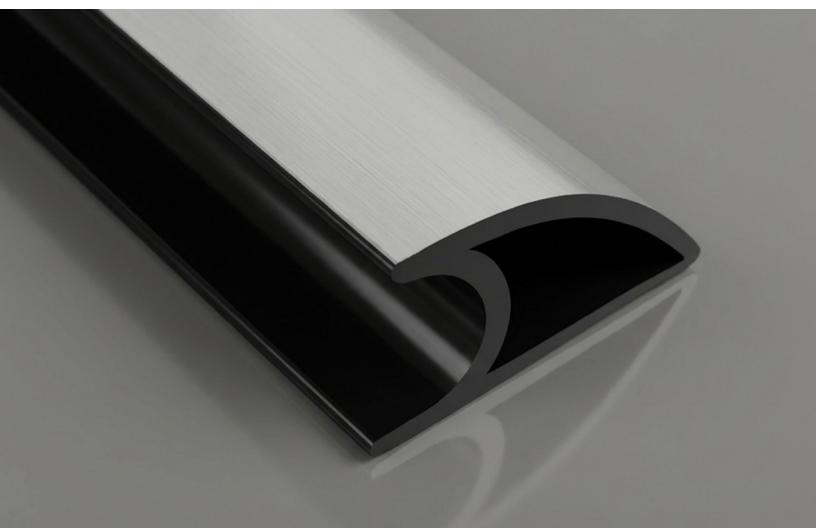
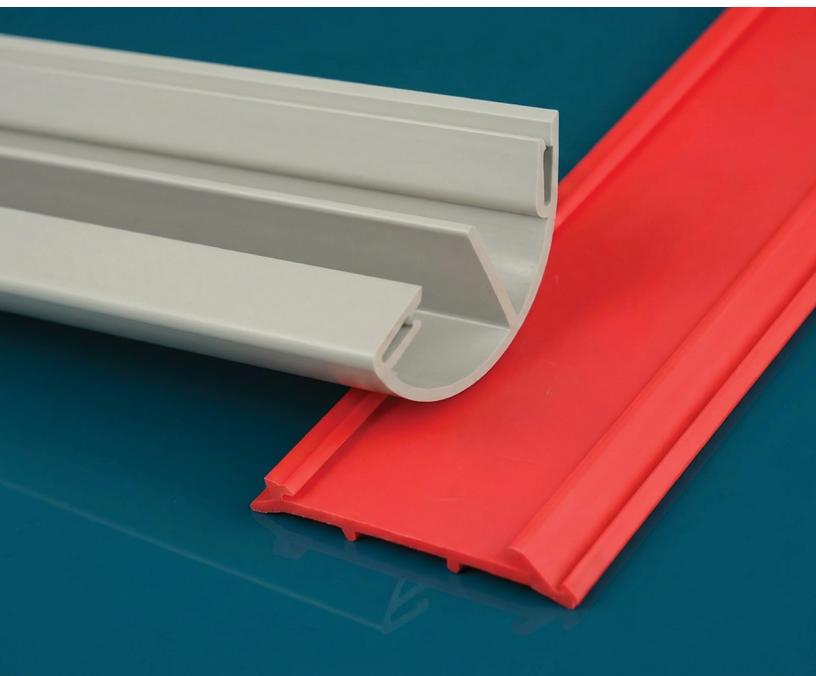


PEXCO

STANDARD

EXTRUSION TOLERANCES



The following **Extrusion Design Tolerance Guide** provides general reference standards for typical extrusion profiles. While these values serve as a helpful baseline, they are not absolute. If your application requires tighter or specialized tolerances, Pexco's expert engineering team is ready to collaborate with you to evaluate options and support your specific needs. Your project is our priority, and we are committed to helping you achieve your performance goals while outlining the associated considerations, benefits, and risks within the manufacturing process.

TABLE 1 // WIDTH TOLERANCES

DIMENSION		NOMINAL DESIGN TOLERANCES FOR THE FOLLOWING TYPES OF DIMENSIONS (SEE ILLUSTRATIONS BELOW)		
Width		Normal Widths (Normal Tolerances)		Width Equals Sum of Several Spaces (Wider Tolerances Required)
From	To	Dimension "W" (Fig. 1) is not affected by changes in the size of other width dimensions and is therefore easier to control.		
Inches	±	±	±	±
0	1	.020		.030
1	2	.030		.045
2	4	.040		.060
4	6	.050		.075
6	10	.060		.090
10	15	.075		.100
15	20	.090		.125
20	24	.125		.150

Notes: The nominal tolerances are design tolerances. Once a part has been developed, the running tolerances can usually be tighter than the design tolerances. Running tolerances normally must be \pm the actual measurements obtained for development samples.

FIG. 1: NORMAL WIDTH

Dimension "W" is not directly dependent on spaces "A" through "D" as the reference dimension "REF" can float. It is therefore easier to control than the "W" dimension in Fig. 2 and **NORMAL TOLERANCES CAN BE USED**.

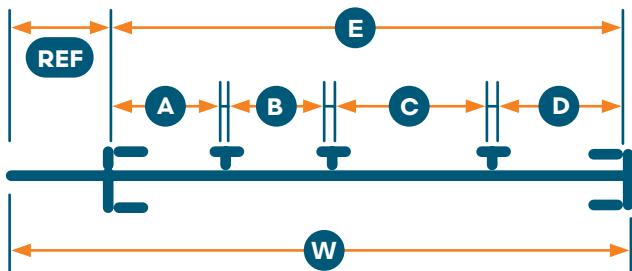


FIG. 2: WIDTH = THE SUM OF SEVERAL SPACES

Dimension "W" is equal to the sum of the spaces "A" + "B" + "C" + "D" and is directly affected by changes to these dimensions. It is therefore more difficult to control than the "W" dimension in Fig. 1 and **WIDER TOLERANCES ARE REQUIRED**. (Dimension "E" in Fig. 1 also is equal to the sum of the space)

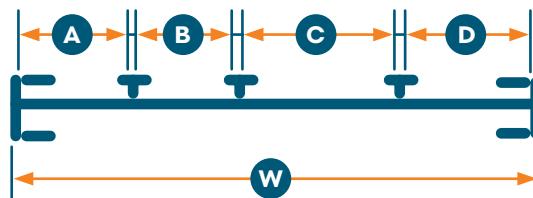


TABLE 2 // LEG LENGTH & HEIGHT DESIGN TOLERANCES

DIMENSION		NOMINAL DESIGN TOLERANCES FOR THE FOLLOWING TYPES OF DIMENSIONS (SEE ILLUSTRATIONS BELOW)		
Leg Length or Height		Single Segments (Normal Tolerances)	Sum of Several Segments (Wider Tolerances Required)	
From	To	Dimension "L" (Fig. 3) is for a single segment. The size of this segment is not dependent on or affected by changes in the size of other dimensions and is easier to control.	Dimension "C" (Fig. 4) is for two or more segments ("L"). Changes in the size of any of the individual segments affects this dimension. This type of dimension is harder to control.	
Inches	±	±	±	±
—	.125	.010	—	—
.125	.250	.015	.020	—
.250	.500	.020	.030	—
.500	1.0	.025	.040	—
1.0	1.5	.030	.045	—
1.5	2.0	.040	.060	—
2.0	3.0	.045	.070	—
3.0	4.0	.050	.075	—
4.0	6.0	.060	—	—
6.0	8.0	.075	—	—
8.0	10.0	.090	—	—

Notes: The nominal tolerances are design tolerances. Once a part has been developed, the running tolerances can usually be tighter than the design tolerances. Running tolerances normally must be \pm the actual measurements obtained for development samples.

FIG. 3: LENGTH OR HEIGHT IS A SINGLE SEGMENT

Dimension "L" is for a single segment. It is not dependent or affected by changes in the size of other dimensions and is easier to control than those in Fig. 4.

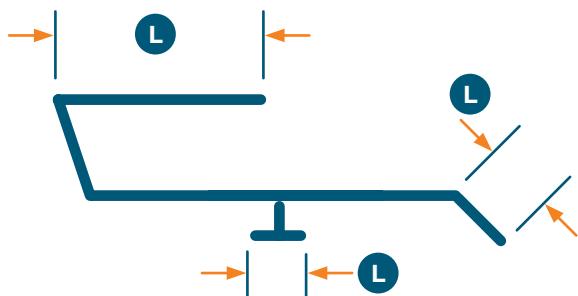


FIG. 4: WIDTH = SUM OF SEVERAL SEGMENT LENGTHS

Dimension "C" is the sum of the segments "L" and is affected by changes in these dimensions. It is therefore more difficult to control "C" than the "L" dimensions in Fig. 3 and **WIDER TOLERANCES ARE REQUIRED**.

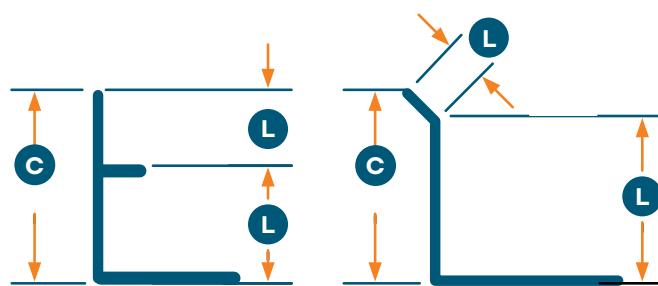


TABLE 3 // SPACE & GAP TOLERANCES

DIMENSION		NOMINAL DESIGN TOLERANCES FOR THE FOLLOWING TYPES OF DIMENSIONS (SEE ILLUSTRATIONS BELOW)			
Width	Gap or Single Space (Normal Tolerances)	MULTIPLE SPACES (Wider Tolerances Required)		ADJUSTABLE GAP (Tighter Tolerances Possible)	
From	To	Dimensions "S" or "G" (Fig. 5) are not affected by changes in the size of other dimensions and are therefore easier to control.		Dimensions "A", "B", "C" & "D" (Fig. 6) are multiple spaces that control width "W". The greater the number of spaces, the wider the tolerances should be for the individual spaces.	
Inches	±	±	±	±	±
.060	.080	15%	—	—	—
.080	.125	10%	—	—	—
.125	.250	10%	—	.015	.015
.250	.500	.025	.030	.015	.015
.500	1.0	.025	.035	.020	.020
1.0	2.0	.030	.045	.020	.020
2.0	3.0	.040	.050	—	—
3.0	4.0	.045	.060	—	—

Notes: The nominal tolerances are design tolerances. Once a part has been developed, the running tolerances can usually be tighter than the design tolerances. Running tolerances normally must be \pm the actual measurements obtained for development samples.

FIG. 1: ANGLE SPACES & GAPS

Single spaces "S" and gaps "G" are individual dimensions and easier to control.

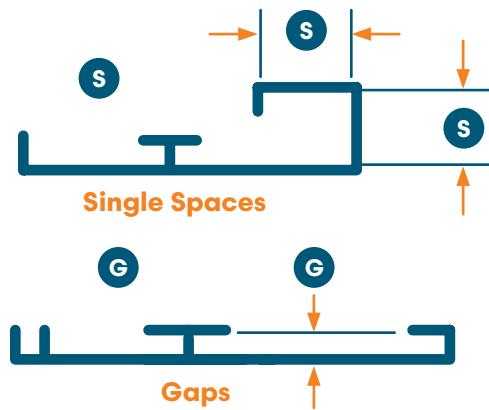


FIG. 2: MULTIPLE SPACES

Dimensions "A" + "B" + "C" + "D" are multiple spaces that control width "W". The greater the number of spaces, the more difficult it is to control the "W" dimension and to hold all the individual spaces within spec. **WIDER TOLERANCES ARE REQUIRED** for the spaces as well as the width.

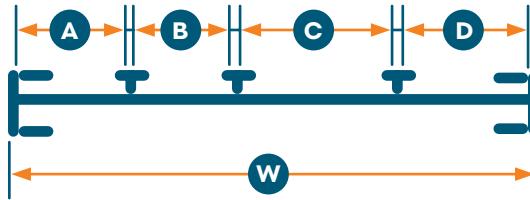
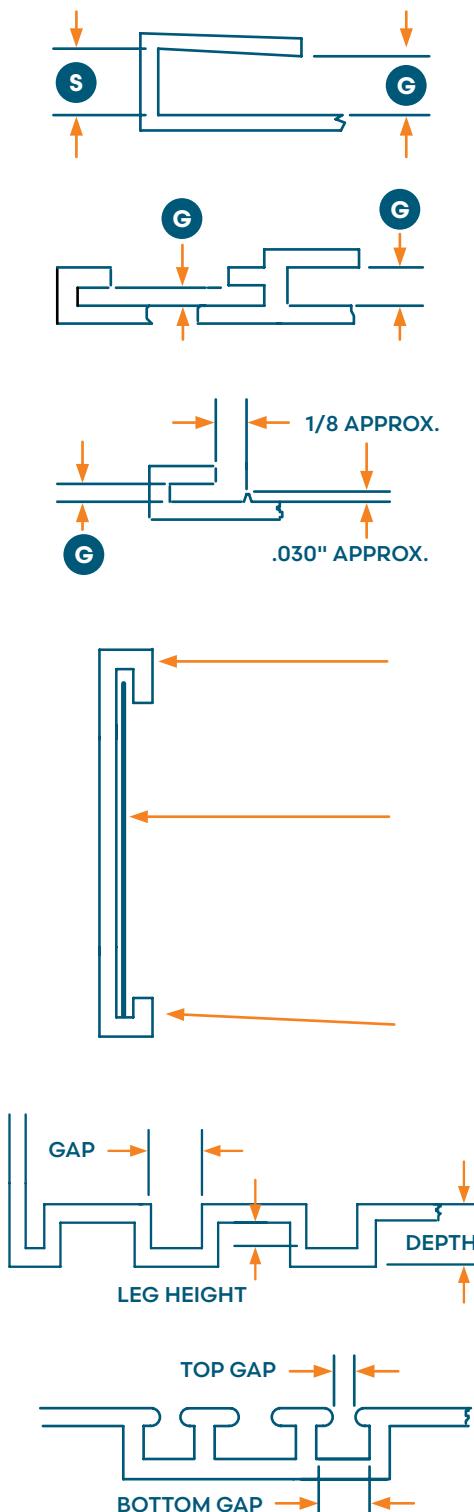


FIG. 7 // GAP DESIGN**EXAMPLE OF AN ADJUSTABLE GAP**

If the part is designed with the space "S" slightly greater than the gap "G", the top leg can be moved up or down slightly to adjust the gap dimension while running the part.

MINIMUM GAP SIZE

Do not specify gaps less than .060" as a jig must be placed inside of the gap to support the legs. The wider the leg, the larger the gap should be, as thicker jigs must be used for deeper gaps.

GAPS FOR THIN INSERTS

If paper or thin flexible inserts are used, set the gap at .060" and add a small thin bead as shown.

CONTROL OF OVERLAP

During development, if this leg is running short and the width of the slot is running toward the max. Standard SPC practice is to lengthen this leg to insure sufficient overlap of the insert. If a minimum overlap is required, this should be specified.

INFORMATION ABOUT INSERT & REQUIRED FIT

Specify the width, thickness, and material of the insert and indicate how it is to be inserted into the slot, such as:

- Insert slides in from the end
- Insert flexes and is inserted from the front
- Insert must slide up into the top gap and then drop into the bottom gap

The bottom leg can normally be shorter.

PROBLEMS WITH DEPTH & FLATNESS

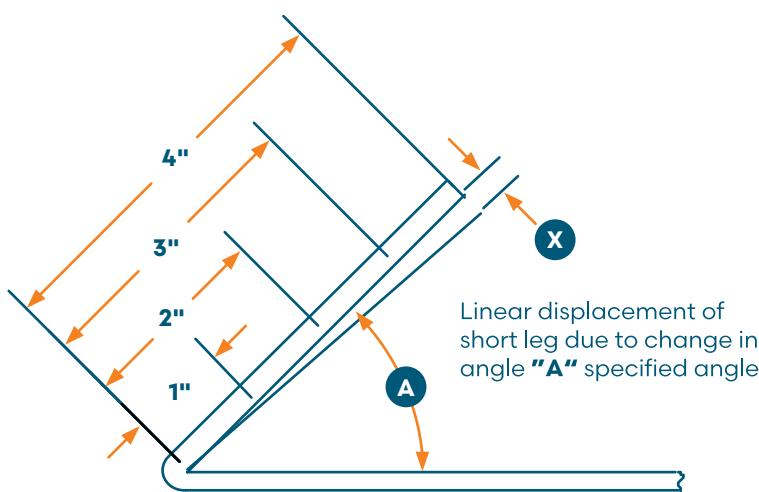
This design makes it difficult to control the depth as the several leg heights won't be the same. This also makes it difficult to get flat bottom and top surfaces.

STACKED GAPS CAUSE PROBLEMS

This is an example of "Stacked Gaps". It is difficult to adjust the gap size, as whatever is done to the top gap usually affects the bottom gap. Larger tolerances may be required, especially if there are a series of gaps as shown. Changes in the adjacent gaps makes it difficult to control the gap dimension.

TABLE 4 // ANGLE DESIGN TOLERANCES

DIMENSION	NOMINAL DESIGN TOLERANCES FOR THE FOLLOWING TYPES OF DIMENSIONS (SEE ILLUSTRATIONS BELOW)		
	Length of Short Leg	Normal Tolerances	Tight Tolerances
See Fig. 8: Angle Tolerances below and Fig. 9: Problems in Measuring Angles on the next page.		Tight tolerances should only be used for simple shapes such as angles and channels. See Fig. 8: Angle Tolerances below and Fig. 9: Problems in Measuring Angles on the next page.	
Inches		±	±
.25	5°	4°	
.50	4°	3°	
.75	3°	2°	
1.0	2°	1.5°	
1.5	2°	1.5°	
2.0	1.5°	1°	
3.0 & Up	1°	.75°	

**FIG. 8:
ANGLE TOLERANCES**

Angles for plastic extrusions are normally controlled by forming plates and jigs as the part is being run. It is usually difficult to move a leg only a few thousandths in order to correct for the linear displacement "X" shown in the illustration.

The legs also move laterally and vertically a small amount due to the extruder surging or due to air drafts as the part is being formed. When legs are short, a small linear displacement changes the angle significantly.

This is why the angular tolerance (in degrees) that can be held increases as the length of the short leg decreases. For a 1° change in an angle, the linear displacement for a 1" long leg is only .017". This jumps to .070" for a 4" long leg.

FIG. 9 // PROBLEMS IN MEASURING ANGLES

This is a drawing of a part. All the legs are perfectly straight and it is easy to measure the angles.

Sometimes it is better to use linear measurements as shown below to control angles.

The legs on plastic extrusions are not perfectly straight but are usually curved slightly as shown below. Note the difference in the measurement at "A" compared to that at "B". For all practical purposes, the angle between the legs is at 120° and the measurement at "A" is correct.

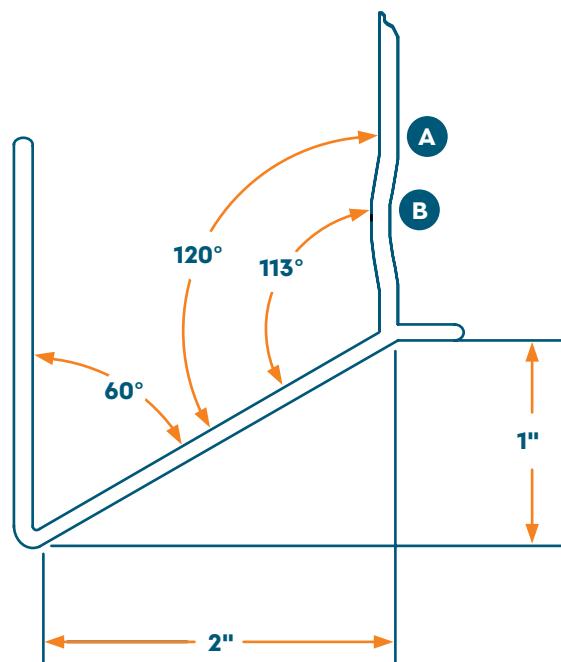
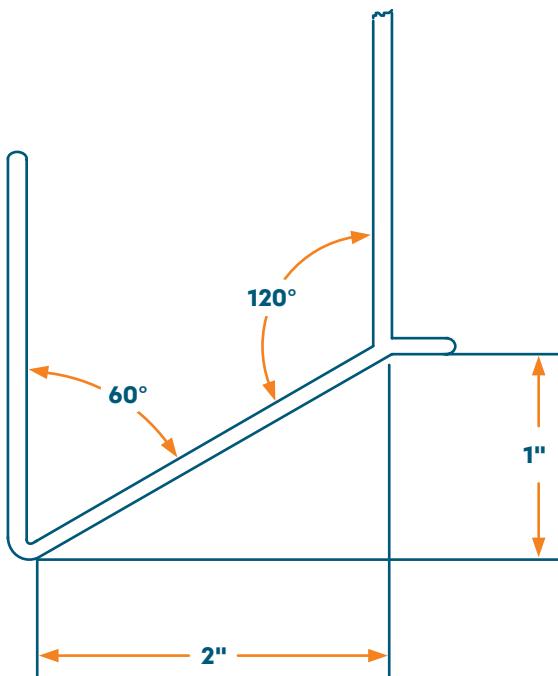
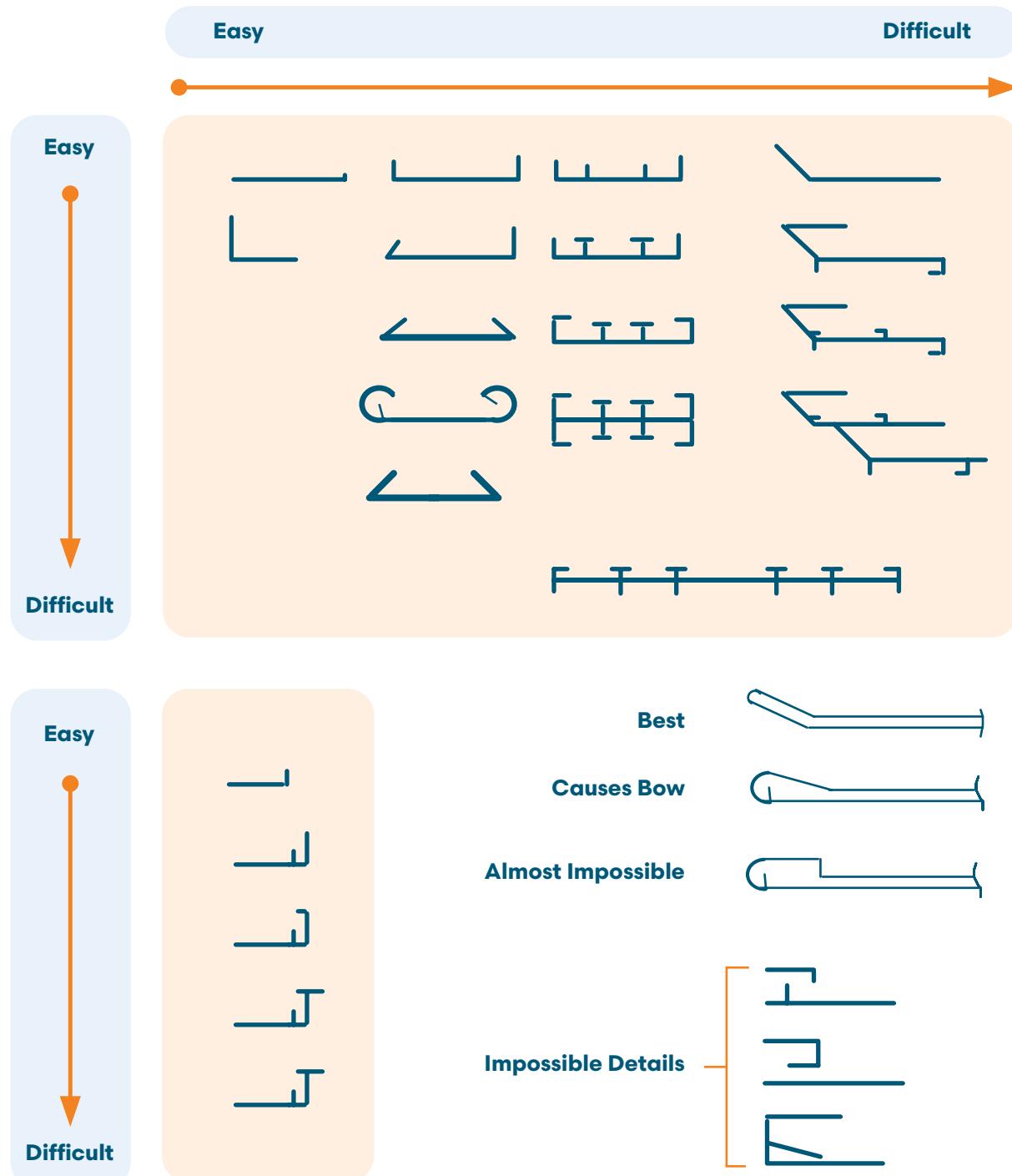


TABLE 5 // FABRICATION TOLERANCES

Hole Size	$\pm .008$
Edge to First Hole	$\pm .031$
Hole to Hole Location	$\pm .031$
Last Hole to Edge	Varies w/ Length Tolerance
Notch Width & Height	$\pm .031$

FIG. 10 // DEGREES OF DIFFICULTY



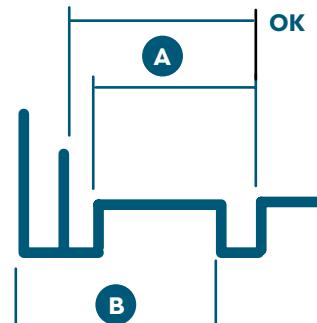
DIMENSIONING

Dimension Not Parallel to Points Being Measured

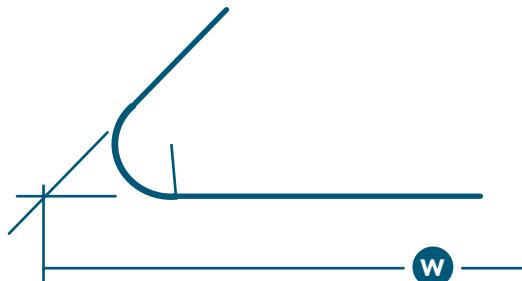
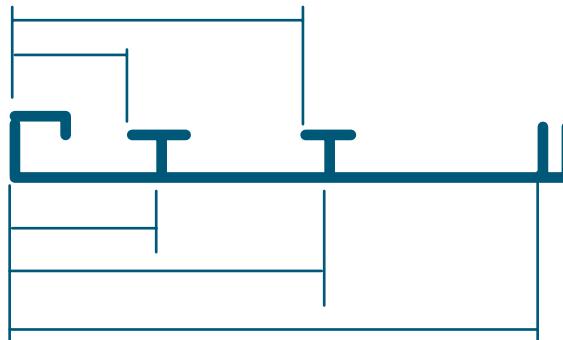
(OK for overall drawing dimension but difficult to measure)

**Outside to Inside Dimensions**

(A&B difficult to measure)

**Dimension Form Intersection of Geometric Points**

(Dimensions OK as reference but not measurable)

**Datum Line Dimensioning**

FACTORS AFFECTING TOLERANCES

- **Tolerances dependent upon complexity of the part**
 - If many segments, more difficult to hold tolerances
 - If simple part, closer tolerances can be held
- **Changing process conditions**
 - Ambient temperature
 - Changes in material from batch to batch
- **Operator dependent — many manual adjustments**
- **Die design**

GUIDELINES FOR USING TOLERANCE TABLES

- **Tolerances are nominal**
- **Best to use dimensions that can be measured directly**
- **Start with dimensions affecting fit with mating parts**
- **Try to limit number of dimensions with tolerances**
- **Use reference dimensions where possible**
 - SPC definition of reference dimension
 - Reference dimensions used in die design
 - Reference dimension checked during development

THICKNESS

- **Normally specify nominal thickness**
 - Expect thickness variations
- **Nominally:** To $.090" \pm 10\%$, Over $.090" \pm 8\%$
- **Where required:** Specify minimum or maximum for particular area

RADI

- **Normally not true radii** — difficult to measure directly
- **Use radius gauges when need to measure**
- **When tolerances required** — see table 2 (single segment)

LENGTH

- **Normally $\pm 1/16"$**
- **Factors affecting length control:**
 - Length, line speed
 - Change in length due to temperature — SPC to destination

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From inspiration to application, Pexco has been helping our customers bring ideas to life for nearly half a century as a plastic extrusion manufacturer. Based in Atlanta, with multiple plants in the U.S. and Mexico, Pexco has grown and evolved to become North America's leader in the design and fabrication of specialty plastic products.

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- Custom Extrusion Lighting Components
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For more information please contact us at:

EMAIL sales@pexco.com / WEB pexco.com/contact / PHONE 844.352.5777