

# AEROSPACE MATERIAL SPECIFICATION

AMS 2244B

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Superseding AMS 2244A

Submitted for recognition as an American National Standard

## TOLERANCES Titanium and Titanium Alloy Tubing

1. **SCOPE:** This specification covers established inch/pound manufacturing tolerances applicable to titanium and titanium alloy tubing ordered to inch/pound dimensions. These tolerances apply to all conditions, unless otherwise noted. The term "excl" is used to apply only to the higher figure of the specified range.
  2. **DIAMETER:** When specified, OD tolerances shall apply to the ID but not to both ID and OD of the same lot of tubing. Mean OD is the average of two measurements taken at right angles to each other. Diameter tolerances include ovality except for tubing having specified wall thickness less than 4% of the specified OD; for tubing with specified wall thickness less than 4% of the specified OD, the ovality tolerance shall be double the diameter tolerance.
- 2.1 Seamless, Cold Reduced, Annealed or Stress Relieved:

TABLE I

Specified OD Inches	Standard Tolerance Inch Plus and minus	Special Tolerance Inch Plus only
Up to 0.093, excl	0.002	0.002
0.093 to 0.188, excl	0.003	0.003
0.188 to 0.500, excl	0.004	0.004
0.500 to 1.000, excl	0.005	0.005
1.000 to 1.500, excl	0.006	0.006
1.500 to 2.000, excl	0.007	0.007
2.000 to 3.000, excl	0.010	0.010
3.000 to 4.500, excl	0.015	0.015

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