

Tolerances

Extrusion

Overview

Viking Extrusions' house tolerances are laid down in our quality manual as follows: (class refers to table 2)

Table 1 – Viking Extrusions house tolerances

| Shape | Class |
|-----------------------|-------|
| Tubes | E1 |
| Strips / Cords | E2 |
| Profiles | E3 |

These tolerances are a general guide and are 'unless otherwise specified'. Invariably any item that has a doubt attaining house tolerance will be specified at time of quoting or clarified during contract review.

Standard

ISO 3302-1:2014 Rubber Tolerances for products

Table 2 – Tolerances on cross-sectional dimensions of unsupported extrusions

| Nominal Dimension | | Class E1 | Class E2 | Class E3 |
|-------------------|---------------------|----------|----------|----------|
| Above | Up to and including | ± | ± | ± |
| 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 | 0.40 | 0.70 | 1.00 |
| 10.0 | 16.0 | 0.50 | 0.80 | 1.30 |
| 16.0 | 25.0 | 0.70 | 1.00 | 1.60 |
| 25.0 | 40.0 | 0.80 | 1.30 | 2.00 |
| 40.0 | 63.0 | 1.00 | 1.60 | 2.50 |
| 63.0 | 100.0 | 1.30 | 2.00 | 3.2 |
| 100.0 | - | 1.3% | 2% | 3.2% |

All values in millimetres

4.2.23.1