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**Permissible stamping variations in dimensions without
tolerance indication**

冲压件未注公差尺寸极限偏差

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Permissible stamping variations in dimensions without tolerance indication

1 Scope

This document specifies linear and angular dimension tolerance grades and limit deviations of stamping pieces without tolerance indication.

This document applies to metal stamping pieces. Non-metal stamping pieces may refer to this document.

The limit deviations specified in this document apply to non-fitted dimensions.

2 Normative references

The following referenced documents are indispensable for the application of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

GB/T 8541, *Terminology of forging and stamping*

3 Terms and definitions

For the purposes of this document, the terms and definitions defined in GB/T 8541 as well as the followings apply.

3.1 blanking size

The linear dimensions of stamping pieces processed by blanking, punching and other separation processes (see D , d , s_1 , s_2 in Figure 1).

mm

3.5 blanking angle

At the plane of the flat or formed piece, the angular dimension formed by blanking (see α in Figure 4)

3.6 bending angle

The angular dimension of the stamping piece processed by the bending forming process (see β in Figure 2).

4 Tolerance grades

The limit deviation of blanking size without tolerance indication, forming size without tolerance indication, blanking corner radius size without tolerance indication, blanking angle size without tolerance indication and bending angle size without tolerance indication are divided into f, m, c, v, four descending tolerance grades. The limit deviation of forming corner radius size without tolerance indication is not divided into the tolerance grades. Tolerances shall be indicated for dimensions of 0.5mm and below.

5 Limit deviation of dimensions without tolerance indication

5.1 Limit deviation of blanking size without tolerance indication

The limit deviation of blanking size without tolerance indication shall be specified in Table 1.

5.2 Limit deviation of forming size without tolerance indication

The limit deviation of forming size without tolerance indication shall be specified in Table 2.

5.3 Limit deviation of corner radius size without tolerance indication

5.3.1 The limit deviation of blanking corner radius size without tolerance indication shall be specified in Table 3.

5.3.2 The limit deviation of forming corner radius size without tolerance indication shall be specified in Table 4.

5.4 Limit deviation of angular size without tolerance indication

5.4.1 The limit deviation of blanking angle size without tolerance indication shall be specified in Table 5.

5.4.2 The limit deviation of bending angle size without tolerance indication shall be specified in Table 6.

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