

Bohler-Uddeholm Limited

GUIDELINES FOR STANDARD FINISHES AND TOLERANCES

A - KLEEN GROUND (Decarb-free)

Surface ground/fine-milled flats and squares

Thickness +0.015"/+0.030
Width +0.015"/+0.025"

B - KLEEN MACHINED (Decarb-free) Flats and Squares

Surface milled < 20" thick +0.100"/+0.180"
Surface milled 20" thick and over +0.125"/+0.3125"

C - KLEEN PEELED (Decarb-free) Rounds

Peeled Rounds, 1/2" - 1 7/8" diameter +0.015"/+0.030"

D - KLEEN TURNED (Decarb-free) Rounds

Turned Rounds 2" diameter and over
2" - 3" +0.035"/+0.045"
3 1/4" - 4 1/2" +0.045"/+0.065"
4 3/4" - 7" +0.080"/+0.120"
7 1/2" - 9 1/2" +0.080"/+0.155"
10" and up +0.080"/+0.195"

E - HOT-ROLLED (Unmachined) Flats and Squares

Flats and Squares (Rolled Bar) Thickness 0/+0.020" to 0/+0.060"
Width 0/+0.040" to 0/+0.100"
(Depending on Section)

Flats (Rolled Plate)
< 1 7/8" Thick +0.125"/+0.185"
2 - 2 7/8" Thick +0.188"/+0.288"
> 2 7/8" Thick +0.188"/+0.338"

F - FINE MACHINED T&B PLATE

Thickness +0.015"/+0.030"
Width +0.100"/+0.180"

G - SAW CUT TOLERANCE - ROUNDS

1/2" - 15" diameter
Cut to Finish - plus 1/4" oversize
Cut to Size - plus 1/8" oversize

> 15" - 20" diameter
Cut to Finish - plus 3/8" oversize
Cut to Size - plus 1/8" oversize

> 20" - 26" diameter
Cut to Finish - > 3/8" oversize
Cut to Size - > 1/8" oversize

H - SAW CUT TOLERANCE - FLATS

> 1" - 4" thick; up to 36" wide
Cut to Finish - > 1/2" oversize
Cut to Size - > 1/8" oversize

> 4" thick and widths 36" and wider
Cut to Finish - > 3/8" oversize
Cut to Size - > 1/8" oversize

This document is intended to provide a general guideline on standard finishes and tolerances. It should not therefore be construed as a warranty of a specific size tolerance. Tolerance may vary on size. Please refer to our website www.bucanada.ca for the latest information. This document is uncontrolled when printed. Rev. February 8, 2011.

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