

Standard Tolerances on measurements of products						measuring method		
product	standard tolerances					to use measure equipment and its accuracy		
	(base) article	tolerances length mm	tolerances width mm	tolerances thickness +/- mm	when thickness is (mm):	Length Width	Thickness	
Rigid Panels	Panel Hydrophobic Panel Slim & Light	+/- 3 if length ≤1,6m +/- 6 if Ø +/- 6 if length >1,6m	+/- 3 if width <1,6m +/- 6 if Ø	0,5 0,8 1,5 2	≤ 10,0 10,1 - 30,0 30,1 - 50,0 > 50,0	tape measure (1mm)	tape measure (1mm) per 10 or Caliper (0,1mm)	
	Slim & Light +	+/-1 only for sawed plate	+1/-2 only for sawed plate	+/-0,5 only for the plate	3 - 6 (remark 1 + 2)		Caliper (0,1mm)	
	VIP cores / SlimVac	see other label KSP7 WKP32 app 1f						
	Remark 1: The tolerances of the thickness for "Slim & light +" are those of the Slim & Light combined with those of the plate used. Remark 2: Rigid panels (exception Vip cores) which are sawed, covered or sealed have a normal standard tolerance on sawed length/width of -3/+6mm							
Flexible Panels/Products	Quilted/(semi) Overstitched Panel Density: ≥ 200 kg/m3	+/-3	+/-3	0,5	≤ 10,0	tape measure (1mm)	Thickness gauge deep throat (0,01mm)  except: small articles e.g. ArvinMeritor : Gauge meter (0,01mm) e.g. Aernova : Caliper (0,01mm)	
	Quilted/(semi) Overstitched Panel - Hydrophobic Density: ≥ 280 kg/m3			0,8	> 10,0			
	Quilted Panel - Aeroguard cloth Density: ≥ 200 kg/m3	+/-5	+/-5	0,75	< 6,25			
	Quilted/(semi) Overstitched Panel Densiteit: < 200 kg/m3	+/-3	+/-3		1,0			6,25 - 10,0
	Quilted/(semi) Overstitched Panel - Hydrophobic Density: < 280 kg/m3			+/-5	+/-5			1,50
	Quilted Panel - Aeroguard cloth Density: < 200 kg/m3	+/-3	+/-15					0,5
	Slatted Panel see remark 3			sawn side	0,8			10,1 - 30,0
	Floppy Panel	+/-8	+/-10	0,5	≤ 10,0			
	Steefflex Panel	sawn +/-3	+/-8	0,8	10,1 - 30,0			
	Steefflex+ Panel			0,5	≤ 10,0			
Slimflex	+/-50	+/-5	+/-1 +/-1,5	5 10				
Coil wrap	0/+5%	NA	NA					
Remark 3: Slatted panels which are not sawed have a tolerance on length and width +/-15mm								
block products	Thin Sheet	Not applicable if cut on size: +/- 2mm		0,25	≥ 1 tot 4	tape measure (1mm)	Thickness gauge deep throat(0,01mm)	
	Block sawed on size (remark 4)	+/-2	+/-2	0,5	4 - 10,0		caliper (0,1mm) or gauge meter (0,1mm)	
	Block (not sawed) (remark 4)	-2/+10	-2/+10		0,8			10,1 - 30,0
	Promalight sawed on size (remark 4)	+/-2	+/-2	1,5	30,1 - 50,0			
	Promalight (not sawed) (remark 4)	-2/+10	-2/+10	2	50,1 - 80,0			
			+/-1	all thicknesses				
Remark 4: if blocks are sealed off/shrinkwrapped, there is a addition tolerance of +/-1mm tolerances on squareness for each corner is max 5mm/m or 2,5mm/0,5m								
MPS	Tube diameter	Length 500 : -1/+10	ID: min as specified in existing articles	+2/-1	25	L: tape measure ID: tube	Convex thickness gauge (0,1mm)	
machined products	Sawn/Cut (not for rigid panels, exception VIP cores) see remark 2	not covered or sealed: +/- 2 mm see remarks below		Tolerances on thickness: see base article (+ see remark 5)		tape measure (1mm)	see base article	
	Milled: dimensions < 300mm	Not covered or sealed see remarks below		length/width - height/depth : +/- 0,5mm inside and outside diameter : +/-0,75mm		Caliper (0,01m) of 3D-measuring equipment (0,001)		
	Milled: dimensions ≥ 300mm	Not covered or sealed see remarks below		length/width - height/depth : +/- 1,0mm inside and outside diameter : +/-1,0mm		Tape measure (1mm) or ruler (0,5mm) if ≤1m		
	WaterJet block dimensions < 300mm	Not covered or sealed see remarks below		ID/OD-Length/Width: +/-0,75mm	Tolerances on thickness or height: see base article (+ see remark 5)		Caliper (0,01mm) or 3D measuring equipment	See base article
	WaterJet panel (rigid + flexible) Waterjet block dimensions ≥300mm	Not covered or sealed see remarks below		ID/OD-Length/Width: +/-1mm			tape measure (1mm) or metal ruler (0,5mm) if ≤1m	
	Lasered block dimensions < 300mm	Length/Width ID/OD not coated/sealed see remarks below		+/- 0,75 on upper side tolerance on opposite side can be up to +/- 3,25mm depending on the thickness	Tolerances on thickness or height: see base article (+ see remark 5)		Caliper (0,01mm) or 3D measuring equipment	
Lasered panel (rigid + flexible) Lasered block dimensions ≥ 300mm	+/- 1 on upper side tolerance on opposite side can be up to +/- 4mm depending on the thickness			tape measure (1mm) or metal ruler (0,5mm) if ≤1m				
Remark 5: if sawn, lasered, milled or items from the waterjet are covered or coated, an extra tolerance of +/-1mm is added. Remark 6: a tolerance of +/- 2 mm needs to be taken into account for lasered panels due to positioning error. Remark 7: If the distance between 2 holes or hole/edge of the panel is smaller than 10mm, no guarantee can be made for dimensions or isolation to be present. Remark 8: If the corner of a panel is smaller than 90° when lasered, sawn or cut on waterjet, insulation can not be guaranteed until the corner angle.								
Powder	Free Flow	Bigbag > 300kg		-5/+10kg		Balance (1kg)		
	Chimney Insulation	zak: 25kg or 15kg		+/- 0,5 kg		Balance (0,1kg)		

These are standard tolerances on endmeasurements. (Other tolerances can be applied when agreed upon.)

These tolerances are not applicable if panels are to be deformed.

Length and width of panels are measured between threads (thread not included).

Length and width of panels are measured with covering/sealing (if applied).

Thickness of panels are not measured on threads or on covered parts which have an overlap, unless specified on drawing or PO.

If article exists out of different base-items, the end-tolerance is those of the sum of the different tolerances.