	+1.8	+2.4	+0.6	+0.20	+0.3	+0.4	+0.6	+0.8	+1.2	+1.8
	> 9.85 to 12.41	+3.1	+3.4	+4.2	+5.2	+7.2	+2.2	+1.6	+1.9	+2.7	+0.7	+0.25	+0.3	+0.5	+0.6	+0.9	+1.2	+2
	> 12.41 to 15.75	+3.5	+3.9	+4.7	+6	+8.5	+2.5	+1.7	+2.1	+2.9	+0.7	+0.3	+0.4	+0.5	+0.7	+1	+1.4	+2.2
	> 15.75 to 19.69	+3.8	+4.4	+5.3	+6.8	+8.8	+2.8	+1.8	+2.4	+3.3	+0.8	+0.3	+0.4	+0.6	+0.8	+1	+1.6	+2.5

* Up to 0.04 in, grades 14 to 16 are not provided.

1. Metric values

Holes F to J

H														J					
4	5	6	7	8	9	10	11	12	13	14 *	15 *	16 *	1 to 16	6		7		8	
ES													EI	ES	EI	ES	EI	ES	EI
+3	+4	+6	+10	+14	+25	+40	+60	+100	+140	+250	+400	+600	0	+2	-4	+4	-6	+6	-8
+4	+5	+8	+12	+18	+30	+48	+75	+120	+180	+300	+480	+750	0	+5	-3	+6	-6	+10	-8
+4	+6	+9	+15	+22	+36	+58	+90	+150	+220	+360	+580	+900	0	+5	-4	+8	-7	+12	-10
+5	+8	+11	+18	+27	+43	+70	+110	+180	+270	+430	+700	+1100	0	+6	-5	+10	-8	+15	-12
+6	+9	+13	+21	+33	+52	+84	+130	+210	+330	+520	+840	+1300	0	+8	-5	+12	-9	+20	-13
+7	+11	+16	+25	+39	+62	+100	+160	+250	+390	+620	+1000	+1600	0	+10	-6	+14	-11	+24	-15
+8	+13	+19	+30	+46	+74	+120	+190	+300	+460	+740	+1200	+1900	0	+13	-6	+18	-12	+28	-18
+10	+15	+22	+35	+54	+87	+140	+220	+350	+540	+870	+1400	+2200	0	+16	-6	+22	-13	+34	-20
+12	+18	+25	+40	+63	+100	+160	+250	+400	+630	+1000	+1600	+2500	0	+18	-7	+26	-14	+41	-22
+14	+20	+29	+46	+72	+115	+185	+290	+460	+720	+1150	+1850	+2900	0	+22	-7	+30	-16	+47	-25
+16	+23	+32	+52	+81	+130	+210	+320	+520	+810	+1300	+2100	+3200	0	+25	-7	+36	-16	+55	-26
+18	+25	+36	+57	+89	+140	+230	+360	+570	+890	+1400	+2300	+3600	0	+29	-7	+39	-18	+60	-29
+20	+27	+40	+63	+97	+155	+250	+400	+630	+970	+1550	+2500	+4000	0	+33	-7	+43	-20	+66	-31

2. Inch values

H														J					
4	5	6	7	8	9	10	11	12	13	14 *	15 *	16 *	1 to 16	6		7		8	
ES													EI	ES	EI	ES	EI	ES	EI
+0.12	+0.15	+0.25	+0.4	+0.6	+1	+1.6	+2.5	+4	+6	+10	+16	+25	0	+0.1	-0.15	+0.15	-0.25	+0.25	-0.35
+0.15	+0.2	+0.3	+0.5	+0.7	+1.2	+1.8	+3	+5	+7	+12	+18	+30	0	+0.2	-0.1	+0.25	-0.25	+0.4	-0.3
+0.15	+0.25	+0.4	+0.6	+0.9	+1.4	+2.2	+3.5	+6	+9	+14	+22	+35	0	+0.25	-0.15	+0.3	-0.3	+0.5	-0.4
+0.2	+0.30	+0.4	+0.7	+1	+1.6	+2.8	+4	+7	+10	+16	+28	+40	0	+0.25	-0.15	+0.4	-0.3	+0.5	-0.5
+0.25	+0.4	+0.5	+0.8	+1.2	+2	+3.5	+5	+8	+12	+20	+35	+50	0	+0.3	-0.2	+0.5	-0.3	+0.7	-0.5
+0.3	+0.4	+0.6	+1	+1.6	+2.5	+4.0	+6	+10	+16	+25	+40	+60	0	+0.4	-0.2	+0.6	-0.4	+1	-0.6
+0.3	+0.5	+0.7	+1.2	+1.8	+3	+4.5	+7	+12	+18	+30	+45	+70	0	+0.5	-0.2	+0.8	-0.4	+1.1	-0.7
+0.4	+0.6	+0.9	+1.4	+2.2	+3.5	+5	+9	+14	+22	+35	+50	+90	0	+0.7	-0.2	+0.9	-0.5	+1.4	-0.8
+0.5	+0.7	+1	+1.6	+2.5	+4	+6	+10	+16	+25	+40	+60	+100	0	+0.7	-0.3	+1	-0.6	+1.6	-0.9
+0.6	+0.8	+1.2	+1.8	+2.8	+4.5	+7	+12	+18	+28	+45	+70	+120	0	+0.9	-0.3	+1.1	-0.7	+1.8	-1
+0.6	+0.9	+1.2	+2	+3	+5	+8	+12	+20	+30	+50	+80	+120	0	+0.9	-0.3	+1.3	-0.7	+2	-1
+0.7	+1	+1.4	+2.2	+3.5	+6	+9	+14	+22	+35	+60	+90	+140	0	+1.1	-0.3	+1.5	-0.7	+2.3	-1.2
+0.8	+1	+1.6	+2.5	+4	+6	+10	+16	+25	+40	+60	+100	+160	0	+1.3	-0.3	+1.6	-0.9	+2.7	-1.3

ES = upper deviation
EI = lower deviation

1. Metric values

Symbol	Letter		J _S																			
	Grade		1		2		3		4		5		6		7		8		9		10	
Deviations			ES	EI	ES	EI	ES	EI	ES	EI	ES	EI	ES	EI	ES	EI	ES	EI	ES	EI	ES	EI
Values of deviations in microns (1 μ = 0.001 mm)	for diameter steps in millimetres	* < 3	+0.4	-0.4	+0.6	-0.6	+1	-1	+1.5	-1.5	+2	-2	+3	-3	+5	-5	+7	-7	+12.5	-12.5	+20	-20
		> 3 to 6	+0.5	-0.5	+0.75	-0.75	+1.25	-1.25	+2	-2	+2.5	-2.5	+4	-4	+6	-6	+9	-9	+15	-15	+24	-24
		> 6 to 10	+0.5	-0.5	+0.75	-0.75	+1.25	-1.25	+2	-2	+3	-3	+4.5	-4.5	+7.5	-7.5	+11	-11	+18	-18	+29	-29
		> 10 to 18	+0.6	-0.6	+1	-1	+1.5	-1.5	+2.5	-2.5	+4	-4	+5.5	-5.5	+9	-9	+13.5	-13.5	+21.5	-21.5	+35	-35
		< 18 to 30	+0.75	-0.75	+1.25	-1.25	+2	-2	+3	-3	+4.5	-4.5	+6.5	-6.5	+10.5	-10.5	+16.5	-16.5	+26	-26	+42	-42
		> 30 to 50	+0.75	-0.75	+1.25	-1.25	+2	-2	+3.5	-3.5	+5.5	-5.5	+8	-8	+12.5	-12.5	+19.5	-19.5	+31	-31	+50	-50
		> 50 to 80	+1	-1	+1.5	-1.5	+2.5	-2.5	+4	-4	+6.5	-6.5	+9.5	-9.5	+15	-15	+23	-23	+37	-37	+60	-60
		> 80 to 120	+1.25	-1.25	+2	-2	+3	-3	+5	-5	+7.5	-7.5	+11	-11	+17.5	-17.5	+27	-27	+43.5	-43.5	+70	-70
		> 120 to 180	+1.75	-1.75	+2.5	-2.5	+4	-4	+6	-6	+9	-9	+12.5	-12.5	+20	-20	+31.5	-31.5	+50	-50	+80	-80
		> 180 to 250	+2.25	-2.25	+3.5	-3.5	+5	-5	+7	-7	+10	-10	+14.5	-14.5	+23	-23	+36	-36	+57.5	-57.5	+92.5	-92.5
		> 250 to 315	+3	-3	+4	-4	+6	-6	+8	-8	+11.5	-11.5	+16	-16	+26	-26	+40.5	-40.5	+65	-65	+105	-105
		> 315 to 400	+3.5	-3.5	+4.5	-4.5	+6.5	-6.5	+9	-9	+12.5	-12.5	+18	-18	+28.5	-28.5	+44.5	-44.5	+70	-70	+115	-115
		> 400 to 500	+4	-4	+5	-5	+7.5	-7.5	+10	-10	+13.5	-13.5	+20	-20	+31.5	-31.5	+48.5	-48.5	+77.5	-77.5	+125	-125

* Up to 1 mm, the grades 14 to 16 are not given.

Numerical values amended from the former ISA System are framed in a bold line.

2. Inch values

Symbol	Letter		J _s																			
	Grade		1		2		3		4		5		6		7		8		9		10	
Deviations			ES	EI	ES	EI	ES	EI	ES	EI	ES	EI	ES	EI	ES	EI	ES	EI	ES	EI	ES	EI
Values of deviations in 0.001 in for diameter steps in inches	* ≤ 0.12	+0.015	-0.015	+0.025	-0.025	+0.04	-0.04	+0.06	-0.06	+0.08	-0.08	+0.12	-0.12	+0.2	-0.2	+0.3	-0.3	+0.5	-0.5	+0.8	-0.8	
	> 0.12 to 0.24	+0.02	-0.02	+0.03	-0.03	+0.05	-0.05	+0.08	-0.08	+0.1	-0.1	+0.15	-0.15	+0.25	-0.25	+0.3	-0.3	+0.6	-0.6	+0.9	-0.9	
	> 0.24 to 0.40	+0.02	-0.02	+0.03	-0.03	+0.05	-0.05	+0.08	-0.08	+0.12	-0.12	+0.2	-0.2	+0.3	-0.3	+0.4	-0.4	+0.7	-0.7	+1	-1	
	> 0.40 to 0.71	+0.025	-0.025	+0.04	-0.04	+0.06	-0.06	+0.1	-0.1	+0.15	-0.15	+0.2	-0.2	+0.3	-0.3	+0.5	-0.5	+0.8	-0.8	+1.4	-1.4	
	> 0.71 to 1.19	+0.03	-0.03	+0.05	-0.05	+0.08	-0.08	+0.12	-0.12	+0.2	-0.2	+0.25	-0.25	+0.4	-0.4	+0.6	-0.6	+1	-1	+1.8	-1.8	
	> 1.19 to 1.97	+0.03	-0.03	+0.05	-0.05	+0.08	-0.08	+0.15	-0.15	+0.2	-0.2	+0.3	-0.3	+0.5	-0.5	+0.8	-0.8	+1.2	-1.2	+2	-2	
	> 1.97 to 3.15	+0.04	-0.04	+0.06	-0.06	+0.1	-0.1	+0.15	-0.15	+0.25	-0.25	+0.3	-0.3	+0.6	-0.6	+0.9	-0.9	+1.6	-1.6	+2.2	-2.2	
	> 3.15 to 4.73	+0.05	-0.05	+0.08	-0.08	+0.12	-0.12	+0.2	-0.2	+0.3	-0.3	+0.4	-0.4	+0.7	-0.7	+1	-1	+1.8	-1.8	+2.5	-2.5	
	> 4.73 to 7.09	+0.06	-0.06	+0.1	-0.1	+0.15	-0.15	+0.25	-0.25	+0.3	-0.3	+0.5	-0.5	+0.8	-0.8	+1.2	-1.2	+2	-2	+3	-3	
	> 7.09 to 9.85	+0.1	-0.1	+0.15	-0.15	+0.2	-0.2	+0.3	-0.3	+0.4	-0.4	+0.6	-0.6	+0.9	-0.9	+1.4	-1.4	+2.2	-2.2	+3.5	-3.5	
	> 9.85 to 12.41	+0.12	-0.12	+0.15	-0.15	+0.25	-0.25	+0.3	-0.3	+0.4	-0.4	+0.6	-0.6	+1	-1	+1.6	-1.6	+2.5	-2.5	+4	-4	
	> 12.41 to 15.75	+0.15	-0.15	+0.2	-0.2	+0.25	-0.25	+0.3	-0.3	+0.5	-0.5	+0.7	-0.7	+1	-1	+1.8	-1.8	+3	-3	+4.5	-4.5	
	> 15.75 to 19.69	+0.15	-0.15	+0.2	-0.2	+0.3	-0.3	+0.4	-0.4	+0.5	-0.5	+0.8	-0.8	+1.2	-1.2	+2	-2	+3	-3	+5	-5	

* Up to 0.04 in, the grades 14 to 16 are not given.

1. Metric values

Holes J_S to K

J _s																K								
9		10		11		12		13		14 *		15 *		16 *		5		6		7		8		
EI	ES	EI	ES	EI	ES	EI	ES	EI	ES	EI	ES	EI	ES	EI	ES	EI	ES	EI	ES	EI	ES	EI	ES	EI
-7	+12.5	-12.5	+20	-20	+30	-30	+50	-50	+70	-70	+125	-125	+200	-200	+300	-300	0	-4	0	-6	0	-10	0	-14
-9	+15	-15	+24	-24	+37.5	-37.5	+60	-60	+90	-90	+150	-150	+240	-240	+375	-375	0	-5	+2	-6	+3	-9	+5	-13
-11	+18	-18	+29	-29	+45	-45	+75	-75	+110	-110	+180	-180	+290	-290	+450	-450	+1	-5	+2	-7	+5	-10	+6	-16
-13.5	+21.5	-21.5	+35	-35	+55	-55	+90	-90	+135	-135	+215	-215	+350	-350	+550	-550	+2	-6	+2	-9	+6	-12	+8	-19
-16.5	+26	-26	+42	-42	+65	-65	+105	-105	+165	-165	+260	-260	+420	-420	+650	-650	+1	-8	+2	-11	+6	-15	+10	-23
-19.5	+31	-31	+50	-50	+80	-80	+125	-125	+195	-195	+310	-310	+500	-500	+800	-800	+2	-9	+3	-13	+7	-18	+12	-27
-23	+37	-37	+60	-60	+95	-95	+150	-150	+230	-230	+370	-370	+600	-600	+950	-950	+3	-10	+4	-15	+9	-21	+14	-32
-27	+43.5	-43.5	+70	-70	+110	-110	+175	-175	+270	-270	+435	-435	+700	-700	+1100	-1100	+2	-13	+4	-18	+10	-25	+16	-38
-31.5	+50	-50	+80	-80	+125	-125	+200	-200	+315	-315	+500	-500	+800	-800	+1250	-1250	+3	-15	+4	-21	+12	-28	+20	-43
-36	+57.5	-57.5	+92.5	-92.5	+145	-145	+230	-230	+360	-360	+575	-575	+925	-925	+1450	-1450	+2	-18	+5	-24	+13	-33	+22	-50
-40.5	+65	-65	+105	-105	+160	-160	+260	-260	+405	-405	+650	-650	+1050	-1050	+1600	-1600	+3	-20	+5	-27	+16	-36	+25	-56
-44.5	+70	-70	+115	-115	+180	-180	+285	-285	+445	-445	+700	-700	+1150	-1150	+1800	-1800	+3	-22	+7	-29	+17	-40	+28	-61
-48.5	+77.5	-77.5	+125	-125	+200	-200	+315	-315	+485	-485	+775	-775	+1250	-1250	+2000	-2000	+2	-25	+8	-32	+18	-45	+29	-68

2. Inch values

J _s																K									
8		9		10		11		12		13		14 *		15 *		16 *		5		6		7		8	
ES	EI	ES	EI	ES	EI	ES	EI	ES	EI	ES	EI	ES	EI	ES	EI	ES	EI	ES	EI	ES	EI	ES	EI	ES	EI
0.3	-0.3	+0.5	-0.5	+0.8	-0.8	+1.2	-1.2	+2	-2	+3	-3	+5	-5	+8	-8	+12	-12	0	-0.15	0	-0.25	0	-0.4	0	-0.6
0.3	-0.3	+0.6	-0.6	+0.9	-0.9	+1.6	-1.6	+2.5	-2.5	+3.5	-3.5	+6	-6	+9	-9	+16	-16	0	-0.2	0	-0.3	+0.1	-0.4	+0.1	-0.6
0.4	-0.4	+0.7	-0.7	+1	-1	+1.8	-1.8	+3	-3	+4.5	-4.5	+7	-7	+10	-10	+18	-18	0	-0.25	+0.05	-0.35	+0.1	-0.5	+0.2	-0.7
0.5	-0.5	+0.8	-0.8	+1.4	-1.4	+2	-2	+3.5	-3.5	+5	-5	+8	-8	+14	-14	+20	-20	0	-0.3	0	-0.4	+0.2	-0.5	+0.2	-0.8
0.6	-0.6	+1	-1	+1.8	-1.8	+2.5	-2.5	+4	-4	+6	-6	+10	-10	+18	-18	+25	-25	0	-0.4	0	-0.5	+0.2	-0.6	+0.3	-0.9
0.8	-0.8	+1.2	-1.2	+2	-2	+3	-3	+5	-5	+8	-8	+12	-12	+20	-20	+30	-30	0	-0.4	+0.1	-0.5	+0.3	-0.7	+0.5	-1.1
0.9	-0.9	+1.6	-1.6	+2.2	-2.2	+3.5	-3.5	+6	-6	+9	-9	+14	-14	+22	-22	+35	-35	+0.1	-0.4	+0.1	-0.6	+0.4	-0.8	+0.5	-1.3
1	-1	+1.8	-1.8	+2.5	-2.5	+4.5	-4.5	+7	-7	+10	-10	+18	-18	+25	-25	+45	-45	+0.1	-0.5	+0.2	-0.7	+0.4	-1	+0.7	-1.5
1.2	-1.2	+2	-2	+3	-3	+5	-5	+8	-8	+12	-12	+20	-20	+30	-30	+50	-50	+0.1	-0.6	+0.2	-0.8	+0.5	-1.1	+0.8	-1.7
1.4	-1.4	+2.2	-2.2	+3.5	-3.5	+6	-6	+9	-9	+14	-14	+22	-22	+35	-35	+60	-60	0	-0.8	+0.2	-1	+0.4	-1.4	+0.8	-2
1.6	-1.6	+2.5	-2.5	+4	-4	+6	-6	+10	-10	+16	-16	+25	-25	+40	-40	+60	-60	+0.1	-0.8	+0.1	-1.1	+0.6	-1.4	+0.8	-2.2
1.8	-1.8	+3	-3	+4.5	-4.5	+7	-7	+10	-10	+18	-18	+30	-30	+45	-45	+70	-70	+0.1	-0.9	+0.2	-1.2	+0.6	-1.6	+1.1	-2.4
2	-2	+3	-3	+5	-5	+8	-8	+12	-12	+20	-20	+30	-30	+50	-50	+80	-80	0	-1	+0.4	-1.2	+0.7	-1.8	+1.3	-2.7

ES = upper deviation
EI = lower deviation

Symbol	Letter	M								N							
	Grade	5		6		7		8 *		5		6		7			
Deviations		ES	EI	ES	EI	ES	EI	ES	EI	ES	EI	ES	EI	ES	EI	ES	EI
Values of deviations in microns ($1 \mu = 0.001 \text{ mm}$)	for diameter steps in millimetres																
	≤ 3	-2	-6	-2	-8	-2	-12	—	—	-4	-8	-4	-10	-4	-14	—	—
	>3 to 6	-3	-8	-1	-9	0	-12	+2	-16	-7	-12	-5	-13	-4	-16	—	—
	>6 to 10	-4	-10	-3	-12	0	-15	+1	-21	-8	-14	-7	-16	-4	-19	—	—
	>10 to 18	-4	-12	-4	-15	0	-18	+2	-25	-9	-17	-9	-20	-5	-23	—	—
	>18 to 30	-5	-14	-4	-17	0	-21	+4	-29	-12	-21	-11	-24	-7	-28	—	—
	>30 to 50	-5	-16	-4	-20	0	-25	+5	-34	-13	-24	-12	-28	-8	-33	—	—
	>50 to 65	-6	-19	-5	-24	0	-30	+5	-41	-15	-28	-14	-33	-9	-39	—	—
	>65 to 80	-6	-19	-5	-24	0	-30	+5	-41	-15	-28	-14	-33	-9	-39	—	—
	>80 to 100	-8	-23	-6	-28	0	-35	+6	-48	-18	-33	-16	-38	-10	-45	—	—
	>100 to 120	-8	-23	-6	-28	0	-35	+6	-48	-18	-33	-16	-38	-10	-45	—	—
	>120 to 140	-9	-27	-8	-33	0	-40	+8	-55	-21	-39	-20	-45	-12	-52	—	—
	>140 to 160	-9	-27	-8	-33	0	-40	+8	-55	-21	-39	-20	-45	-12	-52	—	—
	>160 to 180	-9	-27	-8	-33	0	-40	+8	-55	-21	-39	-20	-45	-12	-52	—	—
	>180 to 200	-11	-31	-8	-37	0	-46	+9	-63	-25	-45	-22	-51	-14	-60	—	—
	>200 to 225	-11	-31	-8	-37	0	-46	+9	-63	-25	-45	-22	-51	-14	-60	—	—
	>225 to 250	-11	-31	-8	-37	0	-46	+9	-63	-25	-45	-22	-51	-14	-60	—	—
	>250 to 280	-13	-36	-9	-41	0	-52	+9	-72	-27	-50	-25	-57	-14	-66	—	—
	>280 to 315	-13	-36	-9	-41	0	-52	+9	-72	-27	-50	-25	-57	-14	-66	—	—
	>315 to 355	-14	-39	-10	-46	0	-57	+11	-78	-30	-55	-26	-62	-16	-73	—	—
	>355 to 400	-14	-39	-10	-46	0	-57	+11	-78	-30	-55	-26	-62	-16	-73	—	—
	>400 to 450	-16	-43	-10	-50	0	-63	+11	-86	-33	-60	-27	-67	-17	-80	—	—
	>450 to 500	-16	-43	-10	-50	0	-63	+11	-86	-33	-60	-27	-67	-17	-80	—	—

Numerical values amended from the former ISA System are framed in a bold line.

Symbol	Letter	M								N							
	Grade	5		6		7		8 *		5		6		7			
Deviations		ES	EI	ES	EI	ES	EI	ES	EI	ES	EI	ES	EI	ES	EI	ES	EI
Values of deviations in 0.001 in	for diameter steps in inches																
	≤ 0.12	-0.1	-0.25	-0.1	-0.35	-0.1	-0.5	—	—	-0.15	-0.3	-0.15	-0.4	-0.15	-0.55	—	—
	>0.12 to 0.24	-0.1	-0.3	0	-0.3	0	-0.5	0	-0.7	-0.25	-0.45	-0.2	-0.5	-0.1	-0.6	—	—
	>0.24 to 0.40	-0.15	-0.4	-0.1	-0.5	0	-0.6	0	-0.9	-0.3	-0.55	-0.25	-0.65	-0.2	-0.8	—	—
	>0.40 to 0.71	-0.2	-0.5	-0.2	-0.6	0	-0.7	0	-1	-0.4	-0.7	-0.4	-0.8	-0.2	-0.9	—	—
	>0.71 to 1.19	-0.15	-0.55	-0.2	-0.7	0	-0.8	+0.1	-1.1	-0.45	-0.85	-0.5	-1	-0.3	-1.1	—	—
	>1.19 to 1.97	-0.3	-0.7	-0.2	-0.8	0	-1	+0.2	-1.4	-0.6	-1	-0.5	-1.1	-0.3	-1.3	—	—
	>1.97 to 2.56	-0.3	-0.8	-0.3	-1	0	-1.2	+0.1	-1.7	-0.6	-1.1	-0.6	-1.3	-0.3	-1.5	—	—
	>2.56 to 3.15	-0.3	-0.8	-0.3	-1	0	-1.2	+0.1	-1.7	-0.6	-1.1	-0.6	-1.3	-0.3	-1.5	—	—
	>3.15 to 3.94	-0.3	-0.9	-0.2	-1.1	0	-1.4	+0.3	-1.9	-0.8	-1.4	-0.7	-1.6	-0.5	-1.9	—	—
	>3.94 to 4.73	-0.3	-0.9	-0.2	-1.1	0	-1.4	+0.3	-1.9	-0.8	-1.4	-0.7	-1.6	-0.5	-1.9	—	—
	>4.73 to 5.52	-0.4	-1.1	-0.3	-1.3	0	-1.6	+0.3	-2.2	-1	-1.7	-0.9	-1.9	-0.6	-2.2	—	—
	>5.52 to 6.30	-0.4	-1.1	-0.3	-1.3	0	-1.6	+0.3	-2.2	-1	-1.7	-0.9	-1.9	-0.6	-2.2	—	—
	>6.30 to 7.09	-0.4	-1.1	-0.3	-1.3	0	-1.6	+0.3	-2.2	-1	-1.7	-0.9	-1.9	-0.6	-2.2	—	—
	>7.09 to 7.88	-0.4	-1.2	-0.2	-1.4	0	-1.8	+0.4	-2.4	-1.2	-2	-1	-2.2	-0.8	-2.6	—	—
	>7.88 to 8.86	-0.4	-1.2	-0.2	-1.4	0	-1.8	+0.4	-2.4	-1.2	-2	-1	-2.2	-0.8	-2.6	—	—
	>8.86 to 9.85	-0.4	-1.2	-0.2	-1.4	0	-1.8	+0.4	-2.4	-1.2	-2	-1	-2.2	-0.8	-2.6	—	—
	>9.85 to 11.03	-0.5	-1.4	-0.5	-1.7	0	-2	+0.2	-2.8	-1.1	-2	-1.1	-2.3	-0.6	-2.6	—	—
	>11.03 to 12.41	-0.5	-1.4	-0.5	-1.7	0	-2	+0.2	-2.8	-1.1	-2	-1.1	-2.3	-0.6	-2.6	—	—
	>12.41 to 13.98	-0.5	-1.5	-0.4	-1.8	0	-2.2	+0.5	-3	-1.3	-2.3	-1.2	-2.6	-0.8	-3	—	—
	>13.98 to 15.75	-0.5	-1.5	-0.4	-1.8	0	-2.2	+0.5	-3	-1.3	-2.3	-1.2	-2.6	-0.8	-3	—	—
	>15.75 to 17.72	-0.7	-1.7	-0.3	-1.9	0	-2.5	+0.6	-3.4	-1.6	-2.6	-1.2	-2.8	-0.9	-3.4	—	—
	>17.72 to 19.69	-0.7	-1.7	-0.3	-1.9	0	-2.5	+0.6	-3.4	-1.6	-2.6	-1.2	-2.8	-0.9	-3.4	—	—

* When M8 deviations are missing, N8 deviations should be substituted for them.

1. Metric values

N										P							
6		7		8		9 to 11	9	10	11	5		6		7		8 and 9	8
ES	EI	ES	EI	ES	EI	ES	EI			ES	EI	ES	EI	ES	EI	ES	EI
-4	-10	-4	-14	-4	-18	-4	-29	-44	-64	-6	-10	-6	-12	-6	-16	-6	-20
-5	-13	-4	-16	-2	-20	0	-30	-48	-75	-11	-16	-9	-17	-8	-20	-12	-30
-7	-16	-4	-19	-3	-25	0	-36	-58	-90	-13	-19	-12	-21	-9	-24	-15	-37
-9	-20	-5	-23	-3	-30	0	-43	-70	-110	-15	-23	-15	-26	-11	-29	-18	-45
-11	-24	-7	-28	-3	-36	0	-52	-84	-130	-19	-28	-18	-31	-14	-35	-22	-55
-12	-28	-8	-33	-3	-42	0	-62	-100	-160	-22	-33	-21	-37	-17	-42	-26	-65
-14	-33	-9	-39	-4	-50	0	-74	-120	-190	-27	-40	-26	-45	-21	-51	-32	-78
-16	-38	-10	-45	-4	-58	0	-87	-140	-220	-32	-47	-30	-52	-24	-59	-37	-91
-20	-45	-12	-52	-4	-67	0	-100	-160	-250	-37	-55	-36	-61	-28	-68	-43	-106
-22	-51	-14	-60	-5	-77	0	-115	-185	-290	-44	-64	-41	-70	-33	-79	-50	-122
-25	-57	-14	-66	-5	-86	0	-130	-210	-320	-49	-72	-47	-79	-36	-88	-56	-137
-26	-62	-16	-73	-5	-94	0	-140	-230	-360	-55	-80	-51	-87	-41	-98	-62	-151
-27	-67	-17	-80	-6	-103	0	-155	-250	-400	-61	-88	-55	-95	-45	-108	-68	-165

2. Inch values

N										P							
6		7		8		9 to 11	9	10	11	5		6		7		8 and 9	8
ES	EI	ES	EI	ES	EI	ES	EI			ES	EI	ES	EI	ES	EI	ES	EI
-0.15	-0.4	-0.15	-0.55	-0.15	-0.75	-0.15	-1.15	-1.75	-2.65	-0.25	-0.4	-0.25	-0.5	-0.25	-0.65	-0.25	-0.85
-0.2	-0.5	-0.1	-0.6	-0.1	-0.8	0	-1.2	-1.8	-3	-0.45	-0.65	-0.4	-0.7	-0.3	-0.8	-0.5	-1.2
-0.25	-0.65	-0.2	-0.8	-0.1	-1	0	-1.4	-2.2	-3.5	-0.5	-0.75	-0.45	-0.85	-0.4	-1	-0.6	-1.5
-0.4	-0.8	-0.2	-0.9	-0.2	-1.2	0	-1.6	-2.8	-4	-0.6	-0.9	-0.6	-1	-0.4	-1.1	-0.7	-1.7
-0.5	-1	-0.3	-1.1	-0.2	-1.4	0	-2	-3.5	-5	-0.65	-1.05	-0.7	-1.2	-0.5	-1.3	-0.8	-2
-0.5	-1.1	-0.3	-1.3	-0.1	-1.7	0	-2.5	-4	-6	-0.9	-1.3	-0.8	-1.4	-0.6	-1.6	-1	-2.6
-0.6	-1.3	-0.3	-1.5	-0.2	-2	0	-3	-4.5	-7	-1.2	-1.7	-1.2	-1.9	-0.9	-2.1	-1.4	-3.2
-0.7	-1.6	-0.5	-1.9	-0.2	-2.4	0	-3.5	-5	-9	-1.4	-2	-1.3	-2.2	-1.1	-2.5	-1.6	-3.8
-0.9	-1.9	-0.6	-2.2	-0.3	-2.8	0	-4	-6	-10	-1.6	-2.3	-1.5	-2.5	-1.2	-2.8	-1.8	-4.3
-1	-2.2	-0.8	-2.6	-0.4	-3.2	0	-4.5	-7	-12	-1.8	-2.6	-1.6	-2.8	-1.4	-3.2	-2	-4.8
-1.1	-2.3	-0.6	-2.6	-0.4	-3.4	0	-5	-8	-12	-1.9	-2.8	-1.9	-3.1	-1.4	-3.4	-2.2	-5.2
-1.2	-2.6	-0.8	-3	-0.3	-3.8	0	-6	-9	-14	-2.2	-3.2	-2.1	-3.5	-1.7	-3.9	-2.5	-6
-1.2	-2.8	-0.9	-3.4	-0.3	-4.3	0	-6	-10	-16	-2.6	-3.6	-2.2	-3.8	-1.9	-4.4	-2.8	-6.8

			R								S					
	8	9	5		6		7		8		5		6		7	
	EI		ES	EI	ES	EI	ES	EI	ES	EI	ES	EI	ES	EI	ES	EI
	-20	-31	-10	-14	-10	-16	-10	-20	-10	-24	-14	-18	-14	-20	-14	-24
	-30	-42	-14	-19	-12	-20	-11	-23	-15	-33	-18	-23	-16	-24	-15	-27
	-37	-51	-17	-23	-16	-25	-13	-28	-19	-41	-21	-27	-20	-29	-17	-32
	-45	-61	-20	-28	-20	-31	-16	-34	-23	-50	-25	-33	-25	-36	-21	-39
	-55	-74	-25	-34	-24	-37	-20	-41	-28	-61	-32	-41	-31	-44	-27	-48
	-65	-88	-30	-41	-29	-45	-25	-50	-34	-73	-39	-50	-38	-54	-34	-59
	-78	-106	-36	-49	-35	-54	-30	-60	-41	-87	-48	-61	-47	-66	-42	-72
			-38	-51	-37	-56	-32	-62	-43	-89	-54	-67	-53	-72	-48	-78
	-91	-124	-46	-61	-44	-66	-38	-73	-51	-105	-66	-81	-64	-86	-58	-93
			-49	-64	-47	-69	-41	-76	-54	-108	-74	-89	-72	-94	-66	-101
	-106	-143	-57	-75	-56	-81	-48	-88	-63	-126	-86	-104	-85	-110	-77	-117
			-59	-77	-58	-83	-50	-90	-65	-128	-94	-112	-93	-118	-85	-125
			-62	-80	-61	-86	-53	-93	-68	-131	-102	-120	-101	-126	-93	-133
	-122	-165	-71	-91	-68	-97	-60	-106	-77	-149	-116	-136	-113	-142	-105	-151
			-74	-94	-71	-100	-63	-109	-80	-152	-124	-144	-121	-150	-113	-159
			-78	-98	-75	-104	-67	-113	-84	-156	-134	-154	-131	-160	-123	-169
	-137	-186	-87	-110	-85	-117	-74	-126	-94	-175	-151	-174	-149	-181	-138	-190
			-91	-114	-89	-121	-78	-130	-98	-179	-163	-186	-161	-193	-150	-202
	-151	-202	-101	-126	-97	-133	-87	-144	-108	-197	-183	-208	-179	-215	-169	-226
			-107	-132	-103	-139	-93	-150	-114	-203	-201	-226	-197	-233	-187	-244
	-165	-223	-119	-146	-113	-153	-103	-166	-126	-223	-225	-252	-219	-259	-209	-272
			-125	-152	-119	-159	-109	-172	-132	-229	-245	-272	-239	-279	-229	-292

			R								S					
	8	9	5		6		7		8		5		6		7	
	EI		ES	EI	ES	EI	ES	EI	ES	EI	ES	EI	ES	EI	ES	EI
	-0.85	-1.25	-0.4	-0.55	-0.4	-0.65	-0.4	-0.8	-0.4	-1	-0.6	-0.75	-0.6	-0.85	-0.6	-1
	-1.2	-1.7	-0.55	-0.75	-0.5	-0.8	-0.4	-0.9	-0.6	-1.3	-0.65	-0.85	-0.6	-0.9	-0.6	-1
	-1.5	-2	-0.7	-0.95	-0.65	-1.05	-0.6	-1.2	-0.8	-1.7	-0.9	-1.15	-0.85	-1.25	-0.8	-1.4
	-1.7	-2.3	-0.9	-1.2	-0.9	-1.3	-0.7	-1.4	-1	-2	-1.1	-1.4	-1.1	-1.5	-0.9	-1.6
	-2	-2.8	-1.05	-1.45	-1.1	-1.6	-0.9	-1.7	-1.2	-2.4	-1.25	-1.65	-1.3	-1.8	-1.1	-1.9
	-2.6	-3.5	-1.3	-1.7	-1.2	-1.8	-1	-2	-1.4	-3	-1.7	-2.1	-1.6	-2.2	-1.4	-2.4
	-3.2	-4.4	-1.4	-1.9	-1.4	-2.1	-1.1	-2.3	-1.6	-3.4	-1.8	-2.3	-1.8	-2.5	-1.5	-2.7
			-2	-2.5	-2	-2.7	-1.7	-2.9			-2	-2.5	-2	-2.7	-1.7	-2.9
	-3.8	-5.1	-1.8	-2.4	-1.7	-2.6	-1.5	-2.9	-2	-4.2	-2.6	-3.2	-2.5	-3.4	-2.3	-3.7
			-2.8	-3.4	-2.7	-3.6	-2.5	-3.9			-2.8	-3.4	-2.7	-3.6	-2.5	-3.9
	-4.3	-5.8	-2.3	-3	-2.2	-3.2	-1.9	-3.5	-2.5	-5	-3.3	-4	-3.2	-4.2	-2.9	-4.5
			-3.8	-4.5	-3.7	-4.7	-3.4	-5			-3.8	-4.5	-3.7	-4.7	-3.4	-5
			-4.3	-5	-4.2	-5.2	-3.9	-5.5			-4.3	-5	-4.2	-5.2	-3.9	-5.5
	-4.8	-6.5	-2.8	-3.6	-2.6	-3.8	-2.4	-4.2	-3	-5.8	-4.8	-5.6	-4.6	-5.8	-4.4	-6.2
			-4.8	-5.6	-4.6	-5.8	-4.4	-6.2			-4.8	-5.6	-4.6	-5.8	-4.4	-6.2
			-5.7	-6.5	-5.6	-6.8	-5.4	-7.2			-5.7	-6.5	-5.6	-6.8	-5.4	-7.2
	-5.2	-7.2	-3.2	-4.1	-3.2	-4.4	-2.7	-4.7	-3.5	-6.5	-6.7	-7.6	-6.7	-7.9	-6.2	-8.2
			-6.7	-7.6	-6.6	-8	-6.2	-8.4			-6.7	-7.6	-6.6	-8	-6.2	-8.4
	-6	-8.5	-4.2	-5.2	-4.1	-5.5	-3.7	-5.9	-4.5	-8	-7.7	-8.7	-7.6	-9	-7.2	-9.4
			-8.8	-9.8	-8.4	-10	-8.1	-10.6			-8.8	-9.8	-8.4	-10	-8.1	-10.6
	-6.8	-8.8	-4.8	-5.8	-4.4	-6	-4.1	-6.6	-5	-9	-9.8	-11.8	-9.4	-11	-9.1	-11.6

ES = upper deviation
EI = lower deviation

1. Metric values

Symbol	Letter	T *				U				V **				X				Y
	Grade	6		7		6		7		6		7		6		7		
Deviations		ES	EI	ES	EI	ES	EI	ES	EI	ES	EI	ES	EI	ES	EI	ES	EI	ES
Values of deviations in microns (1 μ = 0.001 mm)	<3	—	—	—	—	-18	-24	-18	-28	—	—	—	—	-20	-26	-20	-30	—
	>3 to 6	—	—	—	—	-20	-28	-19	-31	—	—	—	—	-25	-33	-24	-36	—
	>6 to 10	—	—	—	—	-25	-34	-22	-37	—	—	—	—	-31	-40	-28	-43	—
	>10 to 14	—	—	—	—	-30	-41	-26	-44	—	—	—	—	-37	-48	-33	-51	—
	>14 to 18	—	—	—	—	—	—	—	—	-36	-47	-32	-50	-42	-53	-38	-56	—
	>18 to 24	—	—	—	—	-37	-50	-33	-54	-43	-56	-39	-60	-50	-63	-46	-67	-55
	>24 to 30	-37	-50	-33	-54	-44	-57	-40	-61	-51	-64	-47	-68	-60	-73	-56	-77	-67
	>30 to 40	-43	-59	-39	-64	-55	-71	-51	-76	-63	-79	-59	-84	-75	-91	-71	-96	-85
	>40 to 50	-49	-65	-45	-70	-65	-81	-61	-86	-76	-92	-72	-97	-92	-108	-88	-113	-105
	>50 to 65	-60	-79	-55	-85	-81	-100	-76	-106	-96	-115	-91	-121	-116	-135	-111	-141	-133
	>65 to 80	-69	-88	-64	-94	-96	-115	-91	-121	-114	-133	-109	-139	-140	-159	-135	-165	-163
	>80 to 100	-84	-106	-78	-113	-117	-139	-111	-146	-139	-161	-133	-168	-171	-193	-165	-200	-201
	>100 to 120	-97	-119	-91	-126	-137	-159	-131	-166	-165	-187	-159	-194	-203	-225	-197	-232	-241
	>120 to 140	-115	-140	-107	-147	-163	-188	-155	-195	-195	-220	-187	-227	-241	-266	-233	-273	-285
	>140 to 160	-127	-152	-119	-159	-183	-208	-175	-215	-221	-246	-213	-253	-273	-298	-265	-305	-325
	>160 to 180	-139	-164	-131	-171	-203	-228	-195	-235	-245	-270	-237	-277	-303	-328	-295	-335	-365
	>180 to 200	-157	-186	-149	-195	-227	-256	-219	-265	-275	-304	-267	-313	-341	-370	-333	-379	-408
	>200 to 225	-171	-200	-163	-209	-249	-278	-241	-287	-301	-330	-293	-339	-376	-405	-368	-414	-453
	>225 to 250	-187	-216	-179	-225	-275	-304	-267	-313	-331	-360	-323	-369	-416	-445	-408	-454	-503
	>250 to 280	-209	-241	-198	-250	-306	-338	-295	-347	-376	-408	-365	-417	-466	-498	-455	-507	-560
	>280 to 315	-231	-263	-220	-272	-341	-373	-330	-382	-416	-448	-405	-457	-516	-548	-505	-557	-630
	>315 to 355	-257	-293	-247	-304	-379	-415	-369	-426	-464	-500	-454	-511	-579	-615	-569	-626	-709
	>355 to 400	-283	-319	-273	-330	-424	-460	-414	-471	-519	-555	-509	-566	-649	-685	-639	-696	-799
	>400 to 450	-317	-357	-307	-370	-477	-517	-467	-530	-582	-622	-572	-635	-727	-767	-717	-780	-897
	>450 to 500	-347	-387	-337	-400	-527	-567	-517	-580	-647	-687	-637	-700	-807	-847	-797	-860	-977

Numerical values amended from the former ISA System are framed in a bold line.

2. Inch values

Symbol	Letter	T *				U				V **				X				Y
	Grade	6		7		6		7		6		7		6		7		
Deviations		ES	EI	ES	EI	ES	EI	ES	EI	ES	EI	ES	EI	ES	EI	ES	EI	ES
Values of deviations in 0.001 in	<0.12	—	—	—	—	-0.7	-0.95	-0.7	-1.1	—	—	—	—	-0.9	-1.15	-0.9	-1.3	—
	>0.12 to 0.24	—	—	—	—	-0.8	-1.1	-0.7	-1.2	—	—	—	—	-1.1	-1.4	-1	-1.5	—
	>0.24 to 0.40	—	—	—	—	-1.05	-1.45	-1	-1.6	—	—	—	—	-1.25	-1.65	-1.2	-1.8	—
	>0.40 to 0.56	—	—	—	—	—	—	—	—	—	—	—	—	-1.5	-1.9	-1.3	-2	—
	>0.56 to 0.71	—	—	—	—	-1.3	-1.7	-1.1	-1.8	-1.5	-1.9	-1.3	-2	-1.7	-2.1	-1.5	-2.2	—
	>0.71 to 0.95	—	—	—	—	-1.5	-1.9	-1.3	-2.1	-1.7	-2.2	-1.5	-2.3	-2.1	-2.6	-1.9	-2.7	-2.2
	>0.95 to 1.19	-1.5	-2	-1.3	-2.1	-1.7	-2.2	-1.5	-2.3	-2.1	-2.6	-1.9	-2.7	-2.4	-2.9	-2.2	-3	-2.7
	>1.19 to 1.58	-1.8	-2.4	-1.6	-2.6	-2.3	-2.9	-2.1	-3.1	-2.6	-3.2	-2.4	-3.4	-2.8	-3.4	-2.6	-3.6	-3.1
	>1.58 to 1.97	-2	-2.6	-1.8	-2.8	-2.6	-3.2	-2.4	-3.4	-2.8	-3.4	-2.6	-3.6	-3.8	-4.4	-3.6	-4.6	-4.1
	>1.97 to 2.56	-2.3	-3	-2	-3.2	-3.3	-4	-3	-4.2	-3.8	-4.5	-3.5	-4.7	-4.8	-5.5	-4.5	-5.7	-5.5
	>2.56 to 3.15	-2.8	-3.5	-2.5	-3.7	-3.8	-4.5	-3.5	-4.7	-4.8	-5.5	-4.5	-5.7	-5.8	-6.5	-5.5	-6.7	-6.5
	>3.15 to 3.94	-3.2	-4.1	-3	-4.4	-4.7	-5.6	-4.5	-5.9	-5.7	-6.6	-5.5	-6.9	-6.7	-7.6	-6.5	-7.9	-7.5
	>3.94 to 4.73	-3.7	-4.6	-3.5	-4.9	-5.7	-6.6	-5.5	-6.9	-6.7	-7.6	-6.5	-7.9	-7.7	-8.6	-7.5	-8.9	-9.5
	>4.73 to 5.52	-4.7	-5.7	-4.4	-6	-6.7	-7.7	-6.4	-8	-7.7	-8.7	-7.4	-9	-9.7	-10.7	-9.4	-11	-11.4
	>5.52 to 6.30	-4.7	-5.7	-4.4	-6	-6.7	-7.7	-6.4	-8	-8.7	-9.7	-8.4	-10	-11.7	-12.7	-11.4	-13	-13.4
	>6.30 to 7.09	-5.7	-6.7	-5.4	-7	-7.7	-8.7	-7.4	-9	-9.7	-10.7	-9.4	-11	-11.7	-12.7	-11.4	-13	-13.4
	>7.09 to 7.88	-6.6	-7.8	-6.4	-8.2	-8.6	-9.8	-8.4	-10.2	-11.6	-12.8	-11.4	-13.2	-13.6	-14.8	-13.4	-15.2	-15.4
	>7.88 to 8.86	-6.6	-7.8	-6.4	-8.2	-9.6	-10.8	-9.4	-11.2	-11.6	-12.8	-11.4	-13.2	-15.6	-16.8	-15.4	-17.2	-17.4
	>8.86 to 9.85	-7.6	-8.8	-7.4	-9.2	-11.6	-12.8	-11.4	-13.2	-13.6	-14.8	-13.4	-15.2	-15.6	-16.8	-15.4	-17.2	-19.4
	>9.85 to 11.03	-8.7	-9.9	-8.2	-10.2	-11.7	-12.9	-11.2	-13.2	-15.7	-16.9	-15.2	-17.2	-17.7	-18.9	-17.2	-19.2	-21.2
	>11.03 to 12.41	-9.7	-10.9	-9.2	-11.2	-13.7	-14.9	-13.2	-15.2	-15.7	-16.9	-15.2	-17.2	-19.7	-20.9	-19.2	-21.2	-24.2
	>12.41 to 13.98	-9.6	-11	-9.2	-11.4	-15.6	-17	-15.2	-17.4	-17.6	-19	-17.2	-19.4	-21.6	-23	-21.2	-23.4	-27.2
	>13.98 to 15.75	-11.6	-13	-11.2	-13.4	-17.6	-19	-17.2	-19.4	-19.6	-21	-19.2	-21.4	-24.6	-26	-24.2	-26.4	-29.2
	>15.75 to 17.72	-11.4	-13	-11.1	-13.6	-19.4	-21	-19.1	-21.6	-21.4	-23	-21.1	-23.6	-27.4	-29	-27.1	-29.6	-34.1
	>17.72 to 19.69	-13.4	-15	-13.1	-15.6	-21.4	-23	-21.1	-23.6	-24.4	-26	-24.1	-26.6	-29.4	-31	-29.1	-31.6	-39.1

* When T6 and T7 deviations are missing, U6 and U7 deviations should be substituted for them.

** When V6 and V7 deviations are missing, X6 and X7 deviations should be substituted for them.

*** When Y7 deviations are missing, Z7 deviations should be substituted for them.

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1. Metric values

Holes T to ZC

X				Y***		Z				ZA				ZB				ZC			
6		7		7		7		8		7		8		8		9		8		9	
ES	EI	ES	EI	ES	EI	ES	EI	ES	EI	ES	EI	ES	EI	ES	EI	ES	EI	ES	EI	ES	EI
-20	-26	-20	-30	—	—	-26	-36	-26	-40	-32	-42	-32	-46	-40	-54	-40	-65	-60	-74	-60	-85
-25	-33	-24	-36	—	—	-31	-43	-35	-53	-38	-50	-42	-60	-50	-68	-50	-80	-80	-98	-80	-110
-31	-40	-28	-43	—	—	-36	-51	-42	-64	-46	-61	-52	-74	-67	-89	-67	-103	-97	-119	-97	-133
-37	-48	-33	-51	—	—	-43	-61	-50	-77												
-42	-53	-38	-56	—	—	-53	-71	-60	-87												
-50	-63	-46	-67	-55	-76	-65	-86	-73	-106												
-60	-73	-56	-77	-67	-88	-80	-101	-88	-121												
-75	-91	-71	-96	-85	-110	-103	-128	-112	-151												
-92	-108	-88	-113	-105	-130	-127	-152	-136	-175												
-116	-135	-111	-141	-133	-163	-161	-191	-172	-218												
-140	-159	-135	-165	-163	-193	-199	-229	-210	-256												
-171	-193	-165	-200	-201	-236	-245	-280	-258	-312												
-203	-225	-197	-232	-241	-276	-297	-332	-310	-364												
-241	-266	-233	-273	-285	-325	-350	-390	-365	-428												
-273	-298	-265	-305	-325	-365	-400	-440	-415	-478												
-303	-328	-295	-335	-365	-405	-450	-490	-465	-528												
-341	-370	-333	-379	-408	-454	-503	-549	-520	-592												
-376	-405	-368	-414	-453	-499	-558	-604	-575	-647												
-416	-445	-408	-454	-503	-549	-623	-669	-640	-712												
-466	-498	-455	-507	-560	-612	-690	-742	-710	-791												
-516	-548	-505	-557	-630	-682	-770	-822	-790	-871												
-579	-615	-569	-626	-709	-766	-879	-936	-900	-989												
-649	-685	-639	-696	-799	-856	-979	-1036	-1000	-1089												
-727	-767	-717	-780	-897	-960	-1077	-1140	-1100	-1197												
-807	-847	-797	-860	-977	-1040	-1227	-1290	-1250	-1347												

2. Inch values

X				Y***		Z				ZA				ZB				ZC			
6		7		7		7		8		7		8		8		9		8		9	
ES	EI	ES	EI	ES	EI	ES	EI	ES	EI	ES	EI	ES	EI	ES	EI	ES	EI	ES	EI	ES	EI
-0.9	-1.15	-0.9	-1.3	—	—	-1.2	-1.6	-1.2	-1.8	-1.4	-1.8	-1.4	-2	-1.6	-2.2	-1.6	-2.6	-2.5	-3.1	-2.5	-3.5
-1.1	-1.4	-1	-1.5	—	—	-1.2	-1.7	-1.4	-2.1	-1.4	-1.9	-1.6	-2.3	-2	-2.7	-2	-3.2	-3	-3.7	-3	-4.2
-1.25	-1.65	-1.2	-1.8	—	—	-1.4	-2	-1.6	-2.5	-1.8	-2.4	-2	-2.9	-2.5	-3.4	-2.5	-3.9	-4	-4.9	-4	-5.4
-1.5	-1.9	-1.3	-2	—	—	-1.7	-2.4	-2	-3												
-1.7	-2.1	-1.5	-2.2	—	—	-2.2	-2.9	-2.5	-3.5												
-2.1	-2.6	-1.9	-2.7	-2.2	-3	-2.5	-3.3	-2.8	-4												
-2.4	-2.9	-2.2	-3	-2.7	-3.5	-3.2	-4	-3.5	-4.7												
-2.8	-3.4	-2.6	-3.6	-3.1	-4.1	-4.1	-5.1	-4.5	-6.1												
-3.8	-4.4	-3.6	-4.6	-4.1	-5.1	-4.6	-5.6	-5	-6.6												
-4.8	-5.5	-4.5	-5.7	-5.5	-6.7	-6.5	-7.7	-7	-8.8												
-5.8	-6.5	-5.5	-6.7	-6.5	-7.7	-7.5	-8.7	-8	-9.8												
-6.7	-7.6	-6.5	-7.9	-7.5	-8.9	-9.5	-10.9	-10	-12.2												
-7.7	-8.6	-7.5	-8.9	-9.5	-10.9	-11.5	-12.9	-12	-14.2												
-9.7	-10.7	-9.4	-11	-11.4	-13	-13.4	-15	-14	-16.5												
-11.7	-12.7	-11.4	-13	-13.4	-15	-15.4	-17	-16	-18.5												
-13.7	-14.7	-13.4	-15	-15.4	-17.2	-17.4	-19	-18	-20.5												
-15.6	-16.8	-15.4	-17.2	-17.4	-19.2	-21.4	-23.2	-22	-24.8												
-17.7	-18.9	-17.2	-19.2	-21.2	-23.2	-27.2	-29.2	-28	-31												
-19.7	-20.9	-19.2	-21.2	-24.2	-26.2	-29.2	-31.2	-30	-33												
-21.6	-23	-21.2	-23.4	-27.2	-29.4	-34.2	-36.4	-35	-38.5												
-24.6	-26	-24.2	-26.4	-29.2	-31.4	-39.2	-41.4	-40	-43.5												
-27.4	-29	-27.1	-29.6	-34.1	-36.6	-44.1	-46.6	-45	-49												
-29.4	-31	-29.1	-31.6	-39.1	-41.6	-49.1	-51.6	-50	-54												