COi RUBBER PRODUCTS

Tolerance Grade Selection Guide for Molded Parts - Commonly Used Plastics

Material Code	Material		Tolerance Class		
			High Precision	General	None
ABS	Acrylonitrile-butadiene-styrene		MT2	MT3	MT5
AS	Acrylonitrile-styrene		MT2	MT3	MT5
CA	Acetate fiber plastic		MT3	MT4	MT6
EP	Epoxy resin		MT2	MT3	MT5
PA	Nylon	No filler	MT3	MT4	MT6
		Fiberglass filled	MT2	MT3	MT5
PBTP	P-x butylene glycol	No filler	MT3	MT4	MT6
		Fiberglass filled	MT2	MT3	MT5
PC	Polycarbonate		MT2	MT3	MT5
PDAP	Poly (diallyl phthalate)		MT2	MT3	MT5
PE	Polyethylene		MT5	MT6	MT7
PESU	Polyether sulfone		MT2	MT3	MT5
PETP	P-x acid ethylene glycol ester	No filler	MT3	MT4	MT6
		Fiberglass filled	MT2	MT3	MT5
PMMA	Polymethylmethacrylate		MT2	MT3	MT5

Material Code	Material		Tolerance Class		
			High Precision	General	None
PF	Bakelite Plastic	Inorganic fillers	MT2	MT3	MT5
		Organic fillers	MT3	MT4	MT6
POM	POM	≤150mm	MT3	MT4	MT6
		>150mm	MT4	MT5	MT7
PP	Polypropylene	No filler	MT3	MT4	MT6
		Inorganic fillers	MT2	MT3	MT5
PPO	Polyphenylene ether		MT2	MT3	MT5
PPS	Polyphenylene sulfide		MT2	MT3	MT5
PS	Polystyrene		MT2	MT3	MT5
PSU	Polysulfone		MT2	MT3	MT5
RPVC	Rigid PVC		MT2	MT3	MT5
SPVC	Soft PVC		MT5	MT6	MT7
VF/MF	Aminophenol Plastic	Inorganic fillers	MT2	MT3	MT5
		Organic fillers	MT3	MT4	MT6

Dimensional Tolerances for Plastic Parts (Per GB/T14486-93)

Grade	Type	Basic Size																								
		3	6	10	14	18	24	30	40	50	65	80	100	120	140	160	180	200	225	250	280	315	355	400	450	500
MT1	A	0.07	0.08	0.09	0.10	0.11	0.12	0.14	0.16	0.18	0.20	0.23	0.26	0.29	0.32	0.36	0.40	0.44	0.48	0.52	0.56	0.60	0.64	0.70	0.78	0.86
	B	0.14	0.16	0.18	0.20	0.21	0.22	0.24	0.26	0.28	0.30	0.33	0.36	0.39	0.42	0.46	0.50	0.54	0.58	0.62	0.60	0.70	0.74	0.80	0.88	0.96
MT2	A	0.10	0.12	0.14	0.16	0.18	0.20	0.22	0.24	0.26	0.30	0.34	0.38	0.42	0.46	0.50	0.54	0.60	0.66	0.72	0.76	0.84	0.92	1.00	1.10	1.20
	B	0.20	0.22	0.24	0.26	0.28	0.30	0.32	0.34	0.36	0.40	0.44	0.48	0.52	0.56	0.60	0.64	0.70	0.76	0.82	0.86	0.94	1.02	1.10	1.20	1.30
MT3	A	0.12	0.14	0.16	0.18	0.20	0.24	0.28	0.32	0.36	0.40	0.46	0.52	0.58	0.64	0.70	0.78	0.86	0.92	1.00	1.10	1.20	1.30	1.44	1.60	1.74
	B	0.32	0.34	0.36	0.38	0.40	0.44	0.48	0.52	0.56	0.60	0.66	0.72	0.78	0.84	0.90	0.98	1.06	1.12	1.20	1.30	1.40	1.50	1.64	1.80	1.94
MT4	A	0.16	0.18	0.20	0.24	0.28	0.32	0.36	0.42	0.48	0.56	0.64	0.72	0.82	0.92	1.02	1.12	1.24	1.36	1.48	1.62	1.80	2.00	2.20	2.40	2.60
	B	0.36	0.38	0.40	0.44	0.48	0.52	0.56	0.62	0.68	0.76	0.84	0.92	1.02	1.12	1.22	1.32	1.44	1.56	1.68	1.82	2.00	2.20	2.40	2.60	2.80
MT5	A	0.20	0.24	0.28	0.32	0.38	0.44	0.50	0.56	0.64	0.74	0.86	1.00	1.14	1.28	1.44	1.60	1.76	1.92	2.10	2.30	2.50	2.80	3.10	3.50	3.90
	B	0.40	0.44	0.48	0.50	0.58	0.64	0.70	0.76	0.84	0.94	1.06	1.20	1.34	1.48	1.64	1.80	1.96	2.12	2.30	2.50	2.70	3.00	3.30	3.70	4.10
MT6	A	0.26	0.32	0.38	0.46	0.54	0.62	0.70	0.80	0.94	1.10	1.28	1.48	1.72	2.00	2.20	2.40	2.60	2.90	3.20	3.50	3.80	4.30	4.70	5.30	6.00
	B	0.46	0.52	0.58	0.68	0.74	0.82	0.90	1.00	1.14	1.30	1.48	1.60	1.90	2.20	2.40	2.60	2.80	3.10	3.40	3.70	4.00	4.50	4.90	5.50	6.20
MT7	A	0.38	0.48	0.58	0.68	0.78	0.88	1.00	1.14	1.32	1.54	1.80	2.10	2.40	2.70	3.00	3.30	3.70	4.10	4.50	4.90	5.40	6.00	6.70	7.40	8.20
	B	0.58	0.68	0.78	0.88	0.98	1.08	1.20	1.34	1.58	1.74	2.00	2.30	2.60	3.10	3.20	3.50	3.90	4.30	4.70	5.10	5.60	6.20	6.90	7.60	8.40

Test Conditions: 24 hours after molding or "post-treatment", specimen are tested at 23±2 ℃ and 65±5% humidity.

Other materials are selected according to shrinkage characteristic value S: 1% (MT2,3,5) 2% (MT3,4,6) 3% (MT4,5,7).

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