

Submitted for recognition as an American National Standard

Tolerances, Metric
Corrosion and Heat Resistant Steel, Iron Alloy,
Titanium, and Titanium Alloy Bars and Wire

1. SCOPE:

This specification covers established metric manufacturing tolerances applicable to corrosion and heat resistant steel, iron alloy, titanium, and titanium alloy bars and wire ordered to metric 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.

1.1 AMS 2241 is the inch/pound version of this MAM.

2. DIAMETER, THICKNESS, AND WIDTH:

2.1 Cold Finished Bars:

2.1.1 Rounds, Squares, Hexagons, and Octagons (See 2.1.3): See Table 1.

TABLE 1 - Diameter or Thickness Tolerances

Specified Diameter or Thickness Millimeters	Tolerance, Millimeter Plus and Minus (See 2.1.1.1) Rounds	Tolerance, Millimeter Minus Only (See 2.1.1.2) Squares, Hexagons, and Octagons
Over 12.50 to 25.00, excl 25.00	0.05 0.062	0.10 0.10
Over 25.00 to 37.50, excl 37.50 to 50.00, incl	0.026 0.08	0.15 0.15
Over 50.00 to 75.00, incl	0.08	0.20
Over 75.00 to 100.00, incl	0.08	0.25

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- 2.1.1.1 Size tolerances for round bars are plus and minus as shown in Table 1. When required, however, they may be specified all plus and nothing minus, or all minus and nothing plus, or any combination of plus and minus, if the total spread in size tolerance for a specified size is not less than the total spread shown in Table 1.
- 2.1.1.2 For titanium and titanium alloys, the difference among the three measurements of the distance between opposite faces of hexagons shall be not greater than one-half the size tolerance and the difference among the measurements of the distance between opposite faces of octagons shall be not greater than the size tolerance.
- 2.1.2 Flats (See 2.1.3): See Table 2.

TABLE 2 - Thickness and Width Tolerances

Specified Width Millimeters	Thickness Tolerance, Millimeter Plus and Minus	Width Tolerance, Millimeter Plus and Minus
3.00 to 6.00, incl	0.05	0.10
Over 6.00 to 25.00, incl	0.05	0.05
Over 25.00 to 50.00, incl	0.08	0.08
Over 50.00 to 75.00, incl	0.10	0.10
Over 75.00 to 115.00, incl	0.12	0.12

- 2.1.3 If cold finished bars are ordered heat treated or heat treated and pickled after cold finishing, tolerances shall be double those of Table 1 and Table 2.
- 2.2 Cold Finished Wire:
- 2.2.1 Rounds, Squares, Hexagons, and Octagons (See 2.2.1.1): See Table 3.

TABLE 3 - Diameter of Thickness Tolerances

Specified Diameter or Thickness Millimeters	Tolerance, Millimeters Plus and Minus Rounds and Squares	Tolerance, Millimeter Minus Only (See 2.2.1.3)
		Hexagons and Octagons
0.08 to 0.12, excl	0.002	-
0.12 to 0.20, excl	0.005	-
0.20 to 0.30, excl	0.008	-
0.30 to 0.60, excl	0.010 (See 2.2.1.2)	-
0.60 to 0.85, excl	0.012 (See 2.2.1.2)	-
0.85 to 1.10, excl	0.020	-
1.10 to 3.15, excl	0.02	-
3.15 to 7.80, excl	0.02	0.05
7.80 to 12.50, excl	0.038	0.08
12.50	0.05	0.10

2.2.1.1 If cold finished wire is ordered heat treated or heat treated and pickled after cold finishing, tolerances shall be double those of Table 3 for nominal sizes 0.60 millimeters and over.

2.2.1.2 For titanium and titanium alloys, tolerances for these sizes are ± 0.019 millimeter.

2.2.1.3 For titanium and titanium alloys, the difference among the three measurements of the distance between opposite faces of hexagons shall be not greater than one-half the size tolerance and the difference among the four measurements of the distance between opposite faces of octagons shall be not greater than one-half the size tolerance.

2.2.1.4 Out-of-Round: Round wire shall not be out-of-round by more than one-half of the total tolerance shown in Table 3.

2.2.2 Flats: See Table 4.

TABLE 4 - Thickness Tolerances

Specified Thickness Millimeters	Tolerance, Millimeter Plus and Minus
Up to 0.70, excl	0.02
0.70 to 0.90, excl	0.038
0.90 to 4.75, excl	0.04

2.2.2.1 Width tolerances shall be ± 0.12 millimeter for specified widths 1.56 to 9.38 millimeters, exclusive.

2.3 Hot Finished Bars:

2.3.1 Hot Rolled:

2.3.1.1 Rounds and Squares: See Table 5. Out-of-round is the difference between the maximum and minimum diameters of the bar, measured at the same cross section. Out-of-square is the difference in the two dimensions at the same cross section of a square bar, each dimension being the distance between opposite faces.

TABLE 5 - Diameter or Thickness Tolerances

Specified Diameter or Thickness Millimeters	Tolerance Millimeters Plus	Tolerance Millimeter Minus	Out-of-Round or Out-of-Square Millimeters
6.25 to 7.80, incl	0.12	0.12	0.20
Over 7.80 to 11.00, incl	0.15	0.15	0.22
Over 11.00 to 15.75, incl	0.18	0.18	0.25
Over 15.75 to 22.00, incl	0.20	0.20	0.30
Over 22.00 to 25.00, incl	0.22	0.22	0.32
Over 25.00 to 28.00, incl	0.25	0.25	0.38
Over 28.00 to 31.00, incl	0.28	0.28	0.40
Over 31.00 to 34.00, incl	0.30	0.30	0.45
Over 34.00 to 37.50, incl	0.35	0.35	0.52
Over 37.50 to 50.00, incl	0.40	0.40	0.58
Over 50.00 to 62.50, incl	0.80	0	0.58
Over 62.50 to 87.50, incl	1.20	0	0.88
Over 87.50 to 115.00, incl	1.60	0	1.15
Over 115.00 to 138.00, incl	2.00	0	1.45
Over 138.00 to 165.00, incl	3.15	0	1.75
Over 165.00 to 200.00, incl	3.90	0	2.12

2.3.1.2 Hexagons and Octagons: See Table 6.

TABLE 6 - Thickness Tolerances

Specified Thickness Millimeters	Tolerance Millimeters Plus and Minus	Maximum Difference
		3 Measurements Hexagons Only Millimeters
6.25 to 12.50, incl	0.18	0.28
Over 12.50 to 25.00, incl	0.25	0.38
Over 25.00 to 37.50, incl	0.52	0.62
Over 37.50 to 50.00, incl	0.78	0.78
Over 50.00 to 62.50, incl	1.18	1.18
Over 62.50 to 87.50, incl	1.56	1.56

2.3.1.3 Flats: See Table 7 and Table 8.

TABLE 7 - Thickness Tolerances, Millimeters; For Thickness Ranges, Millimeters

Specified Width Millimeters	Over 3.10 to 12.50, Inc. Plus and Minus		Over 12.5 to 25.00, Incl Plus and Minus		Over 25.00 to 50.00, Incl Plus and Minus		Over 50.00 to 100.00, Incl Plus and Minus		Over 100.00 to 150.00, Incl Plus and Minus		Over 150.00 to 200.00, Incl Plus and Minus		Over 200.00 to 250.00, Incl Plus and Minus	
	Up to 25.00, incl	0.20	0.25	-	-	-	-	-	-	-	-	-	-	-
Over 25.00 to 50.00, incl	0.30	0.38	0.78	-	-	-	-	-	-	-	-	-	-	-
Over 50.00 to 100.00, incl	0.38	0.50	0.78	1.55	0.78	-	-	-	-	-	-	-	-	-
Over 100.00 to 150.00, incl	0.38	0.50	0.78	1.55	0.78	2.32	1.55	-	-	-	-	-	-	-
Over 150.00 to 200.00, incl	0.40	0.62	0.78	1.55	0.78	2.32	1.55	3.12	3.90	-	-	-	-	-
Over 200.00 to 250.00, incl	0.52	0.78	0.78	1.55	0.78	2.32	1.55	3.12	3.90	-	-	-	-	-

TABLE 8 - Width Tolerances

Specified Width Millimeters	Tolerance, Millimeters	
	Plus	Minus
Up to 25.00, incl	0.38	0.38
Over 25.00 to 50.00, incl	0.78	0.78
Over 50.00 to 100.00, incl	1.55	0.78
Over 100.00 to 150.00, incl	2.32	1.55
Over 150.00 to 200.00, incl	3.12	3.90
Over 200.00 to 250.00, incl	3.90	4.68

2.3.2 Forged: Tolerances shall be as agreed upon by purchaser and vendor.

3. LENGTH:

Tolerances in Table 9 and Table 10 shall apply only when definite lengths are ordered.

3.1 Hot or Cold Finished Bars:

See Table 9.

TABLE 9 - Length Tolerances, Millimeters, Plus Only, For Length Ranges, Millimeters

Specified Diameter of Rounds Thickness of Squares Hexagons, and Octagons Width of Flats Millimeters	Up to 3600,	Over 3600 to 7500,
	Incl	Incl
Up to 50.00, incl	12.5	19.0
Over 50.00 to 100.00, incl	19.0	25.0
Over 100.00 to 150.00, incl	25.0	31.0
Over 150.00 to 225.00, incl	31.0	37.5
Over 225.00 to 300.00, incl	37.5	50.0

3.2 Wire:

3.2.1 Round and Shape, Straightened and Cut, Exact Length Resheared: See Table 10.

TABLE 10 - Length Tolerances, Millimeters, Plus Only, For Length Ranges, Millimeters

Specified Diameter of Rounds Thickness of Squares Hexagons, and Octagons Millimeters	Up to 900,	900 to 3600,	Over 3600 to 7500,
	Excl	Incl	Incl
Up to 3.12, incl	1.6	1.6	3.1
Over 3.12 to 12.50, incl	0.8 (See 2.1.1)	1.6	3.1

3.2.1.1 For titanium and titanium alloys, tolerance for these sizes is +1.6 mm, -0.