

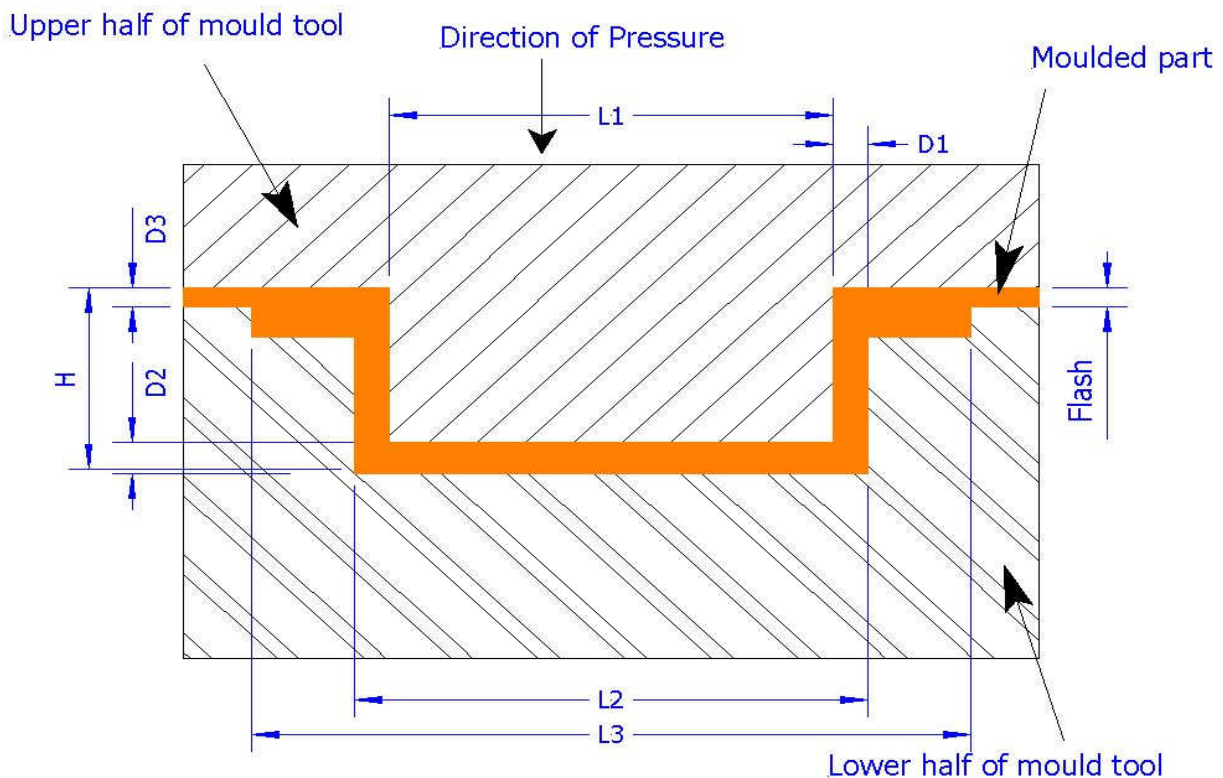
Tolerances for Moulded and Extruded Products

Mouldings

F: Fixed dimensions, unaffected by closure of mould parts. (Dimensions L1, L2 and L3 in diagram below)

C: Closure dimensions, affected by mould part alignment. (Dimensions D1, D2, D3 and H in diagram below)

Mould Dimensions		Class M2		Class M3		Class M4	
above mm	up to mm	F ±mm	C ±mm	F ±mm	C ±mm	F ±mm	C ±mm
0.0	4.0	0.10	0.15	0.25	0.40	0.50	
4.0	6.3	0.15	0.20				
6.3	10	0.20	0.20	0.30	0.50	0.70	
10	16	0.20	0.25	0.40	0.60	0.80	
16	25	0.25	0.35	0.60	0.80	1.00	
25	40	0.35	0.40	0.60	1.00	1.30	
40	63	0.40	0.50	0.80	1.30	1.60	
63	100	0.50	0.70	1.00	1.60	2.00	
100	160	0.70	0.80	1.30	2.00	2.50	
160mm +		F: ±0.5% C: ±0.7%		F: ±0.8% C: ±1.3%		F: ±1.5% C: ±1.5%	



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Extrusions

Nominal Dimension		Class E1		Class E2		Class E3	
above mm	up to mm	±mm	±mm	±mm	±mm	±mm	±mm
0.0	1.5	0.15		0.25		0.40	
1.5	2.5	0.20		0.35		0.50	
2.5	4.0	0.25		0.40		0.70	
4.0	6.3	0.35		0.50		0.80	
6.3	10	0.40		0.70		1.00	
10	16	0.50		0.80		1.30	
16	25	0.70		1.00		1.60	
25	40	0.80		1.30		2.00	
40	63	1.00		1.60		2.50	
63	100	1.30		2.00		3.20	

Rubber Cut Lengths

Nominal Dimension		Class E2		Class E3	
above mm	up to mm	±mm	±mm	±mm	±mm
0.0	40.0	1.00		1.60	
40.0	63.0	1.30		2.00	
63.0	100.0	1.60		2.50	
100.0	160.0	2.00		3.20	
160.0	250	2.50		4.00	
250	400	3.20		5.00	
400	630	4.00		6.30	
630	1000	5.00		10.00	
1000	1600	6.30		12.50	
1600	2500	10.00		16.00	
2500.0	4000.0	12.50		20.00	
4000.0	+	0.32%		0.50%	

Rubber Hardness Tolerances

± 5° IRHD

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Tool-cut, Hand-cut & CAD-cut Gasket Tolerances Rigid Material Gaskets

INSIDE AND OUTSIDE DIAMETER R.F. IBC & FF types	TOOL CUT	HAND/CAD CUT
	Standard 9A	Standard 9B
Up to and including 24" n.b	OD $\pm 0.030''$ $\pm 0.8\text{mm}$ ID ± 0.030 $\pm 0.8\text{mm}$	OD $\pm 0.060''$ $\pm 1.5\text{mm}$ ID $\pm 0.060''$ $\pm 1.5\text{mm}$
Above 24" up to and incl. 60" n.b	OD $\pm 0.060''$ $\pm 1.5\text{mm}$ ID $\pm 0.060''$ $\pm 1.5\text{mm}$	OD $\pm 0.080''$ $\pm 2.0\text{mm}$ ID ± 0.080 $\pm 2.0\text{mm}$
Above 60" n.b	OD $\pm 0.060''$ $\pm 1.5\text{mm}$ ID $\pm 0.060''$ $\pm 1.5\text{mm}$	OD $\pm 0.100''$ $\pm 2.5\text{mm}$ ID $\pm 0.100''$ $\pm 2.5\text{mm}$

PITCH CIRCLE DIAMETER & DIAGONALS OF SQUARES	TOOL CUT	HAND/CAD CUT
	Standard 9A	Standard 9B
Up to, and including 6" n.b/diagonal	$\pm 0.020''$ $\pm 0.5\text{mm}$	$\pm 0.020''$ $\pm 0.5\text{mm}$
Above 6" up to and incl 24" n.b/diagonal	$\pm 0.040''$ $\pm 1.0\text{mm}$	$\pm 0.040''$ $\pm 1.0\text{mm}$
Above 24" n.b/diagonal	$\pm 0.060''$ $\pm 1.5\text{mm}$	$\pm 0.060''$ $\pm 1.5\text{mm}$

BOLT HOLE DIAMETER	TOOL CUT	HAND/CAD CUT
	Standard 9A	Standard 9B
Up to, and including 36" n.b	$\pm 0.040''$ $\pm 1.0\text{mm}$	$\pm 0.040''$ $\pm 1.0\text{mm}$
Above 36" n.b	$\pm 0.060''$ $\pm 2.0\text{mm}$	$\pm 0.060''$ $\pm 2.0\text{mm}$

Flexible Material Gaskets i.e. Rubber, Sponge, Cork etc.

Depending on application, tolerances may be applied with discretion due to material flexibility. With Sales Office and Quality Controller's agreement, add 50% to tolerance levels above.

For flexible materials use tolerance figure above plus 50% E.G. Bolt Hole Diameter for gaskets up to and including 36" N.B. tolerance on bolt hole size is +/- 1.5mm.

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Rubber Sheeting Tolerances

MATERIAL THICKNESS mm	TOLERANCE ±mm	Roll Width ± %	Roll Length ± %
0.7	0.2	2	5
1	0.2	2	5
1.5	0.2	2	5
2	0.3	2	5
2.5	0.3	2	5
3	0.3	2	5
4	0.4	2	5
4.5	0.4	2	5
5	0.4	2	5
6	0.5	2	5
8	0.7	2	5
10	1.0	2	5
12	1.0	2	5
15	1.5	2	5
20	1.5	2	5
25	2.0	2	5
30	2.5	2	5
35	3.0	2	5
40	3.5	2	5
40+	10%	2	5