
International Standard



7757

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Wrought copper and copper alloys — Drawn hexagonal bars — Symmetric plus and minus tolerances on width across flats and form tolerances

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

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Descriptors : copper, copper alloys, drawn products, metal bars, hexagonal bars, width across flats, form tolerances, dimensions, dimensional 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 hexagonal bars — Symmetric plus and minus tolerances on width across flats and form tolerances

1 Scope and field of application

This International Standard specifies the symmetric plus and minus tolerances on width across flats in the range from 3 up to and including 60 mm and the form tolerances for wrought copper and copper alloy drawn hexagonal bars.

2 References

ISO 272, *Fasteners — Hexagon products — Widths across flats.*

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

3 Dimensions and tolerances

3.1 Width across flats

Nominal dimensions shall be selected from ISO 272, and the tolerances specified in table 1 applied.

Table 1 — Tolerances on width across flats

Values in millimetres

Width across flats		Tolerance	
>	<	Material group I	Material groups II and III
≥ 3	6	± 0,07	± 0,11
6	10	± 0,08	± 0,12
10	18	± 0,09	± 0,13
18	30	± 0,10	± 0,14
30	50	± 0,13	± 0,18
50	60	± 0,20	± 0,30

3.2 Corner radii

Hexagonal bars may have rounded corners with corner radii according to table 2.

Table 2 — Corner radii

Values in millimetres

Width across flats		Maximum corner radius
>	<	
≥ 3	6	0,6
6	10	0,8
10	18	1,2
18	30	1,8
30	50	2,8
50	60	4,0

3.3 Twist tolerance

The twist tolerance for hexagonal bars with widths across flats in the range from 18 up to and including 60 mm is 3° per metre and 5° per total length, for the nominal lengths up to 3 000 mm; over 3 000 mm nominal lengths, the tolerance shall be agreed.

3.4 Straightness tolerances

3.4.1 Straightness tolerances apply for drawn bars with widths across flats 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 3.

1) Under revision.

Table 3 — Straightness tolerances (excluding freemachining materials)

Values in millimetres

Nominal length		Maximum curvature (Depth of arc)
>	<	
> 1 000	2 000	2,0 in any 1 000 mm portion
2 000	3 000	5,5 in any 2 000 mm portion
3 000	—	12,0 in any 3 000 mm portion
Local kinks		0,6 in any 300 mm portion

Straightness tolerances for freemachining materials (listed in table 7, Material group I), are given in table 4.

Table 4 — Straightness tolerances for freemachining materials

Values in millimetres

Nominal length		Maximum curvature (Depth of arc)
>	<	
> 1 000	2 000	2,0 in any 1 000 mm portion
2 000	3 000	4,5 in any 2 000 mm portion
3 000	—	10,0 in any 3 000 mm portion
Local kinks		0,6 in any 300 mm portion

3.4.2 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).

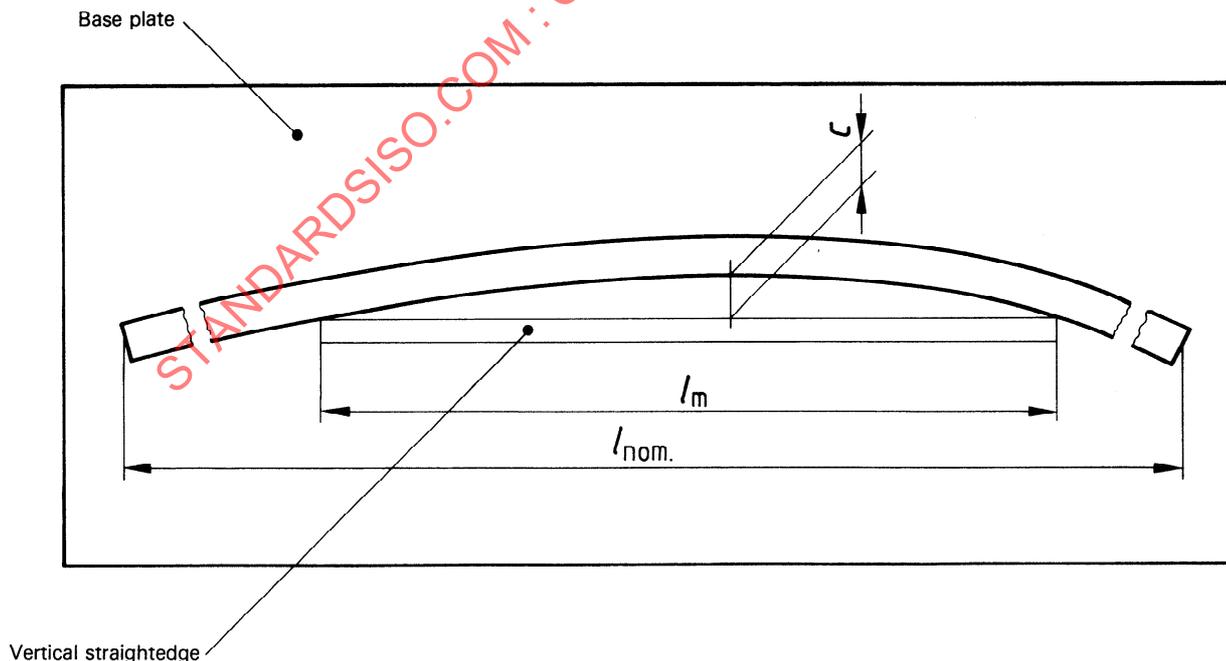


Figure — Measurement of straightness

3.5 Length tolerance

3.5.1 Length as manufactured

For length as manufactured, the tolerances in table 5 apply; permissible underlengths are listed in table 6.

Table 5 — Length as manufactured

Values in millimetres

Width across flats		Nominal length	Tolerance
>	<		
> 3	18	3 000 to 4 000	± 50
18	40		± 100
40	50	2 000 to 4 000	± 200
50	60	2 000 to 3 000	

Table 6 — Permissible underlength

Width across flats		Shortest permissible length % of nominal length	Permissible mass of underlengths % of lot mass
>	mm <		
> 3	18	75	20
18	50	50	40
50	60		50

3.5.2 Fixed length

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

Drawn hexagonal bars according to this International Standard are currently available in commercial quantities in wrought copper and copper alloys listed in table 7.

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 7.

Table 7 — 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
	Copper-zinc-lead alloys	CuS (P0, 01) CuS (P0, 03) CuTe CuTe (P)
		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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