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International Standard



6361 / 3

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INTERNATIONAL ORGANIZATION FOR STANDARDIZATION • МЕЖДУНАРОДНАЯ ОРГАНИЗАЦИЯ ПО СТАНДАРТИЗАЦИИ • ORGANISATION INTERNATIONALE DE NORMALISATION

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**Wrought aluminium and aluminium alloy sheets, strips  
and plates —  
Part 3 : Strips — Tolerances on shape and dimensions**

*Tôles, bandes et tôles épaisses en aluminium et en alliages d'aluminium corroyés — Partie 3 : Bandes — Tolérances sur forme et dimensions*

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## Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards bodies (ISO member bodies). The work of preparing International Standards is normally carried out through ISO technical committees. Each member body interested in a subject for which a technical committee has been established has the right to be represented on that committee. International organizations, governmental and non-governmental, in liaison with ISO, also take part in the work.

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.

International Standard ISO 6361/3 was prepared by Technical Committee ISO/TC 79, *Light metals and their alloys*.

Users should note that all International Standards undergo revision from time to time and that any reference made herein to any other International Standard implies its latest edition, unless otherwise stated.

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# Wrought aluminium and aluminium alloy sheets, strips and plates —

## Part 3 : Strips — Tolerances on shape and dimensions

### 1 Scope and field of application

This part of ISO 6361 specifies dimensional tolerances for aluminium and aluminium alloy strips for thicknesses up to and including 6,3 mm, corresponding to the definition in ISO 3134/3.

By agreement between purchaser and supplier, the values of tolerances specified in this part of ISO 6361 may be differently disposed about the nominal dimension.

The class 2 may be applied, for instance, to hot-rolled metal, as specified in some national standards.

The class chosen by the purchaser shall be indicated on the order.

**4.3** For thicknesses up to and including 6,3 mm, different tolerances are specified for strip in soft alloys (category 1) and hard alloys (category 2) as defined below :

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ISO 6361-3:1985 a) Soft alloys (category 1) :  
<https://standards.itech.ai/catalog/standards/sist/dfdc5408-739a-4735-80b7-16d1a4b1c40d/iso-6361-3-1985> unalloyed aluminium;

### 2 Reference

ISO 3134/3, *Light metals and their alloys — Terms and definitions — Part 3 : Wrought products.*

— alloys Al-Mn and Al-Mg with a maximum of 1,8 % alloying element;

— alloys Al-MgMn with a maximum of 2,3 % alloying element (Mg + Mn).

### 3 Definition

**strip** : A flat/rolled product of rectangular cross-section with uniform thickness over 0,20 mm, supplied in coils usually with slit edges. The thickness does not exceed one-tenth of the width.

b) Hard alloys (category 2) :

— alloys Al-Mn and Al-Mg with more than 1,8 % of alloying element;

— alloys Al-MgMn with more than 2,3 % alloying element (Mg + Mn);

— heat-treatable wrought alloys of the 2 000 (Al-CuMg, Al-CuMgSi), 6 000 (Al-MgSi, Al-SiMg) and 7 000 (Al-ZnMg, Al-ZnMgCu) series.

#### NOTES

1 Corrugated, embossed (with patterns, for example grooves, ribs, checkers, tears, buttons, lozenges), coated, edge-conditioned and perforated products in this general form when derived from strip as defined above are classified as strip.

2 In some English-speaking countries, "strip" is called "coiled sheet".

**4.4** Category 1 tolerances may be used for soft alloys or special purposes and category 2 tolerances may be used for hard alloys or general purposes, depending upon the requirements of the countries concerned.

The category chosen by the purchaser shall be indicated on the order.

### 4 Thickness tolerances

**4.1** Thickness tolerances shall be in accordance with table 1.

**4.2** Two classes of tolerance are specified for thicknesses over 3,2 mm, up to and including 6,3 mm.

**4.5** The thickness tolerances for widths up to and including 500 mm and for widths over 2 000 mm shall be chosen by agreement between purchaser and supplier.

**5 Width tolerances**

**5.1** Width tolerances shall be in agreement with table 2 for widths of 300 mm up to and including 2 000 mm.

These tolerances are all plus.

**5.2** For thicknesses over 3,2 mm up to and including 6,3 mm, different width tolerances are specified for cold-rolled metal (class 1) and for hot-rolled metal (class 2).

**5.3** Tolerances shall be chosen by agreement between purchaser and supplier for widths up to 300 mm and for widths over 2 000 mm.

**6 Lateral curvature tolerances**

When tested with the strip resting on a flat surface, against a straightedge, lateral curvature  $d$  shall not exceed the values given in table 3 for a value of length  $L = 2\ 000$  mm.

**7 Dimensions of coiled strip**

The inside diameter of the coiled strip shall be specified on the order by the purchaser, and the outside diameter or the weight of the coiled strip shall be defined by agreement between purchaser and supplier.

**Table 1 — Thickness tolerances — In plus and minus**

Values in millimetres

Thickness		Specified width								
		Over 500 up to and including 1 000 <sup>2)</sup>			Over 1 000 up to and including 1 500			Over 1 500 up to and including 2 000 <sup>2)</sup>		
		Class 1		Class 2 <sup>1)</sup>	Class 1		Class 2 <sup>1)</sup>	Class 1		Class 2 <sup>1)</sup>
Over	Up to and including	Category 1	Category 2		Category 1	Category 2		Category 1	Category 2	
0,20	0,25	0,03	0,04	—	0,04	0,06	—	—	—	—
0,25	0,40	0,04	0,05	—	0,05	0,07	—	—	—	—
0,40	0,60	0,04	0,05	—	0,06	0,08	—	0,08	—	—
0,60	0,80	0,05	0,06	—	0,08	0,09	—	0,10	0,12	—
0,80	1,00	0,06	0,07	—	0,09	0,10	—	0,11	0,14	—
1,00	1,20	0,07	0,08	—	0,10	0,12	—	0,12	0,16	—
1,20	1,60	0,08	0,09	—	0,12	0,14	—	0,14	0,18	—
1,60	2,00	0,09	0,10	—	0,13	0,15	—	0,16	0,20	—
2,00	2,50	0,10	0,11	—	0,14	0,16	—	0,17	0,22	—
2,50	3,20	0,12	0,13	—	0,17	0,20	—	0,20	0,26	—
3,20	4,00	0,14	0,15	0,30	0,21	0,22	0,30	0,24	0,32	0,40
4,00	5,00	0,18	0,19	0,35	0,25	0,26	0,35	0,29	0,36	0,43
5,00	6,30	0,24	0,25	0,35	0,29	0,32	0,40	0,35	0,44	0,46

1) Class 2 may be applied, for instance, for hot-rolled metal, as specified in some national standards.

2) Tolerances for widths up to and including 500 mm, and for widths over 2 000 mm, may be chosen by agreement between purchaser and supplier.

Table 2 – Width tolerances – All plus<sup>1)</sup>

Values in millimetres

Specified thickness		Class of metal	Specified width		
Over	Up to and including		Over and including 300 up to and including 500 <sup>3)</sup>	Over 500 up to and including 1 250	Over 1 250 up to and including 2 000 <sup>3)</sup>
0,20	1,0	Class 1	1,5	2,0	4,0
1,0	2,0	Class 1	2,0	2,5	4,0
2,0	3,2	Class 1	2,0	3,0	5,0
3,2	6,3	Class 1	3,0	4,0	5,0
		Class 2 <sup>2)</sup>	8,0	8,0	8,0

1) Tolerances may be all plus with values as shown, or symmetrical plus and minus, using half the value shown, by agreement between purchaser and supplier.

2) Class 2 may be applied, for instance, for hot-rolled metal, as specified in some national standards.

3) Tolerances for widths up to 300 mm and for widths over 2 000 mm may be chosen by agreement between purchaser and supplier.

Table 3 – Lateral curvature tolerances for class 1 and class 2 material

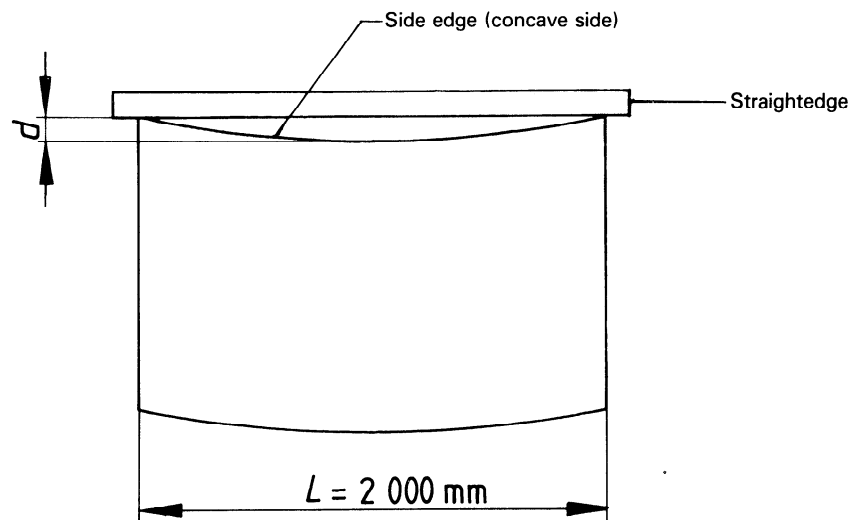
Maximum deviation  $d$  allowable from a straight line, on a length  $L = 2\ 000$  mm.

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Values in millimetres

Specified width		Maximum value of $d$
Over	Up to and including	
100	300	1)
300	500	8
500	1 250	6
1 250	2 000	5
2 000		1)

1) By agreement between purchaser and supplier.



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