
International Standard



7756

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Wrought copper and copper alloys — Drawn round bars — Symmetric plus and minus tolerances on diameter and form tolerances

Cuivre et alliages de cuivre corroyés — Barres étirées de section circulaire — Tolérances en plus et en moins symétriques sur diamètres et tolérances de forme

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Descriptors : copper, copper alloys, drawn products, metal bars, round bars, dimensions, dimensional tolerances, form tolerances.

Foreword

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Draft International Standards adopted by the technical committees are circulated to the member bodies for approval before their acceptance as International Standards by the ISO Council. They are approved in accordance with ISO procedures requiring at least 75 % approval by the member bodies voting.

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Wrought copper and copper alloys — Drawn round bars — Symmetric plus and minus tolerances on diameter and form tolerances

1 Scope and field of application

This International Standard specifies the symmetric plus and minus tolerances on diameter in the range from 2 up to and including 80 mm and the form tolerances for wrought copper and copper alloy drawn round bars.

2 Reference

ISO 1637, *Wrought copper and copper alloys — Solid products supplied in straight lengths — Mechanical properties.*¹⁾

3 Definition

For the purpose of this International Standard, the following definition applies.

circularity: The difference between the maximum and minimum diameters measured on one cross-section.

4 Dimensions and tolerances

4.1 Diameter

Table 1 — Tolerances on diameter

Values in millimetres

Diameter		Tolerance	
>	<	Material group I	Material groups II and III
≥ 2	3	± 0,03	± 0,05
3	6	± 0,04	± 0,05
6	10	± 0,04	± 0,05
10	18	± 0,05	± 0,06
18	30	± 0,05	± 0,08
30	50	± 0,06	± 0,10
50	80	± 0,15	± 0,20

4.2 Circularity

The deviation from circularity shall not exceed half the tolerance on diameter specified in table 1.

1) Under revision.

4.3 Straightness tolerances

4.3.1 Straightness tolerances apply for drawn bars with diameter equal to or greater than 10 mm for all tempers, except the annealed.

Straightness tolerances for copper and copper alloy bars, except free-machining materials, are given in table 2.

Table 2 – Straightness tolerances (excluding free-machining materials)

Values in millimetres

Nominal length l_{nom}		Maximum curvature (Depth of arc)
>	<	
≥ 1 000	2 000	2,0 in any length $l_m = 1\ 000$
2 000	3 000	5,5 in any length $l_m = 2\ 000$
3 000	—	12,0 in any length $l_m = 3\ 000$
Local kinks		0,6 in any length $l_m = 300$

Straightness tolerances for free-machining materials (listed in table 6, material group I), are given in table 3.

Table 3 – Straightness tolerances for free-machining materials

Values in millimetres

Nominal length l_{nom}		Maximum curvature (Depth of arc)
>	<	
≥ 1 000	2 000	1,0 in any length $l_m = 1\ 000$
2 000	3 000	3,0 in any length $l_m = 2\ 000$
3 000	—	7,0 in any length $l_m = 3\ 000$
Local kinks		0,4 in any length $l_m = 300$

4.3.2 The straightness is measured by determining the curvature c against a straightedge, having the appropriate length l_m , when the bar is lying flat on a base plate (see the figure).

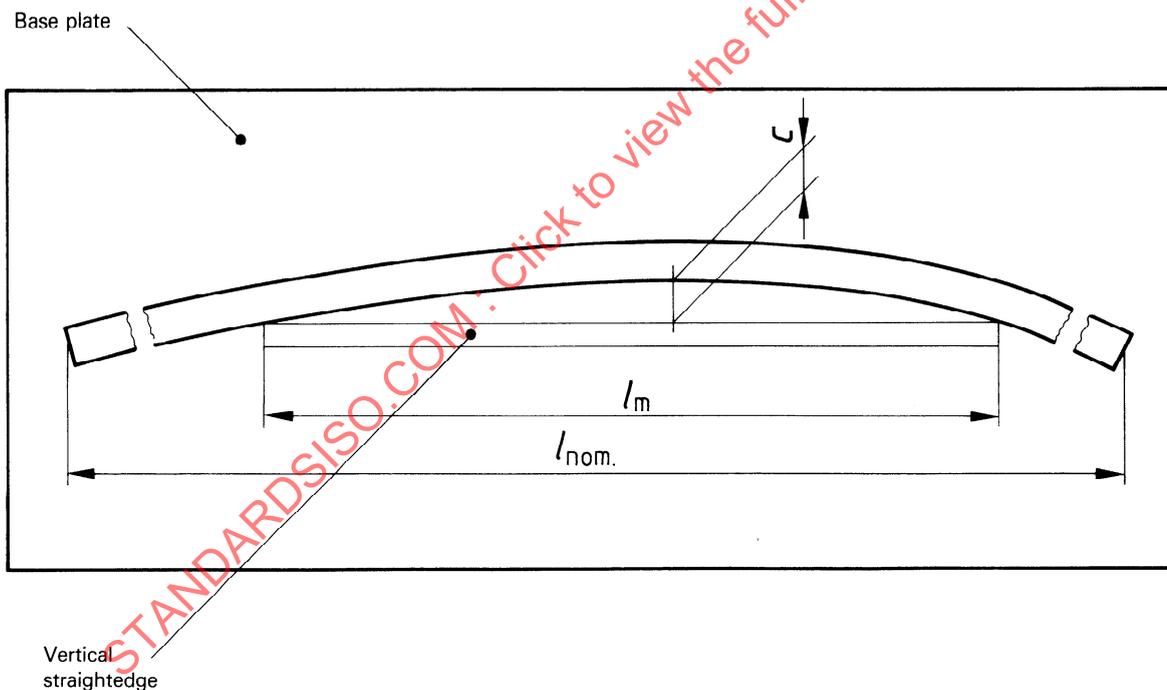


Figure – Measurement of straightness

4.4 Length tolerance

4.4.1 Length as manufactured

For length as manufactured, the tolerances in table 4 apply; permissible underlengths are given in table 5.

Table 4 — Length as manufactured

Values in millimetres

Diameter		Nominal length	Tolerance
>	<		
≥ 2	3	max. 3 000	± 50
3	25	3 000 to 4 000	
25	40	2 000 to 4 000	± 100
40	50		
50	60	2 000 to 3 000	± 200
60	80	1 000 to 2 000	

Table 5 — Permissible underlength

Diameter mm		Shortest permissible length % of nominal length	Permissible mass of underlengths in % of lot mass
>	<		
≥ 2	25	75	20
25	50	50	40
50	80		50

4.4.2 Fixed length

The length of fixed lengths shall be agreed upon between the purchaser and supplier. Fixed lengths have a tolerance of + 10 mm.
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5 Materials

Drawn round bars according to this International Standard are currently available in commercial quantities in wrought copper and copper alloys listed in table 6.

The mechanical properties of the materials listed are specified in ISO 1637.

The materials are divided into material groups I, II and III as classified in table 6.

Table 6 — Materials

Material group	Type	Designation
I	Coppers (Cu min. 99,85 %)	Cu-ETP Cu-FRHC Cu-FRTP Cu-OF Cu-HCP Cu-DLP Cu-DHP
	Copper-zinc alloys	CuZn37 CuZn40
	Coppers (Cu min. 97,5 %)	CuAg 0,05 CuAg 0,1 CuAg 0,05 (OF) CuAg 0,1 (OF) CuAg 0,05 (P) CuAg 0,1 (P) CuCd 1
		CuS (P0, 01) CuS (P0, 03) CuTe CuTe (P)
	Copper-zinc-lead alloys	CuZn34Pb2 CuZn36Pb3 CuZn40Pb CuZn39Pb1 CuZn38Pb2 CuZn40Pb2 CuZn39Pb3 CuZn38Pb4
II	Coppers (Cu min. 97,5 %)	CuCr1 CuCr1Zr
	Special copper-zinc alloys	CuZn37Sn1Pb1 CuZn38Sn1 CuZn39AlFeMn
	Copper-tin alloys	CuSn5 CuSn6 CuSn8
	Copper-nickel alloys	CuNi30Mn1Fe
	Copper-nickel-zinc alloys	CuNi18Zn19Pb1 CuNi10Zn28Pb1
III	Copper-aluminium alloys	CuAl7Si2 CuAl8Fe3 CuAl9Mn2 CuAl10Fe3 CuAl10Ni5Fe4
	Special copper alloys	CuBe2 CuBe2Pb CuCo2Be CuNi2Be CuNi1Si CuNi2Si CuSi1 CuSi3Mn1

Freemachining material

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