



**METRIC PARALLELS**

Dimensions (mm)			UNITS 0.001mm			
			Grade B			
			Caliper measurements for individual parallels		Functional Requirements	
Thickness T	Width W	Length L	Departure from Nominal T & W	Variation in Caliper Measurements of T & W	Individual	Pairs
					Parallelism of T & W	Matching
5	10	100	±10	4	8	12
10	20	125	±10	4	8	12
15	30	150	±10	4	8	12
20	40	200	±10	4	8	12
25	50	250	±20	6	12	20
30	60	300	±20	6	12	20

**IMPERIAL PARALLELS**

Dimensions (inches)			UNITS 0.000 1inch			
			Grade B			
			Maximum Permissible Errors for Each Parallel			A pair of Parallels shall have equal Thickness (T)
Thickness T	Width W	Length L (Minimum)	Tolerance on T&W	Variations in T&W Not to Exceed	Error in Straightness within	
¼	½	4	±2.5	1	±1.0	1
⅜	¾	6	±2.5	1.5	±1.5	1.5
½	1	6	±2.5	1.5	±1.5	1.5
¾	1½	8	±4.0	2	±2.0	2
1	2	10	±4.0	2.5	±2.5	2.5
1¼	2½	10	±5.0	2.5	±2.5	2.5
1½	3	12	±5.0	3	±3.0	3