

# DIMENSIONAL TOLERANCES AND DEFECTS

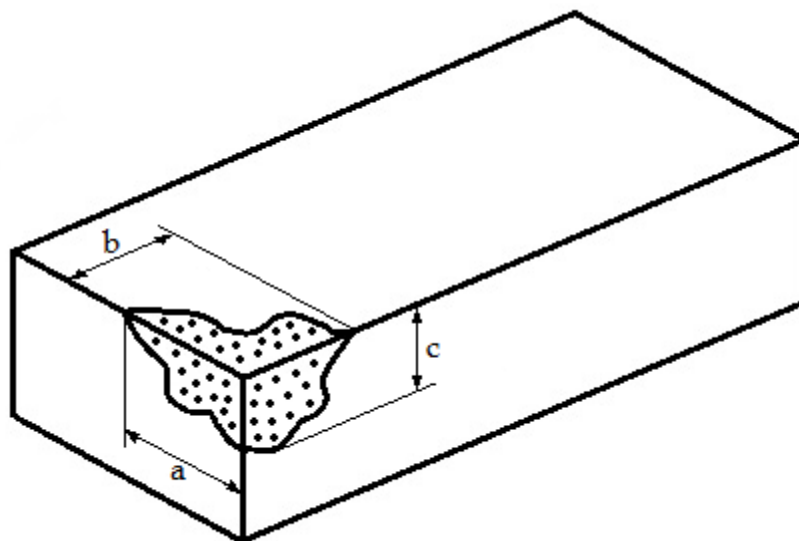
## Products made of plastic and hand-molded masses

### DIMENSIONAL TOLERANCES

Dimensions:	Dimensional deviations:
0 - 100 mm	$\pm 3 \text{ mm}$
100 - 230 mm	$\pm 4 \text{ mm}$
230 - 500 mm	$\pm 2 \%$
above 500 mm	$\pm 1,5 \%$
Warpage checked along the length:	
0 - 230 mm	3 mm
230 - 500 mm	$\pm 1,5 \%$
above 500 mm	$\pm 1,0 \%$

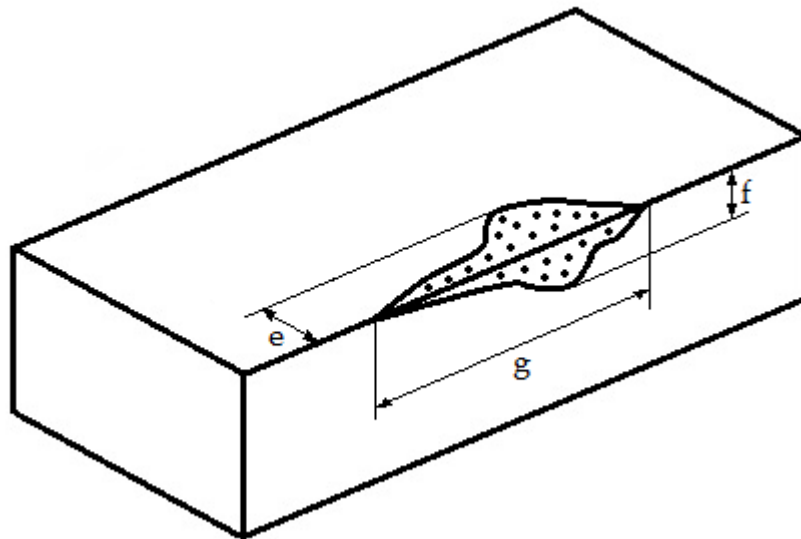
### ACCEPTABLE INTERNAL AND EXTERNAL DEFECTS

#### Corner damage



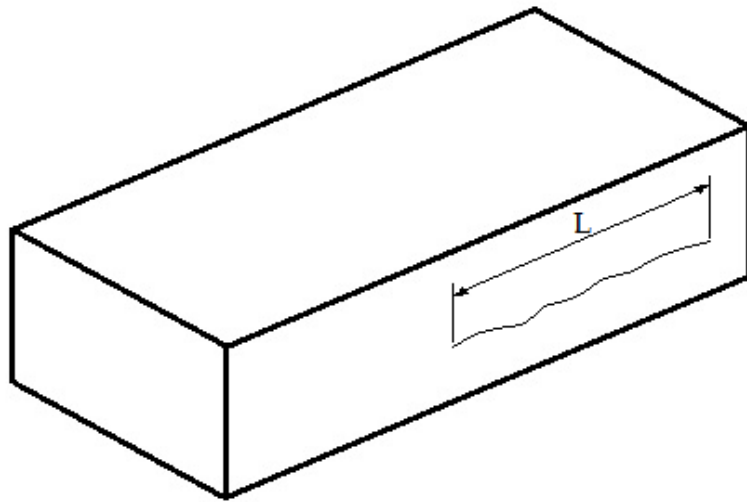
	<b>a + b + c</b>	<b>a, b, c</b>
For products up to 15kg	< 40 mm	< 15 mm
For products above 15 kg	< 80 mm	< 20 mm

Edge damage



	<b>e + f + g</b>	<b>e + f</b>
For products up to 15kg	< 80 mm	< 25 mm
For products above 15 kg	< 120 mm	< 35 mm
Total length of the damaged sections of the edge- <b>max 1/4 of length</b>		

**CRACKS DO NOT PASSING THROUGH THE TWO EDGES**



The crack width 0,2 - 0,5 mm	The crack length L
For products up to 15kg	Acceptable cracks length 50 mm
For products above 15 kg	Acceptable cracks length 100 mm

## **SPOTS AND SLAGGING**

**Allowed single spots do not form clusters in diameter 3 mm.**

**Allowed the slagging in diameter 8 mm.**