

Thickness Tolerance Coil

Tolerances below are for coil product, applies to the following alloys:
(253, 330, 333, 304, 309, 316, 321, 347, 410, 446, 2205, 2507, 2101, 17-4, 17-5, 800)
Tolerances listed were taken from ASTM A480
(Reference Only)

Hot Rolled Sheet / Coil

Table A2.13 Permitted Variations in Thickness of Hot-Rolled, Wide, Coil-Processed Product as Coil and Cut Lengths

Specified Thickness*, in. [mm]	Permitted Variation, in. [mm], Over and Under, Except as Indicated Otherwise, for Specified Width (w) in. [mm]	
	w ≤ 60 [1525]	w > 60 [1525]
0.072 [1.83]	0.006 [0.15]	0.009 [0.22]
>0.072 [1.83] to 0.083 [2.11]	0.007 [0.18]	0.010 [0.25]
>0.083 [2.11] to 0.098 [2.49]	0.008 [0.20]	0.011 [0.27]
>0.098[2.49] to 0.114 [2.90]	0.009 [0.23]	0.012 [0.30]
>0.114 [2.90] to 0.130 [3.30]	0.011 [0.27]	0.013 [0.33]
>0.130 [3.30] to 0.145 [3.68]	0.012 [0.30]	0.013 [0.33]
>0.145 [3.68] to 0.1875 [4.76]	0.013 [0.33]	0.014 [0.35]
>0.1875 [4.76] to 0.250 [6.35]	-0.010 [0.25], +0.020 [0.50]	-0.010 [0.25], +0.020 [0.50]
>0.250 [6.35] to 0.3125 [7.94]	-0.010 [0.25], +0.022 [0.55]	-0.010 [0.25], +0.022 [0.55]
>0.3125 [7.94]	-0.010 [0.25], +0.030 [0.75]	-0.010 [0.25], +0.030 [0.75]

*Thickness measurements are taken at least 3/8 in. [9.52mm] from the edge of the sheet.

Cold Rolled Sheet / Coil

Table A2.1 Permitted Variations in Thickness for Cold-Rolled, Narrow, Coil-Processed Product as Coils and Cut Lengths

Note 1 — Thickness measurements are taken at least 3/8 in. [9.52mm] in from the edge of the product, except on widths less than 1 in. [25.4mm] the measurements should be taken at least 1/8 in. [3.18mm] from the product edge.

Note 2 — The tolerances in this table include crown tolerances

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Thickness Tolerances, for the Thickness and Widths Given, Over and Under, in. [mm]			
Width (w), in. [mm]			
Specified Thickness, in. [mm]	3/16 [4.76] to 6 [152], incl w ≤ 6 [152]	Over 6 [152] to 12 [305], incl 6 [152] < w ≤ 12 [305]	Over 12 [305] to 24 [610], excl 12 [305] < w ≤ 24 [610]
Thickness Tolerances *			
0.002 [0.05] to 0.005 [0.13], excl	10%	10%	10%
0.005 [0.13] to 0.010 [0.25], incl	0.0006 [0.015]	0.0008 [0.020]	0.001 [0.025]
Over 0.010 [0.25] to 0.012 [0.30], incl	0.001 [0.025]	0.001 [0.025]	0.001 [0.025]
Over 0.012 [0.30] to 0.015 [0.40], incl	0.001 [0.025]	0.0015 [0.04]	0.0015 [0.04]
Over 0.015 [0.40] to 0.020 [0.50], incl	0.001 [0.025]	0.0015 [0.04]	0.0015 [0.04]
Over 0.020 [0.50] to 0.029 [0.74], incl	0.0015 [0.04]	0.0015 [0.04]	0.002 [0.050]
Over 0.029 [0.74] to 0.035 [0.89], incl	0.0015 [0.04]	0.002 [0.050]	0.002 [0.050]
Over 0.035 [0.89] to 0.050 [1.27], incl	0.0025 [0.060]	0.003 [0.070]	0.003 [0.070]
Over 0.050 [1.27] to 0.069 [1.75], incl	0.003 [0.070]	0.003 [0.070]	0.003 [0.070]
Over 0.069 [1.75] to 0.100 [2.54], incl	0.003 [0.070]	0.003 [0.070]	0.004 [0.10]
Over 0.100 [2.54] to 0.125 [2.98], incl	0.004 [0.10]	0.004 [0.10]	0.005 [0.12]
Over 0.125 [2.98] to 0.161 [4.09], incl	0.005 [0.12]	0.005 [0.12]	0.005 [0.12]
Over 0.161 [4.09] to under 3/16 [4.76]	0.005 [0.12]	0.005 [0.12]	0.006 [0.15]

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* Thickness tolerances given in in. [mm] unless otherwise indicated.

Table A2.2 Permitted Variations in Width for Cold-Rolled, Narrow, Coil-Processed Product as Coils and Cut Lengths for Edge No. 3*

Specified Thickness**			
in. [mm]	$w \leq 1.6$ [40]	1.60 [40] $< w \leq 6$ [160]	6 [150] $< w \leq 12$ [305]
0.010 [0.25]	0.003 [0.085]	0.004 [0.10]	0.005 [0.125]
0.020 [0.50]	0.005 [0.125]	0.005 [0.125]	0.010 [0.25]
0.040 [1.00]	0.005 [0.125]	0.005 [0.125]	0.010 [0.25]
0.060 [1.50]	0.005 [0.125]	0.006 [0.15]	0.010 [0.25]
0.100 [2.50]	--	0.010 [0.25]	0.016 [0.40]
0.120 [3.00]	--	0.010 [0.25]	0.016 [0.40]
0.160 [4.00]	--	0.016 [0.40]	0.016 [0.40]
0.200 [4.99]	--	0.030 [0.80]	0.030 [0.80]