



SLOVENSKI STANDARD

SIST EN 754-3:1998

01-april-1998

Aluminij in aluminijeve zlitine - Hladno vlečene palice/drogovi in cevi - 3. del: Palice z okroglim prerezom, tolerance mer in oblike

Aluminium and aluminium alloys - Cold drawn rod/bar and tube - Part 3: Round bars, tolerances on dimensions and form

Aluminium und Aluminiumlegierungen - Gezogene Stangen und Rohre - Teil 3:
Rundstangen, Grenzabmaße und Formtoleranzen

Aluminium et alliages d'aluminium - Barres et tubes étirés - Partie 3: Barres rondes, tolérances sur dimensions et forme

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Ta slovenski standard je istoveten z: EN 754-3:1995

ICS:

77.150.10

Aluminijski izdelki

Aluminium products

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en

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EUROPEAN STANDARD

EN 754-3

NORME EUROPÉENNE

EUROPÄISCHE NORM

November 1995

ICS 77.120.10

Descriptors: drawn products, rolled products, aluminium, aluminium alloys, metal bars, round bars, dimensions, dimensional tolerances, form tolerances

English version

**Aluminium and aluminium alloys - Cold drawn
rod/bar and tube - Part 3: Round bars, tolerances
on dimensions and form**

Aluminium et alliages d'aluminium - Barres et tubes étirés - Partie 3: Barres rondes, tolérances sur dimensions et forme

Aluminium und Aluminiumlegierungen - Gezogene Stangen und Rohre - Teil 3: Rundstangen, Grenzabmaße und Formtoleranzen

This European Standard was approved by CEN on 1995-09-15. CEN members are bound to comply with the CEN/CENELEC Internal Regulations which stipulate the conditions for giving this European Standard the status of a national standard without any alteration.

Up-to-date lists and bibliographical references concerning such national standards may be obtained on application to the Central Secretariat or to any CEN member.

The European Standards exist in three official versions (English, French, German). A version in any other language made by translation under the responsibility of a CEN member into its own language and notified to the Central Secretariat has the same status as the official versions.

CEN members are the national standards bodies of Austria, Belgium, Denmark, Finland, France, Germany, Greece, Iceland, Ireland, Italy, Luxembourg, Netherlands, Norway, Portugal, Spain, Sweden, Switzerland and United Kingdom.

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CEN

European Committee for Standardization
Comité Européen de Normalisation
Europäisches Komitee für Normung

Central Secretariat: rue de Stassart, 36 B-1050 Brussels

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Foreword

This European Standard has been drawn up by CEN/TC 132 "Aluminium and aluminium alloys", whose Secretariat is held by the Association Française de Normalisation (AFNOR).

Within its programme of work, Technical Committee CEN/TC 132 entrusted CEN/TC 132/WG 5 "Extruded and drawn products" to work out the following standard :

EN 754-3 Aluminium and aluminium alloys - Cold drawn rod/bar and tube -
Part 3 : Round bars, tolerances on dimensions and form

This standard is part of a set of eight standards. The other standards deal with :

EN 754-1 Aluminium and aluminium alloys - Cold drawn rod/bar and tube -
Part 1 : Technical conditions for inspection and delivery

EN 754-2 Aluminium and aluminium alloys - Cold drawn rod/bar and tube -
Part 2 : Mechanical properties

EN 754-4 Aluminium and aluminium alloys - Cold drawn rod/bar and tube -
Part 4 : Square bars, tolerances on dimensions and form

EN 754-5 Aluminium and aluminium alloys - Cold drawn rod/bar and tube -
Part 5 : Rectangular bars, tolerances on dimensions and form

EN 754-6 Aluminium and aluminium alloys - Cold drawn rod/bar and tube -
Part 6 : Hexagonal bars, tolerances on dimensions and form

EN 754-7 Aluminium and aluminium alloys - Cold drawn rod/bar and tube -
Part 7 : Seamless tubes, tolerances on dimensions and form

EN 754-8 Aluminium and aluminium alloys - Cold drawn rod/bar and tube -
Part 8 : Porthole tubes, tolerances on dimensions and form

CEN/TC 132 met on 11 and 12 May 1993 in Paris and agreed on the text to be submitted to CEN members for formal vote.

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This European Standard shall be given the status of a national standard, either by publication of an identical text or by endorsement, at the latest by May 1996, and conflicting national standards shall be withdrawn at the latest by May 1996.

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The following countries were represented at that meeting : Belgium - Denmark - France - Germany - Italy - Netherlands - Norway - Spain - Sweden - Switzerland - United Kingdom.

According to the common CEN/CENELEC Rules, the following countries are bound to implement this European Standard : Austria, Belgium, Denmark, Finland, France, Germany, Greece, Iceland, Ireland, Italy, Luxembourg, Netherlands, Norway, Portugal, Spain, Sweden, Switzerland and the United Kingdom.

1 Scope

This part of EN 754 specifies the tolerances on dimensions and form for aluminium and aluminium alloy cold drawn round bars having diameters in the range from 3 mm up to and including 100 mm.

2 Tolerances on dimensions and form

2.1 Diameter

The tolerances on diameter are specified in table 1.

Table 1: Diameter tolerances (minus only)

Dimensions in millimetres

Diameter D		Tolerances
from	up to and including	
3 ¹⁾	6	0 - 0,08
6	10	0 - 0,09
10	18	0 - 0,11
18	30	0 - 0,13
30	50	0 - 0,16
50	65	0 - 0,19
65	80	0 - 0,30
80	100	0 - 0,35
1) Except diameter 3 mm which may be used.		

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2.2 Ovality

Ovality is the difference between the maximum and minimum diameters measured in one cross-section.

The maximum permissible ovality is 50 % of the tolerance range specified in table 1 ; e.g. for a diameter tolerance of $\begin{matrix} 0 \\ - 0,08 \text{ mm} \end{matrix}$, the maximum permissible ovality is 0,04 mm.

2.3 Straightness

Deviations from straightness, h_s and h_t , shall be measured as shown in figure 1 with the bar placed on a horizontal baseplate so that its mass decreases the deviation.

The straightness tolerances are specified in table 2.

For bars with diameter less than 10 mm, the straightness tolerances shall be agreed upon between purchaser and supplier.

The straightness tolerances apply to bars with a diameter greater than 10 mm in all tempers except O and Tx51. If a straightness tolerance is required for either O or Tx51 temper, it shall be agreed between purchaser and supplier.

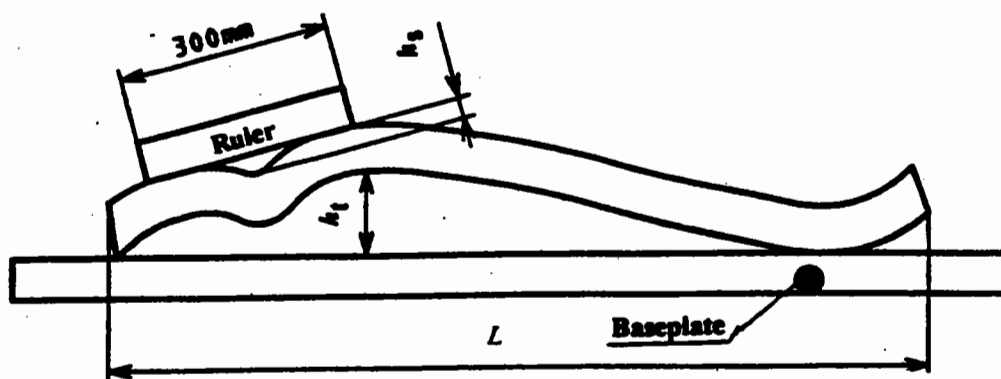


Figure 1 : Measurement of deviation from straightness

Table 2 : Straightness tolerances

Diameter D		Maximum deviation from straightness h_t	Maximum localised kink in any 300 mm portion h_s
from	up to	mm/m	
10	100	2	0,6

Dimensions in millimetres

2.4 Length

If fixed lengths are to be supplied, this shall be stated on the order. The fixed length tolerances are specified in table 3.

Table 3 : Fixed length tolerances

Dimensions in millimetres

Diameter D		Tolerances on fixed length		
from	up to	$L \leq 2\,000$	$2\,000 < L \leq 5\,000$	$L > 5\,000$
3	100	+ 5 0	+ 7 0	+ 10 0

If no fixed or minimum length is specified in the order, round drawn bars may be delivered in random lengths. The actual lengths and tolerances on random lengths shall be agreed between purchaser and supplier.

2.5 Squareness of cut ends

The squareness of cut ends shall be within half of the fixed length tolerance range (table 3) for both fixed and random lengths, e.g. for a fixed length tolerance of $^{+10}_{0\text{ mm}}$, the squareness of cut ends shall be within 5 mm.

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