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**Continuously cold-rolled steel sheet  
products — Dimensional and shape  
tolerances**

*Tôles en acier laminées à froid en continu — Tolérances  
sur dimensions et forme*

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## Foreword

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International Standards are drafted in accordance with the rules given in the ISO/IEC Directives, Part 2.

The main task of technical committees is to prepare International Standards. Draft International Standards adopted by the technical committees are circulated to the member bodies for voting. Publication as an International Standard requires approval by at least 75 % of the member bodies casting a vote.

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. ISO shall not be held responsible for identifying any or all such patent rights.

ISO 16162 was prepared by Technical Committee ISO/TC 17, *Steel*, Subcommittee SC 12, *Continuous mill flat rolled products*.

This third edition cancels and replaces the second edition (ISO 16162:2005), which has been technically revised.

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# Continuously cold-rolled steel sheet products — Dimensional and shape tolerances

## 1 Scope

This International Standard applies to dimensional and shape tolerances for all continuously cold-rolled steel sheet products.

Note Cold-rolled steel strip is not covered by this International Standard.

## 2 Dimensional tolerances

Dimensional tolerances are given in Tables 1 to 9.

**Table 1 — Normal thickness tolerances for coils and cut lengths**

Dimensions and tolerances in millimetres

Specified width	Thickness tolerances for specified thicknesses <sup>a,b,c</sup>									
	≤0,4	> 0,4 ≤0,6	> 0,6 ≤0,8	> 0,8 ≤1,0	> 1,0 ≤1,2	> 1,2 ≤1,6	> 1,6 ≤2,0	> 2,0 ≤2,5	> 2,5 ≤3,0	> 3,0 ≤4,0
600 ≤1 200	±0,04	±0,05	±0,07	±0,08	±0,09	±0,11	±0,13	±0,15	±0,18	±0,20
> 1 200 ≤1 500	±0,05	±0,06	±0,08	±0,09	±0,10	±0,12	±0,14	±0,16	±0,19	±0,21
> 1 500 ≤1 800	—	±0,08	±0,09	±0,10	±0,12	±0,14	±0,16	±0,18	±0,21	±0,23

When International Standards that reference this standard permit sheet that is slit to less than 600 mm in width to be considered as sheet, tolerances shall be subject to agreement.

<sup>a</sup> The thickness tolerances for sheet in coil form are the same as for sheet supplied in cut lengths but, in cases where welds are present, the tolerances shall be double those given over a length of 15 m in the vicinity of the weld.

<sup>b</sup> For specified strength levels of  $R_e = 360$  MPa and greater, increase the thickness tolerances by 10 %, applying normal rounding-off procedures.

<sup>c</sup> Thickness is measured at any point on the sheet not less than 25 mm from a side edge.

**Table 2 — Restricted thickness tolerances for coils and cut lengths**

Dimensions and tolerances in millimetres

Specified width	Thickness tolerances for specified thicknesses <sup>a,b,c</sup>									
	≤0,4	> 0,4 ≤0,6	> 0,6 ≤0,8	> 0,8 ≤1,0	> 1,0 ≤1,2	> 1,2 ≤1,6	> 1,6 ≤2,0	> 2,0 ≤2,5	> 2,5 ≤3,0	> 3,0 ≤4,0
600 ≤1 200	±0,025	±0,035	±0,04	±0,045	±0,055	±0,07	±0,08	±0,10	±0,11	±0,12
> 1 200 ≤1 500	±0,035	±0,045	±0,05	±0,06	±0,07	±0,08	±0,09	±0,11	±0,12	±0,13
> 1 500 ≤1 800	—	±0,05	±0,05	±0,06	±0,07	±0,08	±0,09	±0,11	±0,12	±0,13

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<sup>c</sup> Thickness is measured at any point on the sheet not less than 25 mm from a side edge.

**Table 3 — Width tolerances for coils and cut lengths, not resquared**

Dimensions and tolerances in millimetres

Specified width	Tolerance
≤1 200	+3 0
> 1 200 ≤1 500	+5 0
> 1 500	+6 0

NOTE For resquared material, more restrictive tolerances are subject to negotiation.

**Table 4 — Length tolerances for cut lengths, not resquared**

Dimensions and tolerances in millimetres

Specified width	Tolerance
≤2 000	+10 0
> 2 000 ≤8 000	+0,5 % × length 0
> 8 000	+40 0

NOTE For resquared material, more restrictive tolerances are subject to negotiation.

**Table 5 — Camber tolerances for coils and cut lengths, not resquared**

Dimensions and tolerances in millimetres

Form	Camber tolerance
Coils	20 in any 5 000 length
Cut lengths	0,4 % × length

NOTE Camber is the greatest deviation of a side edge from a straight line, the measurement being taken on the concave side with a straight edge as shown in Figure 1. For resquared material, more restrictive tolerances are subject to negotiation.

Table 6 — Out-of-square tolerance for cut lengths, not resquared

Dimensions	Out-of-square tolerance
All thicknesses and all sizes	1 % × width
NOTE Out-of-square is the greatest deviation of an end edge from a straight line at right angles to a side and touching one corner as shown in Figure 2. It can also be measured as one-half the difference between the diagonals of the cut length of sheet.	

Table 7 — Out-of-square tolerances for resquared material

Dimensions and tolerances in millimetres

Specified length	Specified width	Out-of-square tolerance
≤ 3 000	≤ 1 200	+2 0
	> 1 200	+3 0
> 3 000	All widths	+3 0
NOTE Out-of-square is the greatest deviation of an end edge from a straight line at right angles to a side and touching one corner as shown in Figure 2. It can also be measured as one-half the difference between the diagonals of the cut length of sheet. When measuring material to resquared tolerances, consideration might have to be given to extreme variations in temperature.		

Table 8 — Standard flatness tolerances for cut lengths

Dimensions and tolerances in millimetres

Specified thickness	Specified width	Flatness tolerance specified strength level of $R_e$		
		< 220 MPa	≥ 220 ≤ 340 MPa	> 340 MPa
≤ 0,7	≤ 1 200	12	15	18
	> 1 200 ≤ 1 500	15	18	21
	> 1 500	19	22	27
> 0,7 ≤ 1, 2	≤ 1 200	10	13	16
	> 1 200 ≤ 1 500	12	15	19
	> 1 500	17	20	25
> 1,2	≤ 1 200	10	10	16
	> 1 200 ≤ 1 500	12	13	19
	> 1 500	17	19	25
NOTE This table does not apply to full hard sheet (CH550).				
Maximum deviation from a flat horizontal surface: with the sheet lying under its own weight the maximum distance between the lower surface of the sheet and the flat horizontal surface (maximum deviation from flatness), as shown in Figure 3. This table also applies to sheet cut to length from coil by the customer when agreed-upon flattening procedures are performed.				

**Table 9 — Restricted flatness tolerances for cut lengths**

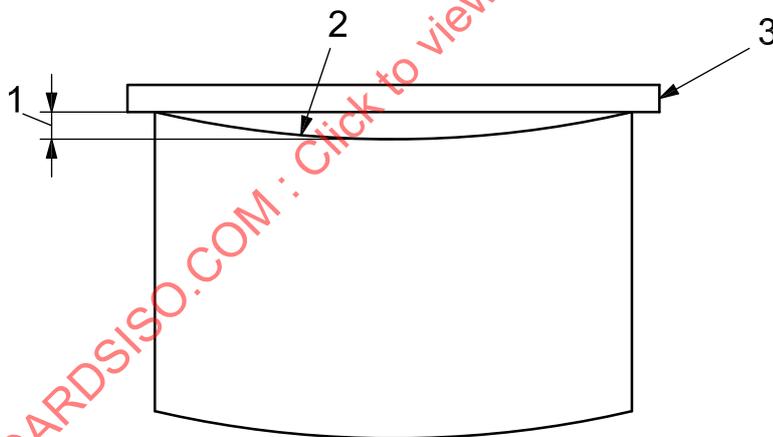
Dimensions and tolerances in millimetres

Specified thickness	Specified width	Flatness tolerance specified strength level of $R_e$		
		< 220 MPa	$\geq 220 \leq 340$ MPa	> 340 MPa
$\leq 0,7$	$\leq 1\ 200$	5	8	—
	$> 1\ 200 \leq 1\ 500$	6	9	—
	$> 1\ 500$	8	12	—
$> 0,7 \leq 1, 2$	$\leq 1\ 200$	4	6	—
	$> 1\ 200 \leq 1\ 500$	5	8	—
	$> 1\ 500$	7	10	—
$> 1,2$	$\leq 1\ 200$	4	5	—
	$> 1\ 200 \leq 1\ 500$	5	6	—
	$> 1\ 500$	6	9	—

NOTE This table does not apply to full hard sheet (CH550).

Maximum deviation from a flat horizontal surface: with the sheet lying under its own weight the maximum distance between the lower surface of the sheet and the flat horizontal surface (maximum deviation from flatness), as shown in Figure 3. This table also applies to sheet cut to length from coil by the customer when agreed-upon flattening procedures are performed.

More restrictive tolerances may be negotiated.



**Key**

- 1 edge camber
- 2 side edge (concave side)
- 3 straight edge

**Figure 1 — Measurement of camber**