

TOLERANCES, METRIC
Titanium and Titanium Alloy Tubing

1. **SCOPE:** This specification covers established metric manufacturing tolerances applicable to titanium and titanium alloy tubing 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 2244, specified in inch/pound units, is the equivalent of this MAM.

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 Millimetres	Standard Tolerance Millimetre plus and minus	Special Tolerance Millimetre plus only
Up to 2.50, excl	0.05	0.05
2.50 to 4.75, excl	0.08	0.08
4.75 to 12.50, excl	0.10	0.10
12.50 to 25.00, excl	0.12	0.12
25.00 to 37.50, excl	0.15	0.15
37.50 to 50.00, excl	0.18	0.18
50.00 to 75.00, excl	0.25	0.25
75.00 to 115.00, excl	0.38	0.38

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