

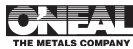
# THICKNESS TOLERANCES

## Cold Rolled Sheets in cut Lengths and Coils Stainless and Heat Resisting Steels

Specified Thickness, <sup>a</sup> in (mm)	Permissible Variations, Over and Under <sup>b</sup>	
	in	mm
0.005 (0.13)	0.001	0.03
Over 0.005 to 0.007 (0.13 to 0.18), incl.	0.0015	0.04
Over 0.007 to 0.016 (0.18 to 0.41), incl.	0.002	0.05
Over 0.016 to 0.026 (0.41 to 0.66), incl.	0.003	0.08
Over 0.026 to 0.040 (0.66 to 1.02), incl.	0.004	0.10
Over 0.040 to 0.058 (1.02 to 1.47), incl.	0.005	0.13
Over 0.058 to 0.072 (1.47 to 1.83), incl.	0.006	0.15
Over 0.072 to 0.083 (1.83 to 2.11), incl.	0.007	0.18
Over 0.083 to 0.098 (2.11 to 2.19), incl.	0.008	0.20
Over 0.098 to 0.114 (2.49 to 2.90), incl.	0.009	0.23
Over 0.114 to 0.130 (2.90 to 3.30), incl.	0.010	0.25
Over 0.130 to 0.145 (3.30 to 3.68), incl.	0.012	0.30
Over 0.145 to 3/16 (3.68 to 4.76), excl.	0.014	0.36

- a. Thickness measurements are taken at least 3/8 in (9.52 mm) from the edge of the sheet.
- b. Cold rolled sheets in cut lengths and coils are produced in some type numbers and some widths and thicknesses to tolerances less than those shown in the table.
- c. The tolerances shown are based on ASTM A480.

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## WIDTH TOLERANCES

Hot Rolled Sheets and Cold Rolled Sheets  
Not Resquared  
And Cold Rolled Sheets in Coils  
Stainless and Heat Resisting Steels

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Tolerances, in (mm) for Specified Width		
Specified Thickness, in (mm)	24 to 48 (610 to 1,219), excl.	48 (1,219) and Over
All thicknesses	1/16 (1.59) over, 0 under	1/8 (3.8) over, 0 under

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NOTE: Tolerances shown are based on ASTM A480.

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## CAMBER TOLERANCES

Hot Rolled Sheets and Cold Rolled Sheets  
Not Resquared  
and Cold Rolled Sheets in Coils  
Stainless and Heat Resisting Steels  
(ASTM A480)

Camber is the greatest deviation of a side edge from a straight line, and measurement is taken by placing an 8 ft. (2,438 mm) straight edge on the concave side and measuring the greatest distance between the sheet edge and the straight edge.

Specified Width, In (mm)	Tolerance, in (mm) per Unit Length of 8 ft (2,438 mm)
24 to 36 (610 to 914), incl.	1/8 (3.18)
Over 36 (914)	3/32 (2.38)

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## LENGTH TOLERANCES

Hot Rolled Sheets and Cold Rolled Sheets  
Not Resquared  
Stainless and Heat Resisting Steels  
(ASTM A480)

Length, in (mm)	Tolerance, in (mm)
Up to 120 (3,048), incl.	1/4 (6.35) over, 0 under
Over 120 to 240 (3,048 to 6,096)	1/2 (12.70) over, 0 under

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## FLATNESS TOLERANCES

Hot Rolled Sheets and Cold Rolled Sheets,  
Specified to Stretcher  
Leveled Standard of Flatness, Not including Hard  
Tempers of 2xx and 3xx series  
Stainless and Heat Resisting Steels

Specified Thickness, in (mm)	Width, in (mm)	Length, in (mm)	Flatness Tolerance, <sup>a</sup> in (mm)
All	To 48 (1,219), incl.	To 96 (2,438), incl.	1/8 (3.18)
All	To 48 (1,219), incl.	Over 96 (2,438)	1/4 (6.35)
All	Over 48 (1,219)	To 96 (2,438), incl.	1/4 (6.35)
All	Over 48 (1,219)	Over 96 (2,438)	1/4 (6.35)

a. Maximum deviation from a horizontal flat surface.

NOTE: Tolerances shown are based on ASTM A480.

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## FLATNESS TOLERANCES

**Hot Rolled Sheets and Cold Rolled Sheets,  
Not Specified to Stretcher Leveled Standard  
of Flatness,  
Not Including Hard Tempers of 2xx and 3xx Series,  
Dead Soft Sheets and Deep Drawing Sheets  
Stainless and Heat Resisting Steels  
(ASTM A480)**

Specified Thickness, in (mm)	Width, in (mm)	Flatness Tolerance, <sup>a</sup> in (mm)
Under 0.062 (1.57)  incl.	To 36 (914), incl.	1/2 (12.70)
	Over 36 to 60 (914 to 1,524),	3/4 (19.05)
	Over 60 (1,564)	1 (25.40)
0.062 (1.57) and over	To 60 (1,524), incl.	1/2 (12.70)
	Over 60 to 72 (1,524 to 1,829), incl.	3/4 (19.05)

- a. Maximum deviation from a horizontal flat surface.

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## RECOMMENDED MACHINING ALLOWANCES FLAME CUT PLATES

Including Circles, Rings and Sketched  
Stainless and Heat Resisting Steels  
(ASTM A480)

Specified Thickness, in (mm)	Machining Allowance per Edge, in (mm)
2 (51) and under	1/4 (6.35)
Over 2 to 3 (51 to 76), incl.	3/8 (9.52)
Over 3 to 6 (76 to 152), incl.	1/2 (12.70)

NOTE: The above minimum recommended machining allowances are to be added by the purchaser to each edge on all flame cut plates.

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