



Designation: ~~E454-80 (Reapproved 2004)~~ Designation: E454 – 09

## Standard Specification for Industrial Perforated Plate and Screens (Square Opening Series)<sup>1</sup>

This standard is issued under the fixed designation E454; 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 reapproval. A superscript epsilon ( $\epsilon$ ) indicates an editorial change since the last revision or reapproval.

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

### INTRODUCTION

Industrial perforated plate can be produced in many thousands of combinations of size and shape of opening, bar size, thickness of material, and type of metal. Such variety is often confusing and, to the vast majority of perforated plate users, unnecessary, since each usually requires only a very few specifications.

The purpose of this specification is to simplify this problem by a condensed table of recommended specifications covering a wide range of openings in which industrial perforated plate is made, with several recommended bar sizes and thicknesses of plate for each opening, for use in various grades of service.

By making selections from this standard, the user will be guided to specifications that are being regularly produced, thus avoiding inadvertent selection of specifications that, because of little or no demand, are unobtainable, except on special order (usually quite expensive unless the quantity ordered is sufficient to justify the cost of special tooling).

If a user has a specific application for industrial perforated plate that can not be solved by a selection from this standard, it is recommended that he consult his perforated plate supplier on the availability of an acceptable alternative specification.

### 1. Scope

1.1 This specification covers the sizes of square opening perforated plate and screens for general industrial uses, including the separating or grading of materials according to designated nominal particle size, and lists standards for openings from 5 in. (125 mm) to 0.127 ( $\frac{1}{8}$ ) in. (3.35 mm) punched with bar sizes and thicknesses of plate for various grades of service. Methods of checking industrial perforated plate and screens are included as information in the Appendix. [2efc598/astm-e454-09](#)

1.2 This specification does not apply to perforated plate or screens with round, hexagon, slotted, or other shaped openings.

~~1.3 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 values stated in inch-pound units are to be regarded as e standard. The values given in parentheses are mathematical conversions to SI units that are provided for information only and are not considered standard. The values stated in inch-pound units are to be regarded as the standard. The values given in parentheses are for information only.

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>2</sup>

E323 [Specification for Perforated-Plate Sieves for Testing Purposes](#)

<sup>1</sup> This specification is under the jurisdiction of ASTM Committee E29 on Particle and Spray Characterization and is the direct responsibility of Subcommittee E29.01 on Sieves, Sieving Methods, and Screening Media.

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<sup>2</sup> For referenced ASTM standards, visit the ASTM website, [www.astm.org](http://www.astm.org), or contact ASTM Customer Service at [service@astm.org](mailto:service@astm.org). For *Annual Book of ASTM Standards* volume information, refer to the standard's Document Summary page on the ASTM website.

2.2 ISO Standards:<sup>3</sup>

ISO 2194-1972, Wire Screens and Plate Screens for Industrial Purposes—Nominal Sizes of Apertures.  
 ISO Recommendation R388-1964, Metric Series for Basic Thicknesses of Sheet and Diameters of Wire.

2.3 Other Documents:

Fed. Std. No. 123 Marking for Shipment (Civil Agencies)<sup>4</sup>  
 Mil-Std-129 Marking for Shipment and Storage<sup>4</sup>

3. Terminology

3.1 Definitions:

- 3.1.1 *aperture or opening, n*—dimensions defining an opening in a screen.
- 3.1.2 *bar, n*—metal between perforations measured at the point where perforations are the closest.
- 3.1.3 *blank, n*—unperforated area located other than along the perimeter of a plate.
- 3.1.4 *break-out, n*—term applied to the action that occurs ahead of the punch in its going through the plate.
  - 3.1.4.1 *Discussion*—The fracturing of the material results in a tapered hole with the small dimensions on the punch side.
- 3.1.5 *centers, n*—dimensional sum of one perforation and one bar or the dimensional distance from the center of one perforation to the center of an adjacent perforation.
- 3.1.6 *die side, n*—surface of the plate that was against the die during the punching operation.
- 3.1.7 *finished end pattern, n*—condition that occurs with some specifications of staggered pattern perforations as a result of tool design in which the pattern is completed on both ends of the plate (Fig. 1).
- 3.1.8 *margin or border, n*—unperforated area located along the perimeter of a plate.
- 3.1.9 *open area, n*—ratio of the total area of the apertures to the total area of the screen, usually expressed in percentage.
- 3.1.10 *perforation, n*—aperture or opening produced by punching.
- 3.1.11 *screen, n*—(1) surface provided with openings of uniform size or (2) machine provided with one or more screen surfaces.
- 3.1.12 *screening, v*—process of separating a mixture of different sizes by means of one or more screen surfaces.
- 3.1.13 *smooth side or punch side, n*—surface of the plate that was uppermost during the punching operation and through which the punch entered the plate.
- 3.1.14 *unfinished end pattern, n*—condition that occurs with some specifications of staggered pattern perforations as a result of tool design.
  - 3.1.14.1 *Discussion*—On one end of the plate, the pattern will appear to be incomplete as a result of unperforated holes in the even numbered rows, while on the other end of the same plate, the pattern will appear to be incomplete because of unperforated holes in the odd numbered rows (Fig. 1).

4. Standard Specifications

34.1 Standard specifications for industrial perforated plate and screens are listed in Table 1.

3.2

4.2 *Openings*—The series of standard openings listed in Table 1 include those of the USA Standard Sieve Series, Specification E323, and those of the ISO apertures for industrial plate screens, ISO 2194-1972, with the addition of those openings in common usage.

3.3

4.3 *Relationship of Grades*—The purpose of the several grades is to provide combinations of opening and bar size for various types of service, from medium-light to heavy. Since it is possible to vary the bar size independently from the plate thickness, each of the service grades lists up to three combinations of bar and gage for each opening. The entire standard series has been designed for a logical relationship of bar size to opening in each grade and between grades with the capability of also being able to vary the plate thickness.

<sup>3</sup> Available from International Organization for Standardization (ISO), 1 rue de Varembe, la Voie-Creuse, Case postale 56, CH-1211, Geneva 20, Switzerland, <http://www.iso.ch>.

<sup>4</sup> Available from Standardization Documents, Order Desk, Bldg. 4 Section D, 700 Robbins Ave., Philadelphia, PA 19111-5098.

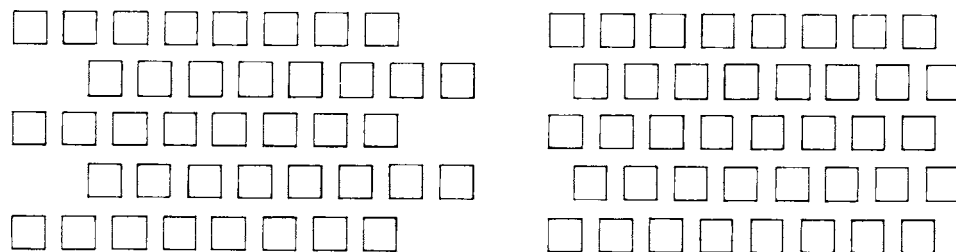


FIG. 1 Unfinished End Pattern Finished End Pattern

**TABLE 1 USA Standard Specifications for Industrial Perforated Plate and Screens (Square Opening Series)—(U.S. Customary Units)**

Perforated Opening		Medium Light				Medium				Medium Heavy				Heavy			
Standard (metric), mm	USA Industrial Standard, in.	Opening, in.	Bar, in.	Gage-Steel, in.	Open Area, percent	Opening, in.	Bar, in.	Gage-Steel, in.	Open Area, percent	Opening, in.	Bar, in.	Gage-Steel, in.	Open Area, percent	Opening, in.	Bar, in.	Gage-Steel, in.	Open Area, percent
125	5	5	1/2	1/2	82.6	5	5/8	5/8	79.0	5	3/4	3/4	75.6	5	1	1	69.4
125	5	5	5/8	5/8	79.0	5	3/4	1/2	75.6	5	7/8	5/8	72.4	5	1 1/8	7/8	66.6
125	5	5	5/8	1/2	79.0	5	3/4	5/8	75.6	5	7/8	3/4	72.4	5	1 1/8	1	66.6
...	...	4 1/2	1/2	1/2	81.0	4 1/2	5/8	5/8	77.1	4 1/2	3/4	3/4	73.4	4 1/2	1	1	66.9
...	...	4 1/2	5/8	3/8	77.1	4 1/2	3/4	1/2	73.4	4 1/2	7/8	5/8	70.1	4 1/2	1 1/8	7/8	64.0
...	...	4 1/2	5/8	1/2	77.1	4 1/2	3/4	5/8	73.4	4 1/2	7/8	3/4	70.1	4 1/2	1 1/8	1	64.0
106	4 1/4	4 1/4	1/2	1/2	80.1	4 1/4	5/8	5/8	76.0	4 1/4	3/4	3/4	72.3	4 1/4	1	1	65.5
106	4 1/4	4 1/4	5/8	3/8	76.0	4 1/4	3/4	1/2	72.3	4 1/4	7/8	5/8	68.8	4 1/4	1 1/8	7/8	62.5
106	4 1/4	4 1/4	5/8	1/2	76.0	4 1/4	3/4	5/8	72.3	4 1/4	7/8	3/4	68.8	4 1/4	1 1/8	1	62.5
100	4	4	1/2	1/2	79.0	4	5/8	5/8	74.8	4	3/4	3/4	70.9	4	1	1	64.0
100	4	4	5/8	3/8	74.8	4	3/4	1/2	70.9	4	7/8	5/8	67.3	4	1 1/8	7/8	60.9
100	4	4	5/8	1/2	74.8	4	3/4	5/8	70.9	4	7/8	3/4	67.3	4	1 1/8	1	60.9
...	...	3 3/4	1/2	1/2	77.9	3 3/4	5/8	5/8	73.5	3 3/4	3/4	3/4	69.4	3 3/4	7/8	7/8	65.7
...	...	3 3/4	5/8	3/8	73.5	3 3/4	3/4	1/2	69.4	3 3/4	7/8	5/8	65.7	3 3/4	1	3/4	62.3
...	...	3 3/4	5/8	1/2	73.5	3 3/4	3/4	5/8	69.4	3 3/4	7/8	3/4	65.7	3 3/4	1	7/8	62.3
90	3 1/2	3 1/2	1/2	1/2	76.6	3 1/2	5/8	5/8	72.0	3 1/2	3/4	3/4	67.8	3 1/2	7/8	7/8	64.0
90	3 1/2	3 1/2	5/8	3/8	72.0	3 1/2	3/4	1/2	67.8	3 1/2	7/8	5/8	64.0	3 1/2	1	3/4	60.5
90	3 1/2	3 1/2	5/8	1/2	72.0	3 1/2	3/4	5/8	67.8	3 1/2	7/8	3/4	64.0	3 1/2	1	7/8	60.5
...	...	3 1/4	3/8	3/8	80.4	3 1/4	1/2	1/2	75.1	3 1/4	5/8	5/8	70.3	3 1/4	3/4	3/4	66.0
...	...	3 1/4	1/2	5/16	75.1	3 1/4	5/8	3/8	70.3	3 1/4	3/4	1/2	66.0	3 1/4	7/8	5/8	62.1
...	...	3 1/4	1/2	3/8	75.1	3 1/4	5/8	1/2	70.3	3 1/4	3/4	5/8	66.0	3 1/4	7/8	3/4	62.1
75	3	3	3/8	3/8	79.0	3	1/2	1/2	73.5	3	5/8	5/8	68.5	3	3/4	3/4	64.0
75	3	3	1/2	5/16	73.5	3	5/8	3/8	68.5	3	3/4	1/2	64.0	3	7/8	5/8	59.9
75	3	3	1/2	3/8	73.5	3	5/8	1/2	68.5	3	3/4	5/8	64.0	3	7/8	3/4	59.9
...	...	2 3/4	3/8	3/8	77.4	2 3/4	1/2	1/2	71.6	2 3/4	5/8	5/8	66.4	2 3/4	3/4	3/4	61.7
...	...	2 3/4	1/2	5/16	71.6	2 3/4	5/8	3/8	66.4	2 3/4	3/4	1/2	61.7	2 3/4	7/8	5/8	57.6
...	...	2 3/4	1/2	3/8	71.6	2 3/4	5/8	1/2	66.4	2 3/4	3/4	5/8	61.7	2 3/4	7/8	3/4	57.6
63	2 1/2	2 1/2	3/8	3/8	75.6	2 1/2	1/2	1/2	69.4	2 1/2	5/8	5/8	64.0	2 1/2	3/4	3/4	59.2
63	2 1/2	2 1/2	1/2	5/16	69.4	2 1/2	5/8	3/8	64.0	2 1/2	3/4	1/2	59.2	2 1/2	7/8	5/8	54.9
63	2 1/2	2 1/2	1/2	3/8	69.4	2 1/2	5/8	1/2	64.0	2 1/2	3/4	5/8	59.2	2 1/2	7/8	3/4	54.9
...	...	2 1/4	3/8	3/8	73.5	2 1/4	1/2	1/2	66.9	2 1/4	5/8	5/8	61.2	2 1/4	3/4	3/4	56.3
...	...	2 1/4	1/2	5/16	66.9	2 1/4	5/8	3/8	61.2	2 1/4	3/4	1/2	56.3	2 1/4	7/8	5/8	51.8
...	...	2 1/4	1/2	3/8	66.9	2 1/4	5/8	1/2	61.2	2 1/4	3/4	5/8	56.3	2 1/4	7/8	3/4	51.8
53	2 1/8	2 1/8	5/16	5/16	76.0	2 1/8	3/8	3/8	72.3	2 1/8	1/2	1/2	65.5	2 1/8	5/8	5/8	59.7
53	2 1/8	2 1/8	3/8	1/4	72.3	2 1/8	1/2	5/16	59.7	2 1/8	5/8	3/8	59.7	2 1/8	3/4	1/2	54.6
53	2 1/8	2 1/8	3/8	5/16	72.3	2 1/8	1/2	3/8	59.7	2 1/8	5/8	1/2	59.7	2 1/8	3/4	5/8	54.6
50	2	2	5/16	5/16	74.8	2	3/8	3/8	70.9	2	1/2	1/2	64.0	2	5/8	5/8	58.0
50	2	2	3/8	1/4	70.9	2	1/2	5/16	64.0	2	5/8	3/8	58.0	2	3/4	1/2	52.9
50	2	2	3/8	5/16	70.9	2	1/2	3/8	64.0	2	5/8	1/2	58.0	2	3/4	5/8	52.9
...	...	1 7/8	5/16	5/16	73.5	1 7/8	3/8	3/8	69.4	1 7/8	1/2	1/2	62.3	1 7/8	5/8	5/8	56.3
...	...	1 7/8	3/8	1/4	69.4	1 7/8	1/2	5/16	62.3	1 7/8	5/8	3/8	56.3	1 7/8	3/4	1/2	51.0
...	...	1 7/8	3/8	5/16	69.4	1 7/8	1/2	3/8	62.3	1 7/8	5/8	1/2	56.3	1 7/8	3/4	5/8	51.0
45	1 3/4	1 3/4	5/16	5/16	72.0	1 3/4	3/8	3/8	67.8	1 3/4	1/2	1/2	60.5	1 3/4	5/8	5/8	54.3
45	1 3/4	1 3/4	3/8	1/4	67.8	1 3/4	1/2	5/16	60.5	1 3/4	5/8	3/8	49.0	1 3/4	3/4	1/2	49.0
45	1 3/4	1 3/4	3/8	5/16	67.8	1 3/4	1/2	3/8	60.5	1 3/4	5/8	1/2	49.0	1 3/4	3/4	5/8	49.0
...	...	1 5/8	1/4	1/4	75.1	1 5/8	5/16	5/16	70.3	1 5/8	3/8	3/8	66.0	1 5/8	1/2	1/2	58.5
...	...	1 5/8	5/16	3/16	70.3	1 5/8	3/8	1/4	66.0	1 5/8	1/2	5/16	58.5	1 5/8	5/8	3/8	52.1
...	...	1 5/8	5/16	1/4	70.3	1 5/8	3/8	5/16	66.0	1 5/8	1/2	3/8	58.5	1 5/8	5/8	1/2	52.1
37.5	1 1/2	1 1/2	1/4	1/4	73.5	1 1/2	5/16	5/16	68.5	1 1/2	3/8	3/8	64.0	1 1/2	1/2	1/2	56.3
37.5	1 1/2	1 1/2	5/16	3/16	68.5	1 1/2	3/8	1/4	64.0	1 1/2	1/2	5/16	56.3	1 1/2	5/8	3/8	49.8
37.5	1 1/2	1 1/2	5/16	1/4	68.5	1 1/2	3/8	5/16	64.0	1 1/2	1/2	3/8	56.3	1 1/2	5/8	1/2	49.8
...	...	1 3/8	1/4	1/4	71.6	1 3/8	5/16	5/16	66.4	1 3/8	3/8	3/8	61.7	1 3/8	1/2	1/2	53.8

Perforated Opening		Medium Light				Medium				Medium Heavy				Heavy			
Standard (metric), mm	USA Industrial Standard, in.	Opening, in.	Bar, in.	Gage-Steel, in.	Open Area, percent	Opening, in.	Bar, in.	Gage-Steel, in.	Open Area, percent	Opening, in.	Bar, in.	Gage-Steel, in.	Open Area, percent	Opening, in.	Bar, in.	Gage-Steel, in.	Open Area, percent
...	...	1 <sup>3</sup> / <sub>8</sub>	5/16	3/16	66.4	1 <sup>3</sup> / <sub>8</sub>	3/8	1/4	61.7	1 <sup>3</sup> / <sub>8</sub>	1/2	5/16	53.8	1 <sup>3</sup> / <sub>8</sub>	5/8	3/8	47.3
...	...	1 <sup>3</sup> / <sub>8</sub>	5/16	1/4	66.4	1 <sup>3</sup> / <sub>8</sub>	3/8	5/16	61.7	1 <sup>3</sup> / <sub>8</sub>	1/2	3/8	53.8	1 <sup>3</sup> / <sub>8</sub>	5/8	1/2	47.3
31.5	1 1/4	1 1/4	1/4	1/4	69.4	1 1/4	5/16	5/16	64.0	1 1/4	3/8	3/8	59.2	1 1/4	1/2	1/2	51.0
31.5	1 1/4	1 1/4	5/16	3/16	64.0	1 1/4	3/8	1/4	59.2	1 1/4	1/2	5/16	51.0	1 1/4	5/8	3/8	44.4
31.5	1 1/4	1 1/4	5/16	1/4	64.0	1 1/4	3/8	5/16	59.2	1 1/4	1/2	3/8	51.0	1 1/4	5/8	1/2	44.4
...	...	1 <sup>3</sup> / <sub>16</sub>	3/16	3/16	74.6	1 <sup>3</sup> / <sub>16</sub>	1/4	1/4	68.2	1 <sup>3</sup> / <sub>16</sub>	5/16	5/16	62.7	1 <sup>3</sup> / <sub>16</sub>	3/8	3/8	57.8
...	...	1 <sup>3</sup> / <sub>16</sub>	1/4	8	68.2	1 <sup>3</sup> / <sub>16</sub>	5/16	3/16	62.7	1 <sup>3</sup> / <sub>16</sub>	3/8	1/4	57.8	1 <sup>3</sup> / <sub>16</sub>	1/2	5/16	49.5
...	...	1 <sup>3</sup> / <sub>16</sub>	1/4	3/16	68.2	1 <sup>3</sup> / <sub>16</sub>	5/16	1/4	62.7	1 <sup>3</sup> / <sub>16</sub>	3/8	5/16	57.8	1 <sup>3</sup> / <sub>16</sub>	1/2	3/8	49.5
...	...	1 1/8	3/16	3/16	73.5	1 1/8	1/4	1/4	66.9	1 1/8	5/16	5/16	61.2	1 1/8	3/8	3/8	56.3
...	...	1 1/8	1/4	8	66.9	1 1/8	5/16	3/16	61.2	1 1/8	3/8	1/4	56.3	1 1/8	1/2	5/16	47.9
...	...	1 1/8	1/4	3/16	66.9	1 1/8	5/16	1/4	61.2	1 1/8	3/8	5/16	56.3	1 1/8	1/2	3/8	47.9
26.5	1 1/16	1 1/16	3/16	3/16	72.2	1 1/16	1/4	1/4	65.5	1 1/16	5/16	5/16	59.7	1 1/16	3/8	3/8	54.6
26.5	1 1/16	1 1/16	1/4	8	65.5	1 1/16	5/16	3/16	59.7	1 1/16	3/8	1/4	54.6	1 1/16	1/2	5/16	46.2
26.5	1 1/16	1 1/16	1/4	3/16	65.5	1 1/16	5/16	1/4	59.7	1 1/16	3/8	5/16	54.6	1 1/16	1/2	3/8	46.2
25	1	1	3/16	3/16	70.9	1	1/4	1/4	64.0	1	5/16	5/16	58.0	1	3/8	3/8	52.9
25	1	1	1/4	8	64.0	1	5/16	3/16	58.0	1	3/8	1/4	52.9	1	1/2	5/16	44.4
25	1	1	1/4	3/16	64.0	1	5/16	1/4	58.0	1	3/8	5/16	52.9	1	1/2	3/8	44.4
...	...	1 <sup>5</sup> / <sub>16</sub>	3/16	3/16	69.4	1 <sup>5</sup> / <sub>16</sub>	1/4	1/4	62.3	1 <sup>5</sup> / <sub>16</sub>	5/16	5/16	56.2	1 <sup>5</sup> / <sub>16</sub>	3/8	3/8	51.0
...	...	1 <sup>5</sup> / <sub>16</sub>	1/4	8	62.3	1 <sup>5</sup> / <sub>16</sub>	5/16	3/16	56.2	1 <sup>5</sup> / <sub>16</sub>	3/8	1/4	51.0	1 <sup>5</sup> / <sub>16</sub>	1/2	3/16	42.5
...	...	1 <sup>5</sup> / <sub>16</sub>	1/4	3/16	62.3	1 <sup>5</sup> / <sub>16</sub>	5/16	1/4	56.2	1 <sup>5</sup> / <sub>16</sub>	3/8	5/16	51.0	1 <sup>5</sup> / <sub>16</sub>	1/2	3/8	42.5
22.4	7/8	7/8	3/16	3/16	67.8	7/8	1/4	1/4	60.5	7/8	5/16	5/16	54.3	7/8	3/8	3/8	49.0
22.4	7/8	7/8	1/4	8	60.5	7/8	5/16	3/16	54.3	7/8	3/8	1/4	49.0	7/8	1/2	5/16	40.5
22.4	7/8	7/8	1/4	3/16	60.5	7/8	5/16	1/4	54.3	7/8	3/8	5/16	49.0	7/8	1/2	3/8	40.5
...	...	1 <sup>3</sup> / <sub>16</sub>	3/16	3/16	66.0	1 <sup>3</sup> / <sub>16</sub>	1/4	1/4	58.5	1 <sup>3</sup> / <sub>16</sub>	5/16	5/16	52.2	1 <sup>3</sup> / <sub>16</sub>	3/8	3/8	46.8
...	...	1 <sup>3</sup> / <sub>16</sub>	1/4	8	58.5	1 <sup>3</sup> / <sub>16</sub>	5/16	3/16	52.2	1 <sup>3</sup> / <sub>16</sub>	3/8	1/4	46.8	1 <sup>3</sup> / <sub>16</sub>	1/2	5/16	38.3
...	...	1 <sup>3</sup> / <sub>16</sub>	1/4	3/16	58.5	1 <sup>3</sup> / <sub>16</sub>	5/16	1/4	52.2	1 <sup>3</sup> / <sub>16</sub>	3/8	5/16	46.8	1 <sup>3</sup> / <sub>16</sub>	1/2	3/8	38.3
19	3/4	3/4	3/16	3/16	64.0	3/4	1/4	1/4	56.3	3/4	5/16	5/16	49.8	3/4	3/8	3/8	44.4
19	3/4	3/4	1/4	8	56.3	3/4	5/16	3/16	49.8	3/4	3/8	1/4	44.4	3/4	1/2	5/16	36.0
19	3/4	3/4	1/4	3/16	56.3	3/4	5/16	1/4	49.8	3/4	3/8	5/16	44.4	3/4	1/2	3/8	36.0
...	...	1 <sup>1</sup> / <sub>16</sub>	3/16	3/16	61.7	1 <sup>1</sup> / <sub>16</sub>	1/4	1/4	53.8	1 <sup>1</sup> / <sub>16</sub>	5/16	5/16	47.2	1 <sup>1</sup> / <sub>16</sub>	3/8	3/8	41.9
...	...	1 <sup>1</sup> / <sub>16</sub>	1/4	8	53.8	1 <sup>1</sup> / <sub>16</sub>	5/16	3/16	47.2	1 <sup>1</sup> / <sub>16</sub>	3/8	1/4	41.9	1 <sup>1</sup> / <sub>16</sub>	1/2	5/16	33.5
...	...	1 <sup>1</sup> / <sub>16</sub>	1/4	3/16	53.8	1 <sup>1</sup> / <sub>16</sub>	5/16	1/4	47.2	1 <sup>1</sup> / <sub>16</sub>	3/8	5/16	41.9	1 <sup>1</sup> / <sub>16</sub>	1/2	3/8	33.5
16	5/8	5/8	5/32	8	64.0	5/8	3/16	3/16	59.2	5/8	1/4	1/4	51.0	5/8	5/16	5/16	44.4
16	5/8	5/8	3/16	10	59.2	5/8	1/4	8	51.0	5/8	5/16	3/16	44.4	5/8	3/8	1/4	39.1
16	5/8	5/8	3/16	8	59.2	5/8	1/4	3/16	51.0	5/8	5/16	1/4	44.4	5/8	3/8	5/16	39.1
...	...	9/16	5/32	8	61.2	9/16	3/16	3/16	56.2	9/16	1/4	1/4	47.9	9/16	5/16	5/16	41.3
...	...	9/16	3/16	10	56.2	9/16	1/4	8	47.9	9/16	5/16	3/16	41.3	9/16	3/8	1/4	36.0
...	...	9/16	3/16	8	56.2	9/16	1/4	3/16	47.9	9/16	5/16	1/4	41.3	9/16	3/8	5/16	36.0
13.2	1 <sup>7</sup> / <sub>32</sub>	1 <sup>7</sup> / <sub>32</sub>	1/8	10	65.5	1 <sup>7</sup> / <sub>32</sub>	5/32	8	59.7	1 <sup>7</sup> / <sub>32</sub>	3/16	3/16	54.6	1 <sup>7</sup> / <sub>32</sub>	1/4	1/4	46.2
13.2	1 <sup>7</sup> / <sub>32</sub>	1 <sup>7</sup> / <sub>32</sub>	5/32	11	59.7	1 <sup>7</sup> / <sub>32</sub>	3/16	10	54.6	1 <sup>7</sup> / <sub>32</sub>	1/4	8	46.2	1 <sup>7</sup> / <sub>32</sub>	5/16	3/16	39.6
13.2	1 <sup>7</sup> / <sub>32</sub>	1 <sup>7</sup> / <sub>32</sub>	5/32	10	59.7	1 <sup>7</sup> / <sub>32</sub>	3/16	8	54.6	1 <sup>7</sup> / <sub>32</sub>	1/4	3/16	46.2	1 <sup>7</sup> / <sub>32</sub>	5/16	1/4	39.6
12.5	1/2	1/2	1/8	10	64.0	1/2	5/32	8	58.0	1/2	3/16	3/16	52.9	1/2	1/4	1/4	44.4
12.5	1/2	1/2	5/32	11	58.0	1/2	3/16	10	52.9	1/2	1/4	8	44.4	1/2	5/16	3/16	37.9
12.5	1/2	1/2	5/32	10	58.0	1/2	3/16	8	52.9	1/2	1/4	3/16	44.4	1/2	5/16	1/4	37.9
...	...	1 <sup>5</sup> / <sub>32</sub>	1/8	10	62.3	1 <sup>5</sup> / <sub>32</sub>	5/32	8	56.2	1 <sup>5</sup> / <sub>32</sub>	3/16	3/16	51.0	1 <sup>5</sup> / <sub>32</sub>	1/4	1/4	42.5
...	...	1 <sup>5</sup> / <sub>32</sub>	5/32	11	56.2	1 <sup>5</sup> / <sub>32</sub>	3/16	10	51.0	1 <sup>5</sup> / <sub>32</sub>	1/4	8	42.5	1 <sup>5</sup> / <sub>32</sub>	5/16	3/16	36.0
...	...	1 <sup>5</sup> / <sub>32</sub>	5/32	10	56.2	1 <sup>5</sup> / <sub>32</sub>	3/16	8	51.0	1 <sup>5</sup> / <sub>32</sub>	1/4	3/16	42.5	1 <sup>5</sup> / <sub>32</sub>	5/16	1/4	36.0
11.2	7/16	7/16	1/8	10	60.5	7/16	5/32	8	54.3	7/16	3/16	3/16	49.0	7/16	1/4	1/4	40.5
11.2	7/16	7/16	5/32	11	54.3	7/16	3/16	10	49.0	7/16	1/4	8	40.5	7/16	5/16	3/16	34.0
11.2	7/16	7/16	5/32	10	54.3	7/16	3/16	8	49.0	7/16	1/4	3/16	40.5	7/16	5/16	1/4	34.0
9.5	3/8	3/8	3/32	11	64.0	3/8	1/8	10	56.3	3/8	5/32	8	49.8	3/8	3/16	3/16	44.4
9.5	3/8	3/8	1/8	12	64.0	3/8	5/32	11	49.8	3/8	3/16	10	44.4	3/8	1/4	8	36.0
9.5	3/8	3/8	1/8	11	56.3	3/8	5/32	10	49.8	3/8	3/16	8	44.4	3/8	1/4	3/16	36.0

Perforated Opening		Medium Light				Medium				Medium Heavy				Heavy			
Standard (metric), mm	USA Industrial Standard, in.	Opening, in.	Bar, in.	Gage-Steel, in.	Open Area, percent	Opening, in.	Bar, in.	Gage-Steel, in.	Open Area, percent	Opening, in.	Bar, in.	Gage-Steel, in.	Open Area, percent	Opening, in.	Bar, in.	Gage-Steel, in.	Open Area, percent
8	5/16	5/16	3/32	11	59.2	5/16	1/8	10	51.0	5/16	5/32	7	44.4	5/16	3/16	3/16	39.0
8	5/16	5/16	1/8	12	51.0	5/16	5/32	11	44.4	5/16	3/16	10	39.0	5/16	1/4	8	30.9
8	5/16	5/16	1/8	11	51.0	5/16	5/32	10	44.4	5/16	3/16	8	39.0	5/16	1/4	3/16	30.9
6.7	17/64	...	...	...	...	17/64	3/32	11	54.6	17/64	1/8	10	46.2	17/64	5/32	8	39.6
6.7	17/64	17/64	3/32	14	54.6	17/64	1/8	12	46.2	17/64	5/32	11	39.6	17/64	3/16	10	34.4
6.7	19/64	17/64	3/32	12	54.6	17/64	1/8	11	46.2	17/64	5/32	11	39.6	17/64	3/16	8	34.4
6.3	1/4	...	...	...	...	1/4	3/32	11	52.9	1/4	1/8	10	44.4	1/4	5/32	8	37.9
6.3	1/4	1/4	3/32	14	52.9	1/4	1/8	12	44.4	1/4	5/32	11	37.9	1/4	3/16	10	32.7
6.3	1/4	1/4	3/32	12	52.9	1/4	1/8	11	44.4	1/4	5/32	10	37.9	1/4	3/16	8	32.7
5.6	7/32	...	...	...	...	...	...	...	...	7/32	3/32	11	49.0	7/32	1/8	10	40.5
5.6	7/32	...	...	...	...	7/32	3/32	14	4.0	7/32	1/8	12	40.5	7/32	5/32	11	34.0
5.6	7/32	...	...	...	...	7/32	3/32	12	49.0	7/32	1/8	11	40.5	7/32	5/32	10	34.0
4.75	3/16	...	...	...	...	...	...	...	...	3/16	3/32	11	44.4	3/16	1/8	10	36.0
4.75	3/16	...	...	...	...	3/16	3/32	14	44.4	3/16	1/4	12	36.0	3/16	5/32	11	29.8
4.75	3/16	...	...	...	...	3/16	3/32	12	44.4	3/16	1/8	11	36.0	3/16	5/32	10	29.8
4	5/32	...	...	...	...	...	...	...	...	...	...	...	...	5/32	3/32	11	39.1
4	5/32	...	...	...	...	...	...	...	...	5/32	3/32	14	39.1	5/32	1/8	12	30.9
4	5/32	...	...	...	...	...	...	...	...	5/32	3/32	12	39.1	5/32	1/8	11	30.9
3.35	1/8	...	...	...	...	...	...	...	...	...	...	...	...	...	...	...	...
3.35	1/8	...	...	...	...	...	...	...	...	...	...	...	...	1/8	3/32	14	32.7
3.25	1/8	...	...	...	...	...	...	...	...	...	...	...	...	1/8	3/32	12	32.7

### 3.4

4.4 **Bar**—A choice of six bars is shown for each standard opening from 5-in. (125-mm) to 0.312-in. (8-mm) opening, inclusive. For practical reasons, the number of bars or grades available for openings finer than 0.312 in. (8 mm) is progressively reduced.

3.54.5 **Gage**—A choice of six gages is shown for each standard opening for 5 in. (125 mm) to 0.312 in. (125 to 8 mm). For practical reasons, the number of gages or grades available for openings finer than 0.312 in. (8 mm) is progressively reduced.

NOTE 1—The gages shown in Table 1 are practical for a low-carbon steel plate. For other materials, consult your perforated plate supplier.

### 3.6

4.6 **Equivalent Metric Specification**—Table A1.1, in the Appendix, Annex A1, shows the equivalent metric specifications to the USA Standard, punched in standard ISO Recommendation R388–1964.

## 4.

### 5. Types of Perforated Pattern

4.1 This 5.1 This specification covers square openings arranged in a staggered pattern with their midpoints nominally at the vertices of isosceles triangles whose bases shall equal their heights, and also covers square openings arranged in line with their midpoints nominally at the vertices of squares (see Fig. 12).

NOTE 2—The percentage of open area for square apertures is identical for both staggered and straight-line patterns (see Fig. 2).

### 5.6. Metal Composition of Plate

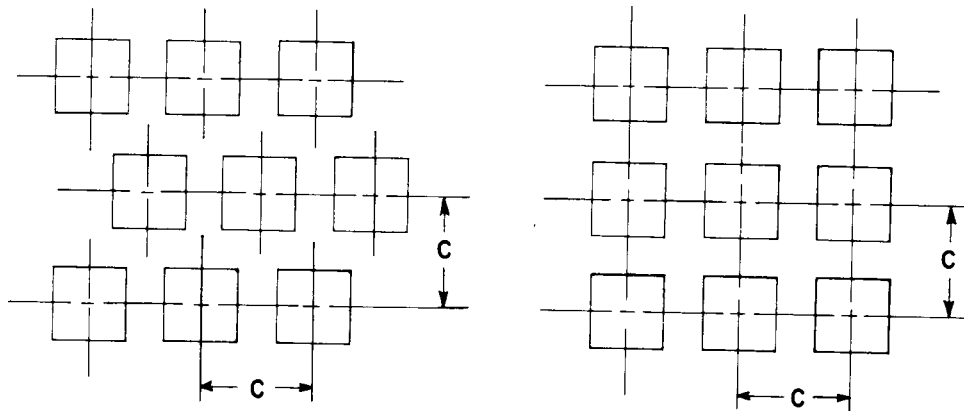
5.6.1 Perforated plate can be punched from a great variety of metals and alloys, but the following are most commonly used:

- Steel, low-carbon
- Steel, high-carbon
- Steel, heat-treated
- Steel, galvanized
- Stainless steel, Type 304
- Stainless steel, Type 316
- Stainless steel, Type 410
- Brass (Cu 80, Zn 20)
- Manganese bronze (Cu 61, Zn 37)
- Monel (high nickel-copper alloy)
- Aluminum (all grades)

## 6.

### 7. Tolerances

6.1



Types of Perforated Pattern

FIG. 2 Staggered Pattern

Straight-Line Pattern

7.1 Openings—Tolerances on openings in USA Standard Specifications for Industrial Perforated Plate and Screens (Table 1 and Table A1.1) shall be in accordance with those listed in Table 2.

TABLE 2 Tolerances on Openings of USA Standard Specifications for Industrial Perforated Plate and Screens

Standard (metric), mm	Perforated Opening		Tolerance on Openings	
	USA Industrial Standard, in.	Additional Sizes, in.	Standard (metric), mm	USA Industrial Standard, in.
125.0	5	...	±2.5	±0.100
...	...	4½	...	±0.090
106.0	4¼	...	±2.1	±0.085
100.0	4	...	±2.0	±0.080
...	...	¾	...	±0.075
90.0	3½	...	±1.8	±0.070
...	...	¾	...	±0.065
75.0	3	...	±1.5	±0.060
...	...	¾	...	±0.055
63.0	2½	...	±1.3	±0.050
...	...	¾	...	±0.045
53.0	2⅛	...	±1.1	±0.043
50.0	2	...	±1.0	±0.040
...	...	⅞	...	±0.038
45.0	1¾	...	±0.9	±0.035
...	...	⅝	...	±0.033
37.5	1½	...	±0.8	±0.030
...	...	⅜	...	±0.028
31.5	1¼	...	±0.6	±0.025
...	...	⅜	...	±0.024
...	...	⅜	...	±0.023
26.5	1⅛	...	±0.5	±0.021
25.0	1	...	±0.5	±0.020
...	...	⅜	...	±0.019
22.4	⅞	...	±0.46	±0.018
...	...	⅜	...	±0.016
19.0	¾	...	±0.38	±0.015
...	...	⅜	...	±0.014
16.0	⅝	...	±0.32	±0.013
...	...	⅜	...	±0.012
13.2	⅞	...	±0.30	±0.012
12.5	½	...	±0.28	±0.011
...	...	⅜	...	±0.011
11.2	⅜	...	±0.28	±0.011
9.5	⅜	...	±0.28	±0.010
8.0	⅜	...	±0.26	±0.010
6.7	⅞	...	±0.25	±0.009
6.3	¼	...	±0.25	±0.009
5.6	⅞	...	±0.24	±0.009
4.75	⅜	...	±0.21	±0.008
4.00	⅜	...	±0.19	±0.007
3.35	0.127 (½)	...	±0.17	±0.006