

TOLERANCE SHEET FOR RUBBER AND PLASTIC

	From	0	From	6	From	30	From	100	From	300	From	1000	From	2000	From	4000
	To	6	To	30	To	100	To	300	To	1000	To	2000	To	4000		
MEDIUM	+/- 0.1		+/- 0.2		+/- 0.3		+/- 0.5		+/- 0.8		+/- 1.2		+/- 2		+/- 3	

ISO FOR RUBBER AND PLASTIC

NOM SIZE		WALL	WIDTH	DIAMETER
mm		10	11	12
From	1	40	60	100
to	3			
From	3	48	75	120
to	6			
From	6	58	90	150
to	10			
From	10	70	110	180
to	18			
From	18	84	130	210
to	30			
From	30	100	160	250
to	50			
From	50	120	190	300
to	80			
From	80	140	220	350
to	120			
From	120	160	250	400
to	180			
From	180	185	200	460
to	250			
From	250	210	320	520
to	315			
From	315	230	360	570
to	400			
From	400	250	400	630
to	500			

SURFACE QUALITY

Roughness depth	R _{max}	R _a
Sliding surface	≤2.5 μm	0.05 – 0.3 μm
Bottom of groove	≤6.3 μm	≤1.6 μm
Sides of groove	≤15 μm	≤3 μm

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TOLERANCE RECOMMENDATION

Nominal – Ø D	fit
≤80	H9/f8
>80-120	H8/f8
>120-500	H8/f7
>500-630	H8/f7
>630-800	H8/f7
>800-1000	H8/f7
>1000-1250	H8/f7

Nominal – Ø D	Rod d	Seal housing d
≤80	f 8	H 8
>80	f 8	H 8

EXTRUSION GAPS

L	Permissible extrusion gap or ØD		R max
	ØD ₂ = Ød + Table value		
	To 200 bar	To 400 bar	
2,2	0,4	0,3	0,3
3,2	0,5	0,3	0,5
4,2	0,5	0,4	0,8
6,3	0,5	0,4	1,2
8,1	0,6	0,5	2,0
9,5	0,7	0,5	2,0