



SEA BALL

ISO 3290:2001 TOLERANCE, SURFACE ROUGHNESS AND GAUGES FOR STEEL BALLS

GRADE	VARIATION OF BALL DIAMETER	DEVIATION FROM SPHERICAL FORM	SURFACE ROUGHNESS	VARIATION OF BALL LOT DIAMETER	GAUGE INTERVAL	PREFERRED GAUGES	SUBGAUGE INTERVAL	SUBGAUGES
	Vdws max.	max.	Ra max.	Vdwl max.				
μm								
G3	0.08	0.08	0.010	0.13	0.5	-5.....-0.5 0 +0.5.....+5	0.1	-0.2.....-0.1 0 +0.1.....+0.2
G5	0.13	0.13	0.014	0.25	1.0	-5.....-1 0 +1.....+5	0.2	-0.4.....-0.2 0 +0.2.....+4
G10	0.25	0.25	0.020	0.5	1.0	-9.....-1 0 +1.....+9	0.2	-0.4.....-0.2 0 +0.2.....+4
G16	0.4	0.4	0.025	0.8	2.0	-10.....-2 0 +2.....+10	0.4	-0.8.....-0.4 0 +0.4.....+0.8
G20	0.5	0.5	0.032	1.0	2.0	-10.....-2 0 +2.....+10	0.4	-0.8.....-0.4 0 +0.4.....+0.8
G28	0.7	0.7	0.050	1.4	2.0	-12.....-2 0 +2.....+12	0.4	-0.8.....-0.4 0 +0.4.....+0.8
G40	1.0	1.0	0.060	2.0	4.0	-16.....-4 0 +4.....+16	0.8	-1.6.....-0.8 0 +0.8.....+1.6
G60	1.5	1.5	0.080	3.0	6.0	-18.....-6 0 +6.....+18	1.2	-2.4.....-1.2 0 +1.2.....+2.4
G100	2.5	2.5	0.100	5.0	10.0	-40.....-10 0 +10.....+40	2.0	-4.....-2 0 +2.....+4
G200	5.0	5.0	0.150	10.0	15.0	-60.....-15 0 +15.....+60	3.0	-6.....-3 0 +3.....+6

INTERNATIONAL STANDARD ISO 3290 (EDITION 2001)