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## Standard Specification for General Requirements for Wrought Copper and Copper- Alloy Rod, Bar, Shapes and Forgings<sup>1</sup>

This standard is issued under the fixed designation B249/B249M; 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 ( $\epsilon$ ) 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 specification<sup>2</sup> establishes the general requirements common to wrought copper and copper alloy rod, bar, shapes, and forgings which shall apply to Specifications B16/B16M, B21/B21M, B98/B98M, B124/B124M, B138/B138M, B139/B139M, B140/B140M, B150/B150M, B151/B151M, B196/B196M, B283, B301/B301M, B371/B371M, B411/B411M, B441, B453/B453M, B455, B570, and B927 to the extent referenced therein.

1.2 The chemical composition, physical and mechanical properties, and all other requirements not included in this specification are prescribed in the product specification.

1.3 The values stated in inch-pounds units or SI units are to be regarded separately in the standard. Within the text the SI values are given in brackets. The values stated in each system of units are not exact equivalents; each system is independent of the other. Combining values from the two systems may result in nonconformance with the specification.

NOTE 1—Requirements for flat wire (defined as flat products up to and including 0.188 in. thick and up to 1/4 in. in width, with all surfaces rolled or drawn, without having been slit, sheared or sawed) including square, furnished in coils or straight lengths, or on spools, reels, or bucks are described by the wire Specifications B206/B206M and ~~B272/B206/B206M/B272~~ and B272.

1.4 *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 establish appropriate safety and health practices and determine the applicability of regulatory limitations prior to use.*

### 2. Referenced Documents

#### 2.1 ASTM Standards:<sup>3</sup>

B16/B16M Specification for Free-Cutting Brass Rod, Bar and Shapes for Use in Screw Machines

B21/B21M Specification for Naval Brass Rod, Bar, and Shapes

B98/B98M Specification for Copper-Silicon Alloy Rod, Bar and Shapes

B124/B124M Specification for Copper and Copper Alloy Forging Rod, Bar, and Shapes

B138/B138M Specification for Manganese Bronze Rod, Bar, and Shapes

B139/B139M Specification for Phosphor Bronze Rod, Bar, and Shapes

B140/B140M Specification for Copper-Zinc-Lead (Red Brass or Hardware Bronze) Rod, Bar, and Shapes

B150/B150M Specification for Aluminum Bronze Rod, Bar, and Shapes

B151/B151M Specification for Copper-Nickel-Zinc Alloy (Nickel Silver) and Copper-Nickel Rod and Bar

B154 Test Method for Mercurous Nitrate Test for Copper Alloys

B187/B187M Specification for Copper, Bus Bar, Rod, and Shapes and General Purpose Rod, Bar, and Shapes

B193 Test Method for Resistivity of Electrical Conductor Materials

B194 Specification for Copper-Beryllium Alloy Plate, Sheet, Strip, and Rolled Bar

B196/B196M Specification for Copper-Beryllium Alloy Rod and Bar

B206/B206M Specification for Copper-Nickel-Zinc (Nickel Silver) Wire and Copper-Nickel Alloy Wire

<sup>1</sup> This specification is under the jurisdiction of ASTM Committee B05 on Copper and Copper Alloys and is the direct responsibility of Subcommittee B05.02 on Rod, Bar, Wire, Shapes and Forgings.

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<sup>2</sup> For ASME Boiler and Pressure Vessel Code applications see related Specifications SB-249 in Section II of that Code.

<sup>3</sup> 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.

\*A Summary of Changes section appears at the end of this standard.

B272 Specification for Copper Flat Products with Finished (Rolled or Drawn) Edges (Flat Wire and Strip)  
 B283 Specification for Copper and Copper-Alloy Die Forgings (Hot-Pressed)  
 B301/B301M Specification for Free-Cutting Copper Rod, Bar, Wire, and Shapes  
 B371/B371M Specification for Copper-Zinc-Silicon Alloy Rod  
 B411/B411M Specification for Copper-Nickel-Silicon Alloy Rod and Bar  
 B441 Specification for Copper-Cobalt-Beryllium, Copper-Nickel-Beryllium, and Copper-Nickel-Lead-Beryllium Rod and Bar (UNS Nos. C17500, C17510, and C17465)  
 B453/B453M Specification for Copper-Zinc-Lead Alloy (Leaded-Brass) Rod, Bar, and Shapes  
 B455 Specification for Copper-Zinc-Lead Alloy (Leaded-Brass) Extruded Shapes  
 B570 Specification for Copper-Beryllium Alloy (UNS Nos. C17000 and C17200) Forgings and Extrusions  
 B577 Test Methods for Detection of Cuprous Oxide (Hydrogen Embrittlement Susceptibility) in Copper  
 B846 Terminology for Copper and Copper Alloys  
 B858 Test Method for Ammonia Vapor Test for Determining Susceptibility to Stress Corrosion Cracking in Copper Alloys  
 B927 Specification for Brass Rod, Bar, and Shapes  
 B929 Specification for Copper-Nickel-Tin Spinodal Alloy Rod and Bar  
 D4855 Practice for Comparing Test Methods  
 E3 Guide for Preparation of Metallographic Specimens  
 E8 Test Methods for Tension Testing of Metallic Materials  
 E8M Test Methods for Tension Testing of Metallic Materials [Metric]  
 E18 Test Methods for Rockwell Hardness of Metallic Materials  
 E29 Practice for Using Significant Digits in Test Data to Determine Conformance with Specifications  
 E53 Test Method for Determination of Copper in Unalloyed Copper by Gravimetry  
 E54 Test Methods for Chemical Analysis of Special Brasses and Bronzes  
 E62 Test Methods for Chemical Analysis of Copper and Copper Alloys (Photometric Methods)  
 E75 Test Methods for Chemical Analysis of Copper-Nickel and Copper-Nickel-Zinc Alloys  
 E76 Test Methods for Chemical Analysis of Nickel-Copper Alloys  
 E112 Test Methods for Determining Average Grain Size  
 E118 Test Methods for Chemical Analysis of Copper-Chromium Alloys  
 E121 Test Methods for Chemical Analysis of Copper-Tellurium Alloys  
 E255 Practice for Sampling Copper and Copper Alloys for the Determination of Chemical Composition  
 E290 Test Methods for Bend Testing of Material for Ductility  
 E478 Test Methods for Chemical Analysis of Copper Alloys  
 E581 Test Methods for Chemical Analysis of Manganese-Copper Alloys

### 3. Terminology

#### 3.1 Definitions:

3.1.1 *bar, n*—a solid rectangular section, or one with two-plane parallel surfaces and round or other simple regularly shaped finished edges, up to and including 12 in. [300 mm] in width and over 0.188 in. [5 mm] in thickness furnished in straight lengths or in rolls and with finished edges, either rolled, drawn, or extruded.

3.1.2 *bus conductor stock, n*—a bar, rod, or shape of high conductivity copper used to make electrical conductors.

3.1.2.1 *bus bar, n*—of solid or square cross section or a solid section with two plane parallel surfaces and round or other simple regular shaped edges.

3.1.2.2 *bus rod, n*—solid round and regular polygons of six and eight sides.

3.1.2.3 *bus shape, n*—a solid section other than regular rod, bar, plate, sheet, strip, or flat wire, and may be of oval, half oval, half round, triangular, pentagonal, or of any special cross section.

3.1.3 *capable of, adj*—possessing the required properties or characteristics, or both, necessary to conform to specification requirement(s) when subjected to specified test(s).

3.1.4 *coil, n*—a length of the product wound into a series of connected turns. The unqualified term as applied to “flat wire” refers to a coil in which the product is spirally wound, with the successive layers one atop the other (sometimes called a “roll”).

3.1.4.1 *coil, level or traverse wound, n*—a coil in which the turns are positioned into layers parallel to the axis of the coil such that successive turns in a given layer are next to one another.

3.1.4.2 *coil, level or traverse wound on a reel or spool, n*—a coil in which the turns are positioned into layers on a reel or spool parallel to the axis of the reel or spool such that successive turns in a given layer are next to one another.

3.1.4.3 *coil, stagger wound, n*—a coil in which the turns are positioned into layers approximately parallel to the axis of the coil, but not necessarily with the fixed regularity of a level or traverse wound coil.

3.1.5 *length, n*—straight pieces of the product.

3.1.5.1 *lengths, ends, n*—straight pieces, shorter than the nominal length, left over after cutting the product into mill lengths, stock lengths, or specific lengths. They are subject to minimum length and maximum weight requirements.

3.1.5.2 *lengths, mill, n*—straight lengths, including ends, that can be conveniently manufactured in the mill. Full length pieces are usually 10 or 12 ft [3000 or 3600 mm].

3.1.5.3 *lengths, multiple, n*—straight lengths of integral multiples of a base length, with suitable allowance for cutting when specified.

3.1.5.4 *lengths, specific, n*—straight lengths that are uniform in length, as specified, and subject to established length tolerances.

3.1.5.5 *lengths, specific with ends, n*—specific lengths, including ends.

3.1.5.6 *lengths, stock, n*—straight lengths that are mill cut and stored in advance of orders. They are usually 10 or 12 ft [3000 or 3600 mm] and subject to established length tolerances.

3.1.5.7 *lengths, stock with ends, n*—stock lengths, including ends.

3.1.6 *reel or spool, n*—a cylindrical device that has a rim at each end and an axial hole for a shaft or spindle, and on which the product is wound to facilitate handling and shipping.

3.1.7 *rod, n*—a round, regular hexagonal, or regular octagonal solid section furnished in straight lengths (a regular hexagonal or a regular octagonal rod is a solid section having equal sides and equal angles).

3.1.7.1 *rod, piston finish, n*—a round rod having a special surface produced by turning or grinding to close tolerances for diameter and straightness.

3.1.7.2 *rod, shafting, n*—a round rod specially manufactured to the close straightness tolerances required for use in shafting.

3.1.8 *shape, n*—a solid section other than regular rod, bar, plate, sheet, strip, or flat wire, and may be of oval, half oval, half round, triangular, pentagonal, or of any special cross section furnished in straight lengths.

3.1.9 *unaided eye, adj*—visual inspection without the use of special equipment or enhancement excepting the use of corrective lenses.

3.2 For other terms not referenced herein, see Terminology B846.

#### 4. Materials and Manufacture

##### 4.1 Materials:

4.1.1 The materials shall conform to the published compositional requirements of the Copper or Copper Alloy UNS No. designation specified in the ordering information.

4.1.2 In the event heat identification or traceability is required, the purchaser shall specify the details desired.

NOTE 2—Because of the discontinuous nature of the processing of castings into wrought products, it is not always practical to identify specific casting analysis with a specific quantity of finished material.

4.2 *Manufacture*—The product shall be produced by hot working, cold working, or both, and finished by such cold working, annealing or heat treatment and straightening as may be necessary to meet the properties specified.

4.2.1 *Edges*—The edge shall be drawn, extruded, or rolled; refer to Edge Contours in Section 6.

#### 5. Chemical Composition

5.1 The material of manufacture shall conform to the compositional requirements prescribed in the product specification.

5.1.1 When a product (check) sample is analyzed by the purchaser, the material shall conform to the compositional requirements within the permitted analytical variance given in the product specification.

5.2 The composition limits established for the Copper or Copper Alloy UNS No. designation specified in the product specification does not preclude the presence of other elements. Limits may be established and analysis required for unnamed elements by agreement between the manufacturer or supplier and the purchaser.

5.3 When material composition has been determined during the course of manufacture, analysis of the finished product by the manufacturer is not required.

#### 6. Dimensions, Mass and Permissible Variations

6.1 *General*—For the purpose of determining conformance with the dimensional requirements, any measured value outside the specified limiting values for any dimension may be cause for rejection.

NOTE 3—Blank spaces in the tolerance tables indicate either that the material generally is not available or that no tolerances are established.

6.2 *Diameter or Distance Between Parallel Surfaces*—The diameter of round sections or the distance between parallel surfaces in the case of other sections, except shapes, shall not vary from that specified by more than the amounts specified in Tables 1-12, incl, for the product, specification indicated:

*Table 1*—Tolerances for diameter or distance between parallel surfaces of cold-drawn rod applicable to Specifications B16/B16M, B21/B21M, B98/B98M (Copper Alloy UNS No. C65100), B124/B124M (Copper Alloy UNS Nos. C11000, C14500, C14700, C46400, C48200, and C48500), B140/B140M, B301/B301M, B453/B453M, and B927.

*Table 2*—Tolerances for diameter or distance between parallel surfaces of cold-drawn rod applicable to Specifications B98/B98M (Copper Alloy UNS Nos. C65500 and C66100), B124/B124M (Copper Alloy UNS Nos. C27450, C36500, C37000, C37700, C61900, C62300, C63000, C63200, C64200, C64210, C65500, C67500, C67600, C70620, C71520, and C77400), B138/B138M, B139/B139M, B150/B150M, B151/B151M, B196/B196M, B371/B371M, B411/B411M, and B441.

**TABLE 1 Tolerances for Diameter or Distance Between Parallel Surfaces of Cold-Drawn Rod**

(Applicable to Specifications B16/B16M, B21/B21M, B98/B98M (Copper Alloy UNS No. C65100), B124/B124M (Copper Alloy UNS Nos. C11000, C14500, C14700, C46400, C48200, and C48500), B140/B140M, B301/B301M, B453/B453M, and B927.)

Diameter or Distance Between Parallel Surfaces, in. [mm]	Tolerances, Plus and Minus, <sup>A</sup> in. [mm]	
	Round	Hexagonal, Octagonal
Up to 0.150 [3.8], incl	0.0013 [0.035]	0.0025 [0.06]
Over 0.150 to 0.500 [3.8 to 12], incl	0.0015 [0.04]	0.003 [0.08]
Over 0.500 to 1.00 [12 to 25], incl	0.002 [0.05]	0.004 [0.10]
Over 1.00 to 2.00 [25 to 50], incl	0.0025 [0.06]	0.005 [0.13]
Over 2.00 [50]	0.15 <sup>B</sup> [0.15] <sup>B</sup>	0.30 <sup>B</sup> [0.30] <sup>B</sup>

<sup>A</sup> When tolerances are specified as all plus or all minus, double the values given.

<sup>B</sup> Percent of specified diameter or distance between parallel surfaces expressed to the nearest 0.001 in. [0.01 mm].

**TABLE 2 Tolerances for Diameter or Distance Between Parallel Surfaces of Cold-Drawn Rod**

(Applicable to Specifications B98/B98M (Copper Alloy UNS No. C65500 and C66100), B124/B124M (Copper Alloy UNS Nos. C27450, C36500, C37000, C37700, C61900, C62300, C63000, C63200, C64200, C64210, C65500, C67500, C67600, C70620, C71520, and C77400), B138/B138M, B139/B139M, B150/B150M, B151/B151M, B196/B196M, B371/B371M, B411/B411M, and B441.)

Diameter or Distance Between Parallel Surfaces, in. [mm]	Tolerances, Plus and Minus, <sup>A</sup> in. [mm]	
	Round	Hexagonal, Octagonal
Up to 0.150 [3.8], incl	0.002 [0.050]	0.004 [0.10]
Over 0.150 to 0.500 [3.8 to 12], incl	0.002 [0.050]	0.004 [0.10]
Over 0.500 to 1.00 [12 to 25], incl	0.003 [0.08]	0.005 [0.13]
Over 1.00 to 2.00 [25 to 50], incl	0.004 [0.10]	0.006 [0.15]
Over 2.00 [50]	0.20 <sup>B</sup> [0.20] <sup>B</sup>	0.40 <sup>B</sup> [0.40] <sup>B</sup>

<sup>A</sup> When tolerances are specified as all plus or all minus, double the values given.

<sup>B</sup> Percent of specified diameter or distance between parallel surfaces expressed to the nearest 0.001 in. [0.01 mm].

**TABLE 3 Diameter Tolerances for Piston-Finish Rod**

(Applicable to Specifications B21/B21M, B138/B138M, B139/B139M, and B150/B150M.)

Diameter, in. [mm]	Tolerances, Plus and Minus, <sup>A</sup> in. [mm]
Over 0.500 to 1.00 [12 to 25], incl	0.0013 [0.35]
Over 1.00 to 2.00 [25 to 50], incl	0.0015 [0.04]
Over 2.00 [50]	0.10 <sup>B</sup> [0.10] <sup>B</sup>

<sup>A</sup> When tolerances are specified as all plus or all minus, double the values given.

<sup>B</sup> Percent of specified diameter expressed to the nearest 0.0005 in. [0.01 mm].

Table 3—Diameter tolerances for piston finish rod applicable to Specifications B21/B21M, B138/B138M, B139/B139M, and B150/B150M.

Table 4—Tolerances for diameter or distance between parallel surfaces of as-extruded rod and bar applicable to Specifications B21/B21M, B124/B124M (Copper Alloy UNS Nos. C27450, C36500, C37000, C37700, C46400, C48200, C48500, C61900, C62300, C63000, C63200, C64200, C64210, C67500, C67600, C70620, and C71520), B138/B138M (Copper Alloy UNS Nos. C67500 and C67600), and B150/B150M.

Table 5—Tolerances for diameter or distance between parallel surfaces of as-extruded rod and bar applicable to Specifications B98/B98M, B124/B124M (Copper UNS Nos. C11000, C14500, C14700, C65500, and C77400), and B138/B138M (Copper Alloy UNS No. C67000), B196/B196M, B441, and B929.

Table 6—Diameter tolerances for hot-rolled round rod applicable to Specification B98/B98M, B124/B124M, B138/B138M, B150/B150M, B196/B196M, and B441.

Table 7—Thickness tolerances for rectangular and square bar applicable to Specifications B124/B124M (Copper Alloy UNS Nos. C11000, C14500, and C14700) and B301/B301M.

Table 8—Thickness tolerances for rectangular and square bar applicable to Specifications B16/B16M, B21/B21M, B98/B98M, B124/B124M (Copper Alloy UNS No. C65100), B124/B124M (Copper Alloy UNS Nos. C46400,

**TABLE 4 Tolerances for Diameter or Distance Between Parallel Surfaces of As-Extruded Rod and Bar**

(Applicable to Specifications B21/B21M, B124/B124M (Copper Alloy UNS Nos. C27450, C36500, C37000, C37700, C46400, C48200, C48500, C61900, C62300, C63000, C63200, C64200, C64210, C67500, C67600, C70620, and C71520), B138/B138M (Copper Alloy UNS Nos. C67500 and C67600), and B150/B150M.)

Diameter or Distance Between Parallel Surfaces, in. [mm]	Tolerances, Plus and Minus, <sup>A</sup> in. [mm]
	Rod (Round, Hexagonal, and Octagonal) Bar (Rectangular and Square)
Up to 1.00 [25], incl	0.010 [0.25]
Over 1.00 to 2.00 [25 to 50], incl	0.015 [0.38]
Over 2.00 to 3.00 [50 to 75], incl	0.025 [0.65]
Over 3.00 to 3.50 [75 to 90], incl	0.035 [0.90]
Over 3.50 to 4.00 [90 to 100], incl	0.060 [1.5]

<sup>A</sup> When tolerances are specified as all plus or all minus, double the values given.

**TABLE 5 Tolerances for Diameter or Distance Between Parallel Surfaces of As-Extruded Rod and Bar**

(Applicable to Specifications B98/B98M, B124/B124M (Copper UNS Nos. C11000, C14500, C14700 and Copper Alloy UNS Nos. C65500 and C77400), B138/B138M (Copper UNS No. C67000), B196/B196M, B441 and B929.)

Diameter or Distance Between Parallel Surfaces, in. [mm]	Tolerances, Plus and Minus, <sup>A</sup> in. [mm]
	Rod (Round, Hexagonal, and Octagonal) Bar (Rectangular and Square)
Up to 1.00 [25], incl	0.020 [0.50]
Over 1.00 to 2.00 [25 to 50], incl	0.030 [0.75]
Over 2.00 to 3.00 [50 to 75], incl	0.050 [1.3]
Over 3.00 to 3.50 [75 to 90], incl	0.070 [1.8]
Over 3.50 to 4.00 [90 to 100], incl	0.120 [3.0]

<sup>A</sup> When tolerances are specified as all plus or all minus, double the values given.

**TABLE 6 Diameter Tolerances for Hot-Rolled Round Rod**

(Applicable to Specifications B98/B98M, B124/B124M, B138/B138M, B150/B150M, B196/B196M, and B441.)

Diameter, in. [mm]	Tolerances, Plus and Minus, <sup>A</sup> in. [mm]
0.250 [6.35] only	+0.020 [+0.50] -0.010 [-0.25]
Over 0.250 to 0.750 [6.35 to 20], incl	0.015 [0.38]
Over 0.750 to 1.25 [20 to 30], incl	0.020 [0.50]
Over 1.25 to 1.50 [30 to 38], incl	0.030 [0.75]
Over 1.50 to 3.00 [38 to 75], incl	1/16 [1.6]
Over 3.00 [75]	1/8 [3.2]

<sup>A</sup> When tolerances are specified as all plus or all minus, double the values given.

C48200, and C48500), B140/B140M, B453/B453M, and B927.

*Table 9*—Thickness tolerances for rectangular and square bar applicable to Specifications B98/B98M (Copper Alloy UNS Nos. C65500 and C66100), B124/B124M (Copper Alloy UNS Nos. C27450, C36500, C37000, C37700, C61900, C62300, C63000, C63200, C64200, C64210, C65500, C67500, C67600, C70620, C71520, and C77400), B138/B138M, B139/B139M, B150/B150M, B151/B151M, B196/B196M, B411/B411M, B441, and B929.

*Table 10*—Width tolerances for rectangular bar applicable to Specifications B16/B16M, B21/B21M, B98/B98M (Copper Alloy UNS No. C65100), B124/B124M (Copper Alloy UNS Nos. C11000, C14500, C14700, C46400, C48200, and C48500), B140/B140M, B301/B301M, B453/B453M, and B927.

*Table 11*—Width tolerances for rectangular bar applicable to Specifications B98/B98M (Copper Alloy UNS Nos. C65500 and C66100), B124/B124M (Copper Alloy UNS Nos. C27450, C36500, C37000, C37700, C61900, C62300, C63000, C63200, C64200, C64210, C65500, C67500, C67600, C70620, C71520, and C77400), B138/B138M, B139/B139M, B150/B150M, B151/B151M, B196/B196M, B411/B411M, B441, and B929.

*Table 12*—Diameter tolerances for hot-forged rod and bar applicable to Specification B138/B138M.

6.3 *Length*—Rod, bar, and shapes shall be furnished in stock lengths with ends, unless the order specifies stock lengths, specific

**TABLE 7 Thickness Tolerances for Rectangular and Square Bar**  
(Applicable to Specifications B124/B124M, (Copper Alloy UNS Nos. C11000, C14500, and C14700), and B301/B301M.)

Thickness, in. [mm]	Thickness Tolerances, Plus and Minus, <sup>A</sup> in. [mm] for Widths Given in Inches					
	½ [12] and Under	Over ½ to 1¼ [12 to 30] Incl	Over 1¼ to 2 [30 to 50] Incl	Over 2 to 4 [50 to 100] Incl	Over 4 to 8 [100 to 200] Incl	Over 8 to 12 [200 to 300] Incl
Over 0.188 to 0.500 [4.8 to 12], incl	0.003 [0.08]	0.003 [0.08]	0.0035 [0.09]	0.004 [0.10]	0.0045 [0.11]	0.0055 [0.13]
Over 0.500 to 1.00 [12 to 25], incl	...	0.004 [0.10]	0.004 [0.10]	0.0045 [0.11]	0.005 [0.13]	0.006 [0.15]
Over 1.00 to 2.00 [25 to 50], incl	...	0.0045 [0.11]	0.0045 [0.11]	0.005 [0.13]	0.006 [0.15]	...
Over 2.00 to 4.00 [50 to 100], incl	...	...	...	0.30 <sup>B</sup>	...	...

<sup>A</sup> When tolerances are specified as all plus or all minus, double the values given.

<sup>B</sup> Percent of specified thickness expressed to the nearest 0.001 in. [0.01 mm].

**TABLE 8 Thickness Tolerances for Rectangular and Square Bar**

(Applicable to Specifications B16/B16M, B21/B21M, B98/B98M, (Copper Alloy UNS No. 65100), B124/B124M (Copper Alloy UNS Nos. C46400, C48200, and C48500), B140/B140M, B453/B453M, and B927.)

Thickness, in. [mm]	Thickness Tolerances, Plus and Minus, <sup>A</sup> in. for Widths Given in Inches					
	½ and Under	Over ½ to 1¼ Incl	Over 1¼ to 2 Incl	Over 2 to 4 Incl	Over 4 to 8 Incl	Over 8 to 12 Incl
Over 0.188 to 0.500 [4.8 to 12], incl	0.0035 [0.09]	0.004 [0.10]	0.0045 [0.11]	0.0045 [0.11]	0.006 [0.13]	0.008 [0.20]
Over 0.500 to 1.00 [12 to 25], incl	...	0.0045 [0.11]	0.005 [0.13]	0.005 [0.13]	0.007 [0.18]	0.009 [0.23]
Over 1.00 to 2.00 [25 to 50], incl	...	0.005 [0.13]	0.005 [0.13]	0.006 [0.15]	0.008 [0.20]	...
Over 2.00 to 4.00 [50 to 100], incl	...	...	...	0.30 <sup>B</sup>	...	...

<sup>A</sup> When tolerances are specified as all plus or all minus, double the values given.

<sup>B</sup> Percent of specified thickness expressed to the nearest 0.001 in. [0.01 mm].

**TABLE 9 Thickness Tolerances for Rectangular and Square Bar**

(Applicable to Specifications B98/B98M (Copper Alloy UNS Nos. C65500 and C66100), B124/B124M (Copper Alloy UNS Nos. C27450, C36500, C37000, C37700, C61900, C62300, C63000, C63200, C64200, C64210, C65500, C67500, C67600, C70620, C75120, and C77400), B138/B138M, B139/B139M, B150/B150M, B151/B151M, B196/B196M, B411/B411M, B441, and B929.)

Thickness, in. [mm]	Thickness Tolerances, Plus and Minus, <sup>A</sup> in. [mm] for Widths Given in Inches					
	½ [12] and Under	Over ½ to 1¼ [12 to 30] Incl	Over 1¼ to 2 [30 to 50] Incl	Over 2 to 4 [50 to 100] Incl	Over 4 to 8 [100 to 200] Incl	Over 8 to 12 [200 to 300] Incl
Over 0.188 to 0.500 [4.8 to 12], incl	0.005 [0.13]	0.005 [0.13]	0.006 [0.15]	0.007 [0.18]	0.009 [0.23]	0.012 [0.30]
Over 0.500 to 1.00 [12 to 25], incl	...	0.006 [0.15]	0.007 [0.18]	0.008 [0.20]	0.010 [0.25]	0.013 [0.33]
Over 1.00 to 2.00 [25 to 50], incl	...	0.006 [0.15]	0.007 [0.18]	0.009 [0.23]	0.011 [0.28]	...
Over 2.00 to 4.00 [50 to 100], incl	...	...	...	0.50 <sup>B</sup>	...	...

<sup>A</sup> When tolerances are specified as all plus or all minus, double the values given.

<sup>B</sup> Percent of specified thickness expressed to the nearest 0.001 in. [0.1 mm].

**TABLE 10 Width Tolerances for Rectangular Bar**

(Applicable to Specifications B16/B16M, B21/B21M, B98/B98M (Copper Alloy UNS No. C65100), B124/B124M (Copper Alloy UNS Nos. C11000, C14500, C14700, C46400, C48200, and C48500), B140/B140M, B301/B301M, B453/B453M and B927.)

Width, in. [mm]	Tolerances, Plus and Minus, <sup>A</sup> in. [mm]
Over 0.188 to 0.500 [4.8 to 12], incl	0.0035 [0.09]
Over 0.500 to 1.25 [12 to 30], incl	0.005 [0.13]
Over 1.25 to 2.00 [30 to 50], incl	0.008 [0.20]
Over 2.00 to 4.00 [50 to 100], incl	0.012 [0.30] <sup>B</sup>
Over 4.00 to 12.00 [100 to 300], incl	0.30 <sup>B</sup> [0.30]

<sup>A</sup> When tolerances are specified as all plus or all minus, double the values given.

<sup>B</sup> Percent of specified width expressed to the nearest 0.001 in. [0.01 mm].

lengths, or specific lengths with ends as specified in Table 13, Table 14, and Table 15 for the product specification indicated:

*Table 13*—Length tolerances for full-length pieces applicable to Specifications B16/B16M, B21/B21M, B98/B98M, B138/B138M, B139/B139M, B140/B140M, B150/B150M, B151/B151M, B196/B196M, B301/B301M, B371/B371M, B411/B411M, B441, B453/B453M, B927, and B929.

*Table 14*—Schedule of lengths (specific and stock) with ends applicable to Specifications B16/B16M, B21/B21M, B138/B138M (Copper Alloy UNS Nos. C67500 and C67600), B140/B140M, B301/B301M, B453/B453M, B927, and B929.

*Table 15*—Schedule of lengths (specific and stock) with ends applicable to Specifications B98/B98M, B138/B138M (Copper Alloy UNS No. C67000), B139/B139M, B150/B150M, B151/B151M, B196/B196M, B371/B371M, B411/B411M, and B441.

**6.4 Straightness:**

6.4.1 Unless otherwise specified, drawn rod, bar, and shapes, other than shafting rod, piston-finish rod shall be furnished in straight lengths, of which the deviation from straightness shall not exceed the limitations specified in Table 16. To determine