

Sign blank tolerance chart

What our line holds, how each figure is measured, and what fails when it is missed. State the measuring method with the number, or the number will be argued about.

CHARACTERISTIC	WHAT WE HOLD	HOW IT IS MEASURED	WHAT GOES WRONG IF MISSED
Thickness	±0.10 mm up to 2.0 mm ±0.15 mm above 2.0 mm	Micrometer, 5 points per blank, bare metal	Film bubbles over high spots; blank rocks in the frame
Flatness	3 mm per running metre 1.5 mm on sorted lots	Straight edge on a flat table, panel relaxed 24 h	Visible ripple in grazing light; film lifts at the crown
Burr	≤0.10 mm, one side, no rolled edge	Profile projector or burr gauge at 3 edges	Film edge cannot seal; water enters in one season
Squareness	Diagonal difference ≤2 mm on 1200 × 800	Tape or laser, both diagonals	Channel mitres open; printed border runs out at the corner
Hole position	±0.5 mm from the stated datum	CMM or jig, datum = bottom-left corner	Fits in the workshop, does not fit on the road
Panel size	±1.0 mm on cut length and width	Steel rule, three positions per side	Frame will not close; post centres wrong on site

Six lines to put in the purchase order.

- Alloy with temper — 5052-H38, not "5052".
- Nominal thickness plus the tolerance band, and whether measured before or after film.
- Flatness over a defined length, on a flat table, before packing.
- Burr limit and which face carries the film.
- Datum for hole positions — one corner, not the panel centre.
- Inspection method, and who pays for a third-party check if it fails.

Figures describe our standard production run. Tighter is possible on a sorted lot at a sorting cost, quoted as a separate line. Looser is possible too, and sometimes correct: a bare blank that the buyer will coat is not improved by ±0.10 mm.