



Extrusion Tolerance Guide

The following tables state the standard tolerances for each type of tube that S&R manufacture in both **METRIC** & **IMPERIAL** measurements.

Tolerance Information Materials - PETG, PROPIONATE AND RPVC					
METRIC					
Thin and Medium Wall	OD ±	ID ±	Wall ±	Length ± (≤ 60")	Length ± (> 60")
4.78mm to 69.8mm	Ref.	0.08	0.08	1.57	3.18
>69.8mm to 98.4mm	Ref.	0.13	1.27	1.57	4.78
>98.4mm to 114mm	Ref.	0.20	0.20	3.18	6.35
>114mm	Ref.	0.30	0.20	3.18	12.70
Heavy Wall	OD ±	ID ±	Wall ±	Length ± (≤ 60")	Length ± (> 60")
4.78mm to 69.8mm	0.08	Ref.	0.08	1.57	3.18
>69.8mm to 98.4mm	0.13	Ref.	0.13	1.57	4.78
>98.4mm to 114mm	0.20	Ref.	0.20	3.18	6.35
>114mm	Ref.	0.30	0.20	3.18	12.70
Extra Heavy Wall	OD ±	ID ±	Wall ±	Length ± (≤ 72")	
9.53mm to 25.4mm	0.13	Ref.	0.13	3.18	
>25.4mm to 50.8mm	0.13	Ref.	0.13	6.35	
>50.8mm to 76.2mm	0.13	Ref.	0.13	6.35	

Tolerance Information Materials - PETG, PROPIONATE AND RPVC					
IMPERIAL					
Thin and Medium Wall	OD ±	ID ±	Wall ±	Length ± (≤ 60")	Length ± (> 60")
3/16" to 2-3/4"	Ref.	0.003	0.003	0.062	0.125
>2-3/4" to 3-7/8"	Ref.	0.005	0.05	0.062	0.188
>3-7/8" to 4-1/2"	Ref.	0.008	0.008	0.125	0.25
>4-1/2"	Ref.	0.012	0.008	0.125	0.5
Heavy Wall	OD ±	ID ±	Wall ±	Length ± (≤ 60")	Length ± (>60")
3/16" to 2-3/4"	0.003	Ref.	0.003	0.062	0.125
>2-3/4" to 3-7/8"	0.005	Ref.	0.005	0.062	0.188
>3-7/8" to 4-1/2"	0.008	Ref.	0.008	0.125	0.25
>4-1/2"	Ref.	0.012	0.008	0.125	0.5
Extra Heavy Wall	OD ±	ID ±	Wall ±	Length ± (≤ 72")	
3/8" to 1"	0.005	Ref.	0.005	0.125	
>1" to 2"	0.005	Ref.	0.005	0.25	
>2" to 3"	0.005	Ref.	0.005	0.25	