



Standard Specification for Nickel-Chromium-Iron Alloys (UNS N06600, N06601, N06603, N06690, N06693, N06025, and N06045) and Nickel- Chromium-Cobalt-Molybdenum Alloy (UNS N06617) Plate, Sheet, and Strip¹

This standard is issued under the fixed designation B 168; the number immediately following the designation indicates the year of original adoption or, in the case of revision, the year of last revision. A number in parentheses indicates the year of last reappraisal. A superscript epsilon (ε) indicates an editorial change since the last revision or reappraisal.

This standard has been approved for use by agencies of the Department of Defense.

1. Scope

1.1 This specification² covers rolled nickel-chromium-iron alloys (UNS N06600, N06601, N06603, N06690, N06693, N06025, and N06045)* and nickel-chromium-cobalt-molybdenum alloy (UNS N06617) plate, sheet, and strip.

1.2 The values stated in inch-pound units are to be regarded as the standard. The values given in parentheses are for information only.

1.3 The following precautionary caveat pertains only to the test methods portion, Section 12, of this specification: *This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the responsibility of the user of this standard to become familiar with all hazards including those identified in the appropriate Material Safety Data Sheet (MSDS) for this product/material as provided by the manufacturer, to establish appropriate safety and health practices, and determine the applicability of regulatory limitations prior to use.*

2. Referenced Documents

2.1 ASTM Standards:³

B 166 Specification for Nickel-Chromium-Iron Alloys (UNS N06600, N06601, N06603, N06690, N06693,

N06025, and N06045)* and Nickel-Chromium-Cobalt-Molybdenum Alloy (UNS N06617) Rod, Bar, and Wire

B 880 Specification for General Requirements for Chemical Check Analysis Limits for Nickel, Nickel Alloys and Cobalt Alloys

E 8 Test Methods for Tension Testing of Metallic Materials

E 10 Test Method for Brinell Hardness of Metallic Materials

E 18 Test Methods for Rockwell Hardness of Metallic Materials

E 29 Practice for Using Significant Digits in Test Data to Determine Conformance with Specifications

E 38 Methods for Chemical Analysis of Nickel-Chromium and Nickel-Chromium-Iron Alloys⁴

E 112 Test Methods for Determining Average Grain Size

E 140 Hardness Conversion Tables for Metals Relationship Among Brinell Hardness, Vickers Hardness, Rockwell Hardness, Superficial Hardness, Knoop Hardness, and Scleroscope Hardness

E 527 Practice for Numbering Metals and Alloys in the Unified Numbering System (UNS)

E 1473 Test Methods for Chemical Analysis of Nickel, Cobalt, and High-Temperature Alloys

F 155 Test Method for Temper of Strip and Sheet Metals for Electronic Devices (Spring-Back Method)⁴

2.2 Federal Standards:⁵

Fed. Std. No. 102 Preservation, Packaging and Packing Levels

Fed. Std. No. 123 Marking for Shipment (Civil Agencies)

Fed. Std. No. 182 Continuous Identification Marking of Nickel and Nickel-Base Alloys

¹ This specification is under the jurisdiction of ASTM Committee B02 on Nonferrous Metals and Alloys and is the direct responsibility of Subcommittee B02.07 on Refined Nickel and Cobalt and Their Alloys.

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² For ASME Boiler and Pressure Code applications, see related Specification SB-168 in Section II of that Code.

* New designation established in accordance with Practice **E 527** and SAE J1086, Practice for Numbering Metals and Alloys (UNS).

³ For referenced ASTM standards, visit the ASTM website, www.astm.org, or contact ASTM Customer Service at service@astm.org. For *Annual Book of ASTM Standards* volume information, refer to the standard's Document Summary page on the ASTM website.

⁴ Withdrawn.

⁵ Available from Standardization Documents Order Desk, DODSSP, Bldg. 4, Section D, 700 Robbins Ave., Philadelphia, PA 19111-5098, http://www.dodssp.daps.mil.

TABLE 1 Product Description

Product	Thickness, in. (mm)	Width, in. (mm)
Hot-rolled plate ^A	3/16 and over (Table 5 and Table 6)	(Table 8) ^B
Hot-rolled sheet ^A	0.018 to 0.250 (0.46 to 6.4), incl (Table 7)	(Table 10)
Cold-rolled sheet ^C	0.018 to 0.250 (0.46 to 6.4), incl (Table 7)	(Table 10)
Cold-rolled strip ^C	0.005 to 0.250 (0.13 to 6.4), incl (Table 7)	(Table 10)

^A Material 3/16 to 1/4 in. (4.8 to 6.4 mm), incl, in thickness may be furnished as sheet or plate provided the material meets the specification requirements for the condition ordered.

^B Hot-rolled plate, in widths 10 in. (254 mm) and under, may be furnished as hot-finished rectangles with sheared or cut edges in accordance with Specification B 166, provided the mechanical property requirements of this specification are met.

^C Material under 48 in. (1219 mm) in width may be furnished as sheet or strip provided the material meets the specification requirements for the condition ordered.

TABLE 2 Chemical Requirements

Element	Composition Limits, %							
	Alloy N06600	Alloy N06601	Alloy N06617	Alloy N06690	Alloy N06693	Alloy N06025	Alloy N06045	Alloy N06603
Nickel	72.0 min	58.0–63.0	44.5 min	58.0 min	remainder ^A	remainder ^A	45.0 min	remainder ^A
Chromium	14.0–17.0	21.0–25.0	20.0–24.0	27.0–31.0	27.0–31.0	24.0–26.0	26.0–29.0	24.0–26.0
Cobalt	10.0–15.0
Molybdenum	8.0–10.0
Niobium	0.5–2.5
Iron	6.0–10.0	remainder ^A	3.0 max	7.0–11.0	2.5–6.0	8.0–11.0	21.0–25.0	8.0–11.0
Manganese	1.0 max	1.0 max	1.0 max	0.5 max	1.0 max	0.15 max	1.0 max	0.15 max
Aluminum	...	1.0–1.7	0.8–1.5	...	2.5–4.0	1.8–2.4	...	2.4–3.0
Carbon	0.15 max	0.10 max	0.05–0.15	0.05 max	0.15 max	0.15–0.25	0.05–0.12	0.20–0.40
Copper	0.5 max	1.0 max	0.5 max	0.5 max	0.5 max	0.1 max	0.3 max	0.50 max
Silicon	0.5 max	0.5 max	1.0 max	0.5 max	0.5 max	0.5 max	2.5–3.0	0.50 max
Sulfur	0.015 max	0.015 max	0.015 max	0.015 max	0.01 max	0.010 max	0.010 max	0.010 max
Titanium	0.6 max	...	1.0 max	0.1–0.2	...	0.01–0.25
Phosphorus	0.020 max	0.020 max	0.020 max
Zirconium	0.01–0.10	...	0.01–0.10
Yttrium	0.05–0.12	...	0.01–0.15
Boron	0.006 max
Nitrogen
Cerium	0.03–0.09	...

^A Element shall be determined arithmetically by difference.

2.3 Military Standard:⁵

MIL-STD-129 Marking for Shipment and Storage

3. Terminology

3.1 *Descriptions of Terms Specific to This Standard*—The terms given in Table 1 shall apply.

4. Ordering Information

4.1 It is the responsibility of the purchaser to specify all requirements that are necessary for the safe and satisfactory performance of material ordered under this specification. Examples of such requirements include, but are not limited to, the following:

- 4.1.1 *Alloy*—Name or UNS number (see Table 2),
- 4.1.2 *ASTM designation*, including year of issue,
- 4.1.3 *Condition*—See 6.1 and 6.2 and Appendix X1,
- 4.1.4 *Finish*—Appendix X1,
- 4.1.5 *Dimensions*—Thickness, width, and length,
- 4.1.6 *Quantity*,
- 4.1.7 *Optional Requirements*:

4.1.7.1 *Sheet and Strip*—Whether to be furnished in coil, in cut straight lengths, or in random straight lengths,

4.1.7.2 *Strip*—Whether to be furnished with commercial slit edge, square edge, or round edge,

4.1.7.3 *Plate*—Whether to be furnished specially flattened (see 7.7.2); also how plate is to be cut (see 7.2.1 and 7.3.2),

4.1.8 *Certification*—State if certification or a report of test results is required (Section 15),

4.1.9 *Samples for Product (Check) Analysis*—Whether samples for product (check) analysis should be furnished (see 5.2), and

4.1.10 *Purchaser Inspection*—If the purchaser wishes to witness tests or inspection of material at the place of manufacture, the purchase order must so state indicating which tests or inspections are to be witnessed (Section 13).

5. Chemical Composition

5.1 The material shall conform to the requirements as to chemical composition prescribed in Table 2.

5.2 If a product (check) analysis is performed by the purchaser, the material shall conform to the product (check) analysis variations prescribed in Specification B 880.

6. Mechanical Properties and Other Requirements

6.1 *Mechanical Properties*—The material shall conform to the mechanical properties prescribed in Table 3.

TABLE 3 Mechanical Properties for Plate, Sheet, and Strip (All Thicknesses and Sizes Unless Otherwise Indicated)

Condition (Temper)	Tensile Strength, min, psi (MPa)	Yield Strength ^A (0.2 % offset), min, psi (MPa)	Elongation in 2 in. or 50 mm (or 4D), min,%	Rockwell Hardness ^{B,C}
Hot-Rolled Plate				
UNS N06600:				
Annealed	80 000 (550)	35 000 (240)	30	...
As-rolled ^{D,E}	85 000 (586)	35 000 (240)	30	...
UNS N06601:				
Annealed	80 000 (550)	30 000 (205)	30	...
UNS N06603:				
Annealed	94 000 (650)	43 000 (300)	25	...
UNS N06617:				
Annealed	95 000 (655)	35 000 (240)	35	...
UNS N06690:				
Annealed	85 000 (586)	35 000 (240)	30	...
As-rolled ^{D,E}	85 000 (586)	35 000 (240)	30	...
Annealed ^F	75 000 (514)	30 000 (206)	30	...
UNS N06693				
Annealed	100 000 (690)	50 000 (345)	30	...
UNS N06025				
Annealed	98 000 (680)	39 000 (270)	30	...
UNS N06045				
Annealed	90 000 (620)	35 000 (240)	35	...
Hot-Rolled Sheet				
UNS N06600:				
Annealed	80 000 (550)	35 000 (240)	30	...
UNS N06601:				
Annealed	80 000 (550)	30 000 (205)	30	...
UNS N06603:				
Annealed	94 000 (650)	43 000 (300)	25	...
UNS N06617:				
Annealed	95 000 (655)	35 000 (240)	30	...
UNS N06690:				
Annealed	85 000 (586)	35 000 (240)	30	...
UNS N06693				
Annealed	100 000 (690)	50 000 (345)	30	...
UNS N06025				
Annealed	98 000 (680)	39 000 (270)	30	...
UNS N06045				
Annealed	90 000 (620)	35 000 (240)	35	...
Cold-Rolled Plate				
UNS N06603				
Annealed	94 000 (650)	43 000 (300)	25	...
UNS N06025				
Annealed	98 000 (680)	39 000 (270)	30	...
UNS N06045				
Annealed	90 000 (620)	35 000 (240)	35	...
Cold-Rolled Sheet				
UNS N06600:				
Annealed	80 000 (550) ^G	35 000 (240)	30 ^G	...
Hard	125 000 (860) ^G	90 000 (620)	2 ^G	...
UNS N06601:				
Annealed	80 000 (550) ^G	30 000 (205)	30 ^G	...
UNS N06603:				
Annealed	94 000 (650)	43 000 (300)	25 ^G	...
UNS N06617:				
Annealed	95 000 (655) ^G	35 000 (240)	25 ^G	...
UNS N06690:				
Annealed	85 000 (586) ^G	35 000 (240)	30 ^G	...
Hard	125 000 (860) ^G	90 000 (620)	2 ^G	...
UNS N06693				
Annealed	100 000 (690)	50 000 (345)	30	...
UNS N06025				
Annealed	98 000 (680)	39 000 (270)	30	...
UNS N06045				
Annealed	90 000 (620)	35 000 (240)	35	...
Cold-Rolled Strip				

TABLE 3 Continued

Condition (Temper)	Tensile Strength, min, psi (MPa)	Yield Strength ^A (0.2 % offset), min, psi (MPa)	Elongation in 2 in. or 50 mm (or 4D), min, %	Rockwell Hardness ^{B,C}
UNS N06600:				
Annealed	80 000 (550) ^G	35 000 (240)	30 ^G	...
Skin-hard	B85 to B88
Quarter-hard	B88 to B94
Half-hard	B93 to B98
Three-quarter-hard	B97 to C25
Hard	125 000 (860) ^G	90 000 (620)	2 ^G	...
Spring	C30 min
UNS N06601:				
Annealed	80 000 (550) ^G	30 000 (205)	30 ^G	...
UNS N06603:				
Annealed	94 000 (650)	43 000 (300)	25 ^G	...
UNS N06617:				
Annealed	95 000 (655) ^G	35 000 (240)	30 ^G	...
UNS N06690:				
Annealed	85 000 (586) ^G	35 000 (240)	30 ^G	...
Skin-hard	B85 to B88
Quarter-hard	B88 to B94
Half-hard	B93 to B98
Three-quarter-hard	B97 to C25
Hard	125 000 (860) ^G	90 000 (620)	2 ^G	...
Spring	C30 min
UNS N06693				
Annealed	100 000 (690)	50 000 (345)	30	...
UNS N06025				
Annealed	98 000 (680)	39 000 (270)	30	...
UNS N06045				
Annealed	90 000 (620)	35 000 (240)	35	...

^A Yield strength requirements do not apply to material under 0.020 in. (0.51 mm) in thickness.

^B For Rockwell or equivalent hardness conversions, see Hardness Conversion Tables E 140.

^C Caution should be served in using the Rockwell test on thin material, as the results may be affected by specimen thickness. For thicknesses under 0.050 in. (1.3 mm), the use of the Rockwell superficial or the Vickers hardness test is suggested.

^D As-rolled plate may be given a stress relieving heat treatment subsequent to final rolling.

^E As-rolled plate specified "suitable for hot forming" shall be furnished from heats of known good hot-malleability characteristics (see X1.2.2). There are no applicable tensile or hardness requirements for such material.

^F Annealed at 1850°F (1010°C) minimum.

^G Not applicable for thickness under 0.010 in. (0.25 mm).

6.2 Deep Drawing and Spinning Quality Sheet and Strip—The material shall conform to the grain size and hardness requirements as prescribed in Table 4.

6.2.1 The mechanical properties of Table 3 do not apply to deep drawing and spinning quality sheet and strip.

7. Dimensions and Permissible Variations

7.1 Thickness and Weight:

7.1.1 Plate—For plate up to 2 in. (50.8 mm), inclusive, in thickness, the permissible variation under the specified thickness and permissible excess in overweight shall not exceed the amounts prescribed in Table 5.

7.1.1.1 For use with Table 5, plate shall be assumed to weigh 0.304 lb/in.³ (8.415 g/cm³).

7.1.2 Plate—For plate over 2 in. (50.8 mm) in thickness, the permissible variations over the specified thickness shall not exceed the amounts prescribed in Table 6.

7.1.3 Sheet and Strip—The permissible variations in thickness of sheet and strip shall be as prescribed in Table 7. The thickness of strip and sheet shall be measured with the micrometer spindle 3/8 in. (9.5 mm) or more from either edge for material 1 in. (25.4 mm) or over in width and at any place on the strip under 1 in. in width.

7.2 Width or Diameter:

TABLE 4 Grain Size and Hardness for Cold-Rolled, Deep-Drawing, and Spinning-Quality Sheet and Strip

Thickness, in. (mm)	Calculated Diameter of Average Grain Section, max, in. (mm)	Corresponding ASTM MicroGrain Size No.	Rockwell B ^{A,B} Hardness, max
Sheet (56 in. (1.42 m) Wide and Under)			
0.050 (1.3) and less	0.0030 (0.075)	4.5	86
Over 0.050 to 0.250 (1.3 to 6.4), incl	0.0043 (0.110)	3.5	86
Strip (12 in. (305 mm) Wide and Under) ^C			
0.005 ^D to 0.010 (0.13 to 0.25), incl	0.0009 (0.022)	8 ^E	88 ^E
Over 0.010 to 0.125 (0.25 to 3.2), incl	0.0030 (0.075)	4.5	86

^A For Rockwell or equivalent hardness conversions, see Hardness Conversion Tables E 140.

^B Caution should be observed in using the Rockwell test on thin material, as the results may be affected by specimen thickness. For thicknesses under 0.050 in. (1.3 mm), the use of the Rockwell superficial or the Vickers hardness test is suggested.

^C Sheet requirements (above) apply to strip thicknesses over 0.125 in. (3.2 mm), and for all thicknesses of strip over 12 in. (305 mm) in width.

^D For ductility evaluations for strip under 0.005 in. (0.13 mm) in thickness, the springback test, such as described in Test Method F 155, is often used and the manufacturer should be consulted.

^E Accurate grain size and hardness determinations are difficult to make on strip under 0.005 in. (0.13 mm) in thickness and are not recommended.

TABLE 5 Permissible Variations in Thickness and Overweight of Rectangular Plates

NOTE 1—All plates shall be ordered to thickness and not to weight per square foot (cm). No plates shall vary more than 0.01 in. (0.3 mm) under the thickness ordered, and the overweight of each lot^A in each shipment shall not exceed the amount in the table. Spot grinding is permitted to remove surface imperfections, such spots not to exceed 0.01 in. under the specified thickness.

Specified Thickness, in. (mm)	Permissible Excess in Average Weight ^{B,C} per Square Foot of Plates for Widths Given in Inches (Millimetres) Expressed in Percentage of Nominal Weights									
	Under 48 (1220)	48 to 60 (1220 to 1520), excl	60 to 72 (1520 to 1830), excl	72 to 84 (1830 to 2130), excl	84 to 96 (2130 to 2440), excl	96 to 108 (2440 to 2740), excl	108 to 120 (2740 to 3050), excl	120 to 132 (3050 to 3350), excl	132 to 144 (3350 to 3660), excl	144 to 160 (3660 to 4070), excl
3/16 to 5/16 (4.8 to 7.9), excl	9.0	10.5	12.0	13.5	15.0	16.5	18.0
5/16 to 3/8 (7.9 to 9.5), excl	7.5	9.0	10.5	12.0	13.5	15.0	16.5	18.0
3/8 to 7/16 (9.5 to 11.1), excl	7.0	7.5	9.0	10.5	12.0	13.5	15.0	16.5	18.0	19.5
7/16 to 1/2 (11.1 to 12.7), excl	6.0	7.0	7.5	9.0	10.5	12.0	13.5	15.0	16.5	18.0
1/2 to 5/8 (12.7 to 15.9), excl	5.0	6.0	7.0	7.5	9.0	10.5	12.0	13.5	15.0	16.5
5/8 to 3/4 (15.9 to 19.1), excl	4.5	5.5	6.0	7.0	7.5	9.0	10.5	12.0	13.5	15.0
3/4 to 1 (19.1 to 25.4), excl	4.0	4.5	5.5	6.0	7.0	7.5	9.0	10.5	12.0	13.5
1 to 2 (25.4 to 50.8), incl	4.0	4.0	4.5	5.5	6.0	7.0	7.5	9.0	10.5	12.0

^A The term "lot" applied to this table means all of the plates of each group width and each group thickness.

^B The permissible overweight for lots of circular and sketch plates shall be 25 % greater than the amounts given in this table.

^C The weight of individual plates shall not exceed the nominal weight by more than 1/4 times the amount given in the table and Footnote B.

TABLE 6 Permissible Variations in Thickness for Rectangular Plates Over 2 in. (51 mm) in Thickness

NOTE 1—Permissible variation under specified thickness, 0.01 in. (0.3 mm)

Specified Thickness, in. (mm)	Permissible Variations, in. (mm), over Specified Thickness for Widths Given, in. (mm)					
	To 36 (915), excl	36 to 60 (915 to 1520), excl	60 to 84 (1520 to 2130), excl	84 to 120 (2130 to 3050), excl	120 to 132 (3050 to 3350), excl	132 (3350) and over
Over 2 to 3 (51 to 76), excl	1/16 (1.6)	3/32 (2.4)	7/64 (2.8)	1/8 (3.2)	1/8 (3.2)	3/64 (3.6)
3 to 4 (76 to 102), incl	5/64 (2.0)	3/32 (2.4)	7/64 (2.8)	1/8 (3.2)	1/8 (3.2)	3/64 (3.6)

**TABLE 7 Permissible Variations in Thickness of Sheet and Strip
(Permissible Variations, Plus and Minus, in Thickness, in. (mm), for Widths Given in in. (mm))**

Specified Thickness, in. (mm)	Sheet ^A			
	Hot-Rolled		Cold-Rolled	
	48 (1220) and Under	Over 48 to 60 (1220 to 1520), incl	48 (1220) and Under	Over 48 to 60 (1220 to 1520), incl
0.018 to 0.025 (0.5 to 0.6), incl	0.003 (0.08)	0.004 (0.10)	0.002 (0.05)	0.003 (0.08)
Over 0.025 to 0.034 (0.6 to 0.9), incl	0.004 (0.10)	0.005 (0.13)	0.003 (0.08)	0.004 (0.10)
Over 0.034 to 0.043 (0.9 to 1.1), incl	0.005 (0.13)	0.006 (0.15)	0.004 (0.10)	0.005 (0.13)
Over 0.043 to 0.056 (1.1 to 1.4), incl	0.005 (0.13)	0.006 (0.15)	0.004 (0.10)	0.005 (0.13)
Over 0.056 to 0.070 (1.4 to 1.8), incl	0.006 (0.15)	0.007 (0.18)	0.005 (0.13)	0.006 (0.15)
Over 0.070 to 0.078 (1.8 to 1.9), incl	0.007 (0.18)	0.008 (0.20)	0.006 (0.15)	0.007 (0.18)
Over 0.078 to 0.093 (1.9 to 2.4), incl	0.008 (0.20)	0.009 (0.23)	0.007 (0.18)	0.008 (0.20)
Over 0.093 to 0.109 (2.4 to 2.8), incl	0.009 (0.23)	0.010 (0.25)	0.007 (0.18)	0.009 (0.23)
Over 0.109 to 0.125 (2.8 to 3.2), incl	0.010 (0.25)	0.012 (0.31)	0.008 (0.20)	0.010 (0.25)
Over 0.125 to 0.140 (3.2 to 3.6), incl	0.012 (0.31)	0.014 (0.36)	0.008 (0.20)	0.010 (0.25)
Over 0.140 to 0.171 (3.6 to 4.3), incl	0.014 (0.36)	0.016 (0.41)	0.009 (0.23)	0.012 (0.31)
Over 0.171 to 0.187 (4.3 to 4.8), incl	0.015 (0.38)	0.017 (0.43)	0.010 (0.25)	0.013 (0.33)
Over 0.187 to 0.218 (4.8 to 5.5), incl	0.017 (0.43)	0.019 (0.48)	0.011 (0.28)	0.015 (0.38)
Over 0.218 to 0.234 (5.5 to 5.9), incl	0.018 (0.46)	0.020 (0.51)	0.012 (0.31)	0.016 (0.41)
Over 0.234 to 0.250 (5.9 to 6.4), incl	0.020 (0.51)	0.022 (0.56)	0.013 (0.33)	0.018 (0.46)

Specified Thickness, in. (mm)	Cold-Rolled Strip ^{A,B}	
	Widths 12 in. (305 mm) and under, plus and minus	
Up to 0.050 (1.27), incl	0.0015 (0.038)	
Over 0.050 to 0.093 (1.27 to 2.39), incl	0.0025 (0.063)	
Over 0.093 to 0.125 (2.39 to 3.18), incl	0.004 (0.11)	

^A Measured 3/8 in. (9.5 mm) or more from either edge except for strip under 1 in. (25.4 mm) in width which is measured at any place.

^B Standard sheet tolerances apply for thicknesses over 0.125 in. (3.2 mm) and for all thicknesses of strip over 12 in. (305 mm) wide.

7.2.1 *Plate*—The permissible variations in width of rectangular plates and diameter of circular plates shall be as prescribed in **Table 8** and **Table 9**.

7.2.2 *Sheet and Strip*—The permissible variations in width for sheet and strip shall be as prescribed in **Table 10**.

7.3 *Length*:

TABLE 8 Permissible variations^A of Sheared, Plasma-Torch-Cut, and Abrasive-Cut Rectangular Plate^{B,C}

Specified Thickness	Permissible Variations in Widths for Widths Given, in. (mm)									
	Up to 30 (760), incl		Over 30 to 72 (760 to 1830), incl		Over 72 to 108 (1830 to 2740), incl		Over 108 to 144 (2740 to 3660), incl		Over 144 to 160 (3660 to 4070), incl	
	+	-	+	-	+	-	+	-	+	-
Inches										
Sheared: ^D										
3/16 to 5/16, excl	3/16	1/8	1/4	1/8	3/8	1/8	1/2	1/8
5/16 to 1/2, excl	1/4	1/8	3/8	1/8	3/8	1/8	1/2	1/8	5/8	1/8
1/2 to 3/4, excl	3/8	1/8	3/8	1/8	1/2	1/8	5/8	1/8	3/4	1/8
3/4 to 1, excl	1/2	1/8	1/2	1/8	5/8	1/8	3/4	1/8	7/8	1/8
1 to 1 1/4, incl	5/8	1/8	5/8	1/8	3/4	1/8	7/8	1/8	1	1/8
Abrasive cut: ^{E,F}										
3/16 to 1 1/4, incl	1/8	1/8	1/8	1/8	1/8	1/8	1/8	1/8	1/8	1/8
Over 1 1/4 to 2 3/4, incl	3/16	1/8	3/16	1/8	3/16	1/8	3/16	1/8	3/16	1/8
Plasma-torch-cut: ^G										
3/16 to 2, excl	1/2	0	1/2	0	1/2	0	1/2	0	1/2	0
2 to 3, incl	5/8	0	5/8	0	5/8	0	5/8	0	5/8	0
Millimetres										
Sheared: ^D										
4.8 to 7.9, excl	4.8	3.2	6.4	3.2	9.5	3.2	12.7	3.2
7.9 to 12.7, excl	6.4	3.2	9.5	3.2	9.5	3.2	12.7	3.2	15.9	3.2
12.7 to 19.1, excl	9.5	3.2	9.5	3.2	12.7	3.2	15.9	3.2	19.1	3.2
19.1 to 25.4, excl	12.7	3.2	12.7	3.2	15.8	3.2	19.1	3.2	22.2	3.2
25.4 to 31.8, incl	15.9	3.2	15.9	3.2	19.1	3.2	22.2	3.2	25.4	3.2
Abrasive cut: ^{E,F}										
4.8 to 31.8, incl	3.2	3.2	3.2	3.2	3.2	3.2	3.2	3.2	3.2	3.2
Over 31.8 to 69.8, incl	4.8	3.2	4.8	3.2	4.8	3.2	4.8	3.2	4.8	3.2
Plasma-torch-cut: ^G										
4.8 to 50.8, excl	12.7	0	12.7	0	12.7	0	12.7	0	12.7	0
50.8 to 76.2, incl	15.9	0	15.9	0	15.9	0	15.9	0	15.9	0

^A Permissible variations in width for powder- or inert-arc-cut plate shall be as agreed upon between the manufacturer and the purchaser.

^B Permissible variations in machined, powder-, or inert-arc-cut circular plate shall be as agreed upon between the manufacturer and the purchaser.

^C Permissible variations in plasma-torch-cut sketch plates shall be as agreed upon between the manufacturer and the purchaser.

^D The minimum sheared width is 10 in. (254 mm) for material 3/4 in. (19.1 mm) and under in thickness and 20 in. (508 mm) for material over 3/4 in. (19.1 mm) in thickness.

^E The minimum abrasive-cut width is 2 in. (50.8 mm) and increases to 4 in. (101.6 mm) for thicker plates.

^F These tolerances are applicable to lengths of 240 in. (6100 mm), max. For lengths over 240 in., an additional 1/16 in. (1.6 mm) is permitted, both plus and minus.

^G The tolerance spread shown for plasma-torch cutting may be obtained all on the minus side, or divided between the plus and minus side if so specified by the purchaser.

TABLE 9 Permissible Variations in Diameter for Circular Plates

Specified Diameter, in. (mm)	Sheared Plate				
	Permissible Variations over Specified Diameter for Thickness Given, in. (mm) ^A				
	To 3/8 (9.5), incl				
20 to 32 (508 to 813), excl	1/4 (6.4)				
32 to 84 (813 to 2130), excl	5/16 (7.9)				
84 to 108 (2130 to 2740), excl	3/8 (9.5)				
108 to 140 (2740 to 3580), incl	7/16 (11.1)				
Specified Diameter, in. (mm)	Plasma-Torch-Cut Plate ^B				
	Permissible Variations in Specified Diameter for Thickness Given, in. (mm) ^C				
	Thickness, max. in. (mm)	3/16 to 2 (4.8 to 50.8), excl		2 to 3 (50.8 to 76.2), incl	
+		-	+	-	
19 to 20 (483 to 508), excl	3 (76.2)	1/2 (12.7)	0	5/8 (15.9)	0
20 to 22 (508 to 559), excl	2 3/4 (69.8)	1/2 (12.7)	0	5/8 (15.9)	0
22 to 24 (559 to 610), excl	2 1/2 (63.5)	1/2 (12.7)	0	5/8 (15.9)	0
24 to 28 (610 to 711), excl	2 1/4 (57.3)	1/2 (12.7)	0	5/8 (15.9)	0
28 to 32 (711 to 812), excl	2 (50.8)	1/2 (12.7)	0	5/8 (15.9)	0
32 to 34 (812 to 864), excl	1 3/4 (44.5)	1/2 (12.7)	0
34 to 38 (864 to 965), excl	1 1/2 (38.1)	1/2 (12.7)	0
38 to 40 (965 to 1020), excl	1 1/4 (31.8)	1/2 (12.7)	0
40 to 140 (1020 to 3560), incl	3 (76.2)	1/2 (12.7)	0	5/8 (15.9)	0

^A No permissible variations under.

^B Permissible variations in plasma-torch-cut sketch plates shall be as agreed upon between the manufacturer and the purchaser.

^C The tolerance spread shown may also be obtained all on the minus side or divided between the plus and minus sides if so specified by the purchaser.