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**NATIONAL STANDARD OF THE
PEOPLE'S REPUBLIC OF CHINA**

GB/T 13914-2013

Replacing GB/T 13914-2002

Tolerance of dimensions for stamping parts

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Foreword

This Standard was drafted as per the rules specified in GB/T 1.1-2009. This Standard replaced GB/T 13914-2002 Tolerance of Dimensions for Stampings. Compared with GB/T 13914-2002, this Standard has the major technical changes as follows besides the editorial modifications:

- Add legends of blanking parts and stamping parts (see Figures 1 and 2 of this Edition);
- Add the basic size of
0.5 for blanking parts (see Table 1 of this Edition);
- Add the basic size of
0.5 for stamping parts (see Table 2 of this Edition);
- Modify the English translation of the standard name (see cover of this Edition; cover of 2002 Edition);
- Modify the limit deviation (see Clauses 1 and 4, 4.1, 4.2,
4.3 of this Edition; Clauses 1 and 4, 4.1, 4.2,
4.3 of 2002 Edition);
- Modify the English translation of nouns (see 2.1,
2.2 of this Edition;
2.2 of 2002 Edition);
- Modify the content of 3.3; and specify the expression method selected from this Standard (see

2 Terms and Definitions

For the purpose of this document, the following terms and definitions apply.

2.1 Blanking parts Stamping parts that are processed by plane blanking process.

2.2 Stamping parts Stamping parts that are processed by bending, deep drawing and other forming methods.

3 Dimensional Tolerance Grade, Code and Value of Stamping Parts 3.1 The dimensional tolerances of blanking parts are divided into 11 grades, namely: ST1 to ST11. ST represents the dimensional tolerance of blanking parts; while the code of tolerance grade is indicated by Arabic numerals. From ST1 to ST11, the grades gradually decrease. The dimensional tolerances of blanking parts are applicable to blanking parts, as well as the dimensions that are processed by the blanking process on the stamping parts. The dimensional tolerance values of blanking parts are specified in Table 1. See Figure 1 for the selection example of basic dimensions of B,

11 For example, when selecting the ST 6 tolerance grade of this Standard, it is expressed as: GB/T13914-ST 6; when selecting the FT 6 tolerance grade of this Standard, it is expressed as: GB/T13914-FT 6.

4 Dimensional Deviation of Stamping Parts 4.1 The deviation value of the hole (inner shape) size takes the tolerance value given in Tables 1 and 2; the upper deviation is prefixed with a "+" sign, and the lower deviation is "0".

4.2 The deviation value of the shaft (outer shape) size shall take the tolerance value given in Tables 1 and 2; the lower deviation is prefixed with "-" sign, and the upper deviation shall be "0".

4.3 The deviation values of the hole center distance, hole edge distance, bending, deep drawing and other stamping parts length, height and unmarked dimensional tolerances shall be taken as half of the tolerance values given in Tables 1 and 2; the upper and lower deviations are prefixed with "±" sign, respectively.

5 Selection of Tolerance Grade

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