
**Wrought aluminium and aluminium
alloys — Extruded rods/bars, tubes and
profiles —**

Part 4:
**Profiles — Tolerances on shape and
dimensions**

iTeh STANDARD PREVIEW

*Aluminium et alliages d'aluminium corroyés — Barres, tubes et
profils filés —*
(standards.iteh.ai)

Partie 4: Profilés — Tolérances sur forme et dimensions
ISO 6362-4:2012

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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. ISO collaborates closely with the International Electrotechnical Commission (IEC) on all matters of electrotechnical standardization.

International Standards are drafted in accordance with the rules given in the ISO/IEC Directives, Part 2.

The main task of technical committees is to prepare International Standards. Draft International Standards adopted by the technical committees are circulated to the member bodies for voting. Publication as an International Standard requires approval by at least 75 % of the member bodies casting a vote.

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. ISO shall not be held responsible for identifying any or all such patent rights.

ISO 6362-4 was prepared by Technical Committee ISO/TC 79, *Light metals and their alloys*, Subcommittee SC 6, *Wrought aluminium and aluminium alloys*.

This second edition cancels and replaces the first edition (ISO 6362-4:1988), which has been technically revised.

ISO 6362 consists of the following parts, under the general title *Wrought aluminium and aluminium alloys — Extruded rods/bars, tubes and profiles*:

- Part 1: *Technical conditions for inspection and delivery*
- Part 2: *Mechanical properties*
- Part 3: *Extruded rectangular bars — Tolerances on shape and dimensions*
- Part 4: *Profiles — Tolerances on shape and dimensions*
- Part 5: *Round, square and hexagonal bars — Tolerances on shape and dimensions*
- Part 6: *Round, square, rectangular and hexagonal tubes — Tolerances on shape and dimensions*
- Part 7: *Chemical composition*

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Wrought aluminium and aluminium alloys — Extruded rods/ bars, tubes and profiles —

Part 4: Profiles — Tolerances on shape and dimensions

1 Scope

This part of ISO 6362 specifies the tolerances on dimensions and shape of wrought aluminium and aluminium alloy extruded profiles with a cross-section contained within a circumscribing circle not greater than 800 mm.

This part of ISO 6362 applies to extruded profiles for general engineering applications only.

2 Normative references

The following referenced documents are indispensable for the application of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

ISO 6362-1, *Wrought aluminium and aluminium alloys — Extruded rods/bars, tubes and profiles — Part 1: Technical conditions for inspection and delivery*

3 Terms and definitions

ISO 6362-4:2012

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For the purposes of this document, the terms and definitions given in ISO 6362-1 apply.

4 Materials

For the purposes of this part of ISO 6362, wrought aluminium and aluminium alloys are divided into two groups, which correspond to varying difficulty when manufacturing the products.

The division into Group I and Group II of the most commonly used general engineering alloys is specified in Tables 1 and 2.

Table 1 — Alloy group I

Alloy system	Alloy number
Pure aluminium	1070, 1070A, 1060, 1050, 1050A, 1100, 1200, 1350
Al-Mn system alloy	3003, 3102, 3103, 3203
Al-Mg system alloy	5005, 5005A, 5051A, 5251
Al-Mg-Si system alloy	6005, 6005A, 6005C, 6008, 6012, 6014, 6018, 6023, 6060, 6061, 6063, 6063A, 6065, 6081, 6082, 6182, 6101, 6101A, 6101B, 6106, 6110A, 6261, 6262, 6262A, 6351, 6360, 6463

Table 2 — Alloy group II (all aluminium alloys except those given in alloy group I)

Alloy system	Alloy number
Al-Mg system alloy	5019, 5049, 5052, 5083, 5086, 5154A, 5454, 5754
Al-Cu-Mg system alloy	2007, 2014, 2014A, 2017, 2017A, 2024, 2030
Al-Zn-Mg system alloy	7204, 7003, 7005, 7020, 7021, 7022, 7049A, 7050, 7075, 7108, 7108A

5 Tolerances on shape and dimensions

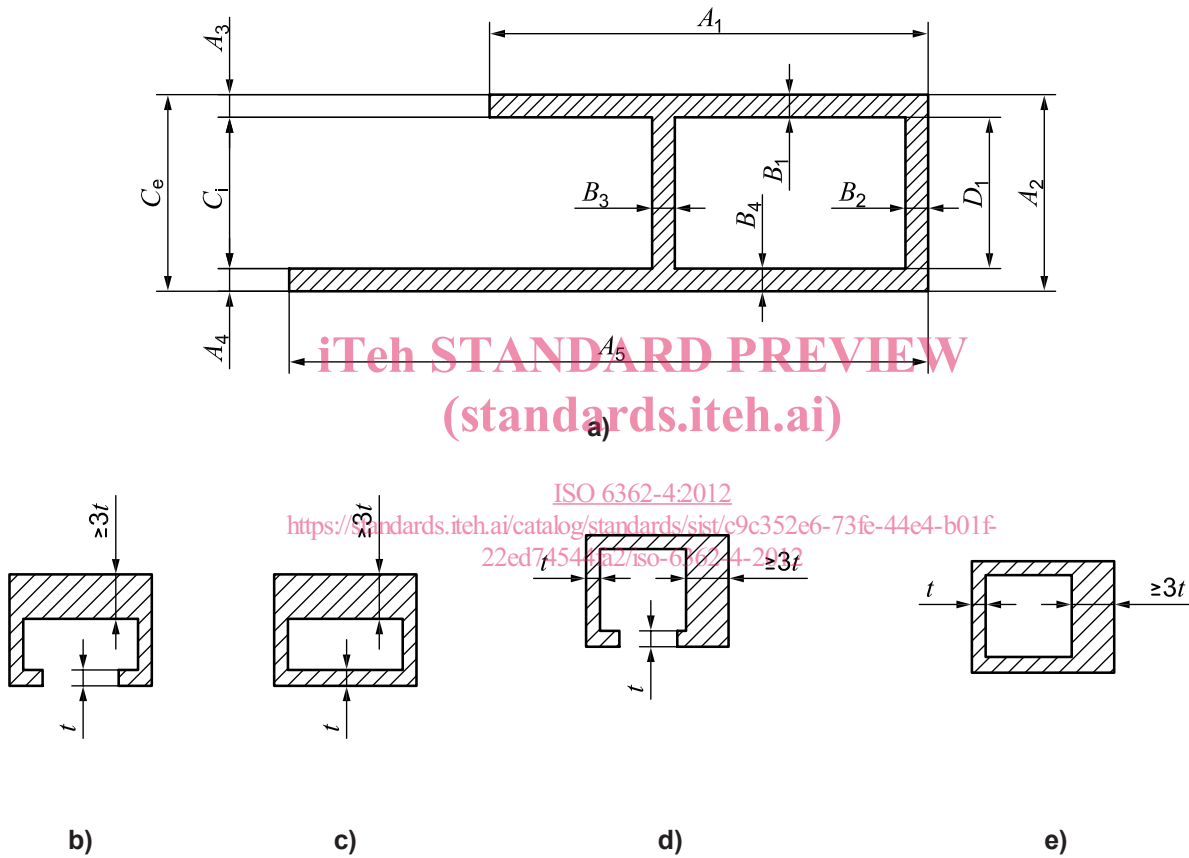
5.1 Dimensional tolerances

5.1.1 General

Tolerances on dimensions (see Figures 1 and 2) are specified in Tables 3 to 5.

The tolerances to be applied to the sectional dimensions as shown in Figure 1, where the nominal thickness of one wall is equal to or greater than three times the thickness of the other wall, t , shall be agreed between the purchaser and supplier.

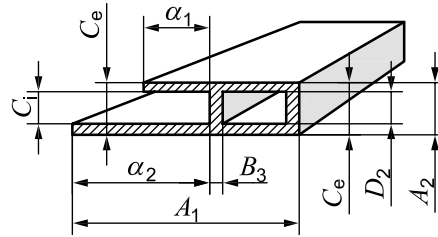
The purchaser should specify whether ordinary or special tolerances are required.



Key

- A_1 to A_5 dimensions of metallic parts except the thickness of wall surface at hollow place (B)
- B_1 to B_4 thickness of wall surface at hollow place
- C_e, C_i dimensions of empty space at opening
- D_1 dimensions of empty space at hollow place

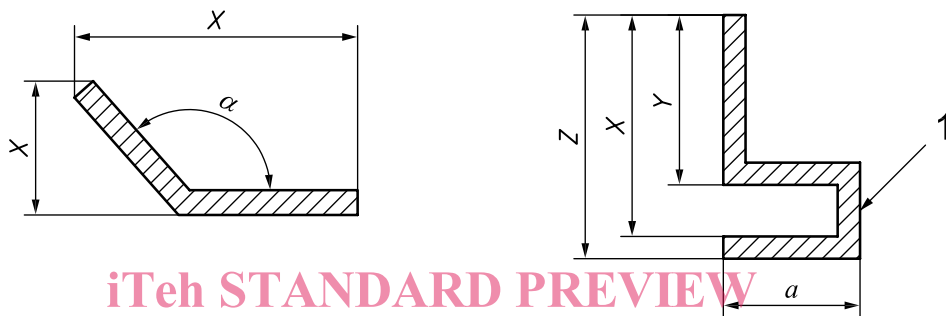
Figure 1 — Sectional dimensions



Key

α_1, α_2 distance between specified point and root of let

Figure 2 — Definition of α_1, α_2 on sectional dimensions



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Figure 3 — Sectional dimensions

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Table 3 — Tolerance (ordinary class) on sectional dimensions

Dimensions in millimetres

Diameter of circumscribing circle ^a		Dimension at specified part		Alloy group		Tolerance ^b													
						Metallic part ^{c,d} (where 75 % or more is metal)						Hollow part (where more than 25 % is hollow space, i.e. less than 75 % is metal) C ₁ or C _e ^e							
						Metallic part other than that in the right column <i>A</i> ₁ , <i>A</i> ₂		Thickness of wall surface at hollow part ^f <i>B</i>		Distance between specified point and root of let <i>c</i> ^g		Distance between specified point and root of let <i>c</i> ^g		Distance between specified point and root of let <i>c</i> ^g		Distance between specified point and root of let <i>c</i> ^g			
250 ≤ <i>D</i>	Alloy group	I	II	I	II	I	II	I	II	I	II	I	II	I	II	I	II		
		± 0,23	± 0,35	± 0,43	± 0,38	± 0,48													
		± 0,27	± 0,42	± 0,39	± 0,45	± 0,58	± 0,51	± 0,64											
		± 0,30	± 0,45	± 0,47	± 0,51	± 0,64	± 0,58	± 0,70	± 0,61	± 0,73									
		± 0,35	± 0,54	± 0,53	± 0,58	± 0,73	± 0,64	± 0,80	± 0,67	± 0,83									
		± 0,38	± 0,57	± 0,60	± 0,64	± 0,80	± 0,70	± 0,86	± 0,77	± 0,91	± 0,89	± 1,0							
		± 0,45	± 0,69	± 0,69	± 0,73	± 0,93	± 0,83	± 1,0	± 0,91	± 1,1	± 1,0	± 1,2							
		± 0,54	± 0,80	± 0,79	± 0,83	± 1,1	± 0,99	± 1,2	± 1,1	± 1,3	± 1,2	± 1,4	± 1,4	± 1,7					
		± 0,92	± 1,4	± 1,1	± 1,2	± 1,6	± 1,5	± 1,9	± 1,7	± 2,1	± 2,0	± 2,3	± 2,3	± 2,7					
		± 1,3	± 2,0	± 1,5	± 1,6	± 2,1	± 2,0	± 2,6	± 2,4	± 2,9	± 2,8	± 3,3	± 3,2	± 3,7					
		± 1,7	± 2,5	± 1,8	± 2,0	± 2,7	± 2,6	± 3,3	± 3,0	± 3,7	± 3,6	± 4,2	± 4,1	± 4,7					
		± 2,1	± 3,1	± 2,1	± 3,0	± 3,2	± 3,2	± 4,0	± 3,7	± 4,5	± 4,3	± 5,4	± 4,9	± 5,7					
250 < <i>D</i> ≤ 800	Alloy group	± 0,54	± 0,80	± 0,64	± 0,90	± 0,69	± 0,93												
		± 0,57	± 0,84	± 0,67	± 0,92	± 0,76	± 1,0	± 1,1											
		± 0,62	± 0,92	± 0,71	± 0,99	± 0,82	± 1,1	± 1,2	± 1,5	± 1,7									
		± 0,65	± 0,96	± 0,78	± 1,1	± 0,93	± 1,2	± 1,3	± 1,6	± 1,7	± 2,0								
		± 0,69	± 1,0	± 0,81	± 1,1	± 1,3	± 1,6	± 1,8	± 2,0	± 2,3	± 2,7	± 2,9							
		± 0,72	± 1,1	± 0,85	± 1,2	± 1,5	± 1,9	± 2,2	± 2,3	± 2,6	± 3,0	± 3,2	± 3,6	± 4,9					
		± 0,92	± 1,4	± 1,2	± 1,6	± 1,9	± 2,2	± 2,6	± 2,6	± 3,0	± 3,3	± 3,6	± 4,6	± 4,9					
		± 1,3	± 2,0	± 1,6	± 2,2	± 1,8	± 2,4	± 2,5	± 3,1	± 2,9	± 3,6	± 4,1	± 4,9	± 5,4					
		± 1,7	± 2,5	± 1,9	± 2,7	± 2,2	± 2,9	± 2,9	± 3,6	± 3,2	± 3,8	± 4,5	± 5,2	± 5,8					
		± 2,1	± 3,1	± 2,3	± 3,2	± 2,5	± 3,5	± 3,2	± 4,0	± 3,5	± 4,3	± 4,9	± 5,4	± 6,2					
		± 2,4	± 3,7	± 2,6	± 3,8	± 2,9	± 4,0	± 3,5	± 4,5	± 3,8	± 4,7	± 5,4	± 6,2	± 6,6					

Table 3 (continued)

		Tolerance ^b															
		Metallic part ^{c,d} (where 75 % or more is metal)						Hollow part (where more than 25 % is hollow space, i.e. less than 75 % is metal) C_1 or C_e									
Diameter of circumscribing circle ^a	Dimension at specified part	Metallic part other than that in the right column ^{A1, A2}		Thickness of wall surface at hollow part ^f B		Distance between specified point and root of let $\alpha\beta$											
		I	II	I	II	5 < $\alpha \leq 15$		15 < $\alpha \leq 30$		30 < $\alpha \leq 60$		60 < $\alpha \leq 100$		100 < $\alpha \leq 150$		150 < $\alpha \leq 200$	
250 < $D \leq 800$	Alloy group	I	II	I	II	I	II	I	II	I	II	I	II	I	II	I	II
	250,00 < $A \leq 300,00$	± 2,8	± 4,2	± 20 %	± 20 %	± 3,0	± 4,3	± 3,2	± 4,5	± 3,8	± 5,0	± 4,1	± 5,2	± 4,7	± 5,8	± 6,0	± 7,0
	300,00 < $A \leq 350,00$	± 3,2	± 4,8	± 20 % but,	± 20 % but,	± 3,3	± 4,8	± 3,6	± 5,0	± 4,1	± 5,5	± 4,4	± 5,6	± 5,0	± 6,3	± 6,2	± 7,4
	350,00 < $A \leq 400,00$	± 3,6	± 5,4	± 3,4 max.	± 3,4 max.	± 3,7	± 5,4	± 3,9	± 5,5	± 4,5	± 5,9	± 4,7	± 6,0	± 5,3	± 6,7	± 6,5	± 7,8
	400,00 < $A \leq 450,00$	± 4,0	± 5,9	± 0,57 min.	± 0,95 min.	± 4,1	± 5,9	± 4,3	± 6,0	± 4,8	± 6,4	± 5,0	± 6,5	± 5,6	± 7,2	± 6,8	± 8,2
	450,00 < $A \leq 500,00$	± 4,4	± 6,5			± 4,4	± 6,4	± 4,6	± 6,5	± 5,1	± 6,9	± 5,3	± 6,9	± 5,9	± 7,6	± 7,1	± 8,6
	500,00 < $A \leq 550,00$	± 4,7	± 7,1			± 4,8	± 7,0	± 4,9	± 7,1	± 5,4	± 7,4	± 5,6	± 7,4	± 6,2	± 8,1	± 7,3	± 9,0
	550,00 < $A \leq 800,00$	± 5,1	± 7,7			± 5,1	± 7,5	± 5,3	± 7,6	± 5,7	± 7,8	± 5,8	± 7,8	± 6,5	± 8,5	± 7,6	± 9,4

NOTE 1 Dimensional tolerances for the space portions of hollow parts shall be as given in Table 5 (column D).

NOTE 2 When either only a minus or plus side tolerance is specified, the value in this table shall be doubled.

a The circumscribing circle is the smallest circle which encloses entirely the cross-section of the shape. However, this dimension may have to be increased when shapes are subjected to corrections of the uneven thickness or in the case of hollow shapes for which the centre of the circumscribing circle needs to be considered, based on the void. These matters should be confirmed with the supplier beforehand as required.

b When the dimensional tolerance is not made equal at the plus side and minus side, determine the value in the column corresponding to the centre of allowable range, and use this value as a standard to decide the tolerance.

c In the case of angled shapes as shown in Figure 3, the tolerances shall be decided not on the base of the length of dimension X, but on the base of the angle α (see 6.6).

d Even when value Y in Figure 3 is equal to or greater than 75 % of value X, these tolerances are not applied to the dimension X or Z. The tolerances for X and Y shall conform to the column corresponding to space dimension C₁ and C_e depending on the distance from the reference base.

e If the purchaser and the supplier agree, the outside dimension C_e may be specified instead of the inside dimension C₁.

f This is applicable when the space volume enveloped with hollow part is 70 mm² or larger. If less than 70 mm², employ column A.

g If 5 mm or under, employ column A.

Table 4 — Tolerance (special class) on sectional dimensions

Dimensions in millimetres

Diameter of circumscribing circle ^a		Dimension at specified part		Metallic part ^{c,d} (where 75 % or more is metal)		Tolerance ^b																																		
				Metallic part other than that in the right column <i>A</i> ₁ , <i>A</i> ₂		Thickness of wall surface at hollow part ^f <i>B</i>		Hollow part (where more than 25 % is hollow space, i.e. less than 75 % is metal) <i>C</i> ₁ or <i>C</i> ₂ ^e						Distance between specified point and root of let <i>αβ</i>																										
								5 < <i>α</i> ≤ 15		15 < <i>α</i> ≤ 30		30 < <i>α</i> ≤ 60		60 < <i>α</i> ≤ 100		100 < <i>α</i> ≤ 150		150 < <i>α</i> ≤ 200																						
250 ≤ <i>D</i>		Alloy group		I	II	I	II	I	II	I	II	I	II	I	II	I	II																							
		<i>A</i> ≤ 3,20	3,20 < <i>A</i> ≤ 6,30	6,30 < <i>A</i> ≤ 12,50	12,50 < <i>A</i> ≤ 20,00	20,00 < <i>A</i> ≤ 25,00	25,00 < <i>A</i> ≤ 40,00	40,00 < <i>A</i> ≤ 50,00	50,00 < <i>A</i> ≤ 100,00	100,00 < <i>A</i> ≤ 150,00	150,00 < <i>A</i> ≤ 200,00	200,00 < <i>A</i> ≤ 250,00	± 0,15	± 0,23	± 0,33	± 0,30	± 0,38	± 0,41	± 0,50	± 0,56	± 0,60	± 0,70	± 0,76	± 0,88	± 1,05	± 1,25	± 1,25	± 2,05	± 2,05	± 2,80	± 3,25									
250 ≤ <i>D</i>		Alloy group		I	II	I	II	± 0,25	± 0,30	± 0,36	± 0,41	± 0,46	± 0,50	± 0,58	± 0,64	± 0,74	± 0,84	± 0,96	± 1,25	± 1,70	± 2,15	± 2,55	± 0,25	± 0,30	± 0,36	± 0,41	± 0,46	± 0,50	± 0,58	± 0,64	± 0,70	± 0,76	± 0,88	± 1,05	± 1,25	± 1,25	± 2,05	± 2,05	± 2,80	± 3,25
		<i>A</i> ≤ 3,20	3,20 < <i>A</i> ≤ 6,30	6,30 < <i>A</i> ≤ 12,50	12,50 < <i>A</i> ≤ 20,00	20,00 < <i>A</i> ≤ 25,00	25,00 < <i>A</i> ≤ 40,00	40,00 < <i>A</i> ≤ 50,00	50,00 < <i>A</i> ≤ 100,00	100,00 < <i>A</i> ≤ 150,00	150,00 < <i>A</i> ≤ 200,00	200,00 < <i>A</i> ≤ 250,00	± 0,15	± 0,23	± 0,36	± 0,46	± 0,54	± 0,60	± 0,86	± 1,10	± 1,35	± 1,65	± 2,30	± 0,25	± 0,30	± 0,36	± 0,41	± 0,46	± 0,50	± 0,58	± 0,64	± 0,70	± 0,76	± 0,88	± 1,05	± 1,25	± 1,25	± 2,05	± 2,05	± 2,80

Table 4 (continued)

Diameter of circumscribing circle ^a	Dimension at specified part	Metallic part ^{c,d} (where 75 % or more is metal)		Tolerance ^b														
		Metallic part other than that in the right column <i>A₁, A₂</i>		Thickness of wall surface at hollow part ^f <i>B</i>		Hollow part (where more than 25 % is hollow space, i.e. less than 75 % is metal) <i>C₁ or C_e</i>						Distance between specified point and root of let <i>αβ</i>						
		I	II	I	II	5 < α ≤ 15		15 < α ≤ 30		30 < α ≤ 60		60 < α ≤ 100		100 < α ≤ 150		150 < α ≤ 200		
250 < D ≤ 800	Alloy group	I	II	I	II	I	II	I	II	I	II	I	II	I	II	I	II	
	<i>A</i> ≤ 3,20	± 0,36	± 0,54			± 0,48	± 0,64	± 0,50	± 0,68									
	3,20 < <i>A</i> ≤ 6,30	± 0,38	± 0,56			± 0,48	± 0,66	± 0,56	± 0,74	± 0,72	± 0,88							
	6,30 < <i>A</i> ≤ 12,50	± 0,41	± 0,60			± 0,50	± 0,72	± 0,60	± 0,80	± 0,76	± 0,96	± 1,25	± 1,45					
	12,50 < <i>A</i> ≤ 20,00	± 0,43	± 0,64			± 0,56	± 0,76	± 0,68	± 0,88	± 1,00	± 1,25	± 1,50	± 1,75					
	20,00 < <i>A</i> ≤ 25,00	± 0,46	± 0,68			± 0,58	± 0,78	± 0,76	± 1,00	± 1,25	± 1,45	± 1,80	± 2,00	± 2,30	± 2,50			
	25,00 < <i>A</i> ≤ 40,00	± 0,48	± 0,72			± 0,60	± 0,84	± 0,86	± 1,10	± 1,50	± 1,75	± 2,05	± 2,25	± 2,55	± 2,75			
	40,00 < <i>A</i> ≤ 50,00	± 0,60	± 0,92	± 15 % but, ± 2,30 max.	± 15 % but, ± 2,30 max.	± 0,86	± 1,15	± 1,10	± 1,40	± 1,80	± 2,10	± 2,30	± 2,60	± 2,80	± 3,10	± 4,30	± 4,60	
	50,00 < <i>A</i> ≤ 100,00	± 0,86	± 1,30	± 2,30 max.	± 2,30 max.	± 1,10	± 1,55	± 1,35	± 1,80	± 2,05	± 2,45	± 2,55	± 2,95	± 3,05	± 3,50	± 4,55	± 5,00	
	100,00 < <i>A</i> ≤ 150,00	± 1,10	± 1,70	± 0,38 min.	± 0,38 min.	± 1,35	± 1,95	± 1,65	± 2,20	± 2,30	± 2,85	± 2,80	± 3,35	± 3,30	± 3,85	± 4,85	± 5,40	
	150,00 < <i>A</i> ≤ 200,00	± 1,35	± 2,05			± 1,65	± 2,30	± 1,90	± 2,65	± 2,55	± 3,25	± 3,05	± 3,75	± 3,55	± 4,25	± 5,10	± 5,75	
	200,00 < <i>A</i> ≤ 250,00	± 1,65	± 2,45			± 1,90	± 2,70	± 2,15	± 2,95	± 2,80	± 3,60	± 3,30	± 4,10	± 3,80	± 4,60	± 5,35	± 6,15	
	250,00 < <i>A</i> ≤ 300,00	± 1,90	± 2,80			± 2,15	± 3,05	± 2,40	± 3,35	± 3,05	± 4,00	± 3,55	± 4,50	± 4,05	± 5,00	± 5,60	± 6,55	
	300,00 < <i>A</i> ≤ 350,00	± 2,15	± 3,20			± 2,40	± 3,45	± 2,65	± 3,70	± 3,30	± 4,35	± 3,80	± 4,90	± 4,30	± 5,40	± 5,85	± 6,90	
	350,00 < <i>A</i> ≤ 400,00	± 2,40	± 3,60			± 2,65	± 3,85	± 2,90	± 4,10	± 3,55	± 4,75	± 4,05	± 5,25	± 4,55	± 5,75	± 6,10	± 7,30	
400,00 < <i>A</i> ≤ 450,00	± 2,65	± 3,95			± 2,90	± 4,20	± 3,15	± 4,45	± 3,80	± 5,15	± 4,30	± 5,65	± 4,85	± 6,15	± 6,35	± 7,65		
500,00 < <i>A</i> ≤ 550,00	± 3,15	± 4,70			± 3,40	± 5,00	± 3,65	± 5,25	± 4,30	± 5,90	± 4,85	± 6,40	± 5,35	± 6,90	± 6,85	± 8,45		
550,00 < <i>A</i> ≤ 800,00	± 3,40	± 5,10			± 3,65	± 5,35	± 3,90	± 5,60	± 4,55	± 6,25	± 5,10	± 6,80	± 5,60	± 7,30	± 7,10	± 8,80		