

## MANUFACTURING TOLERANCES

### THICKNESS TOLERANCE

Table 1:

WIDTH		THICKNESS (+ / - mm)									
		≤6	>6 ≤8	>8 ≤10	>10 ≤13	>13 ≤18	>18 ≤22	>22 ≤30	>30 ≤42	>42 ≤63	>63
≥1600	<1600	0.53	0.60	0.60	0.68	0.83	0.90	1.05	1.28	1.73	2.55
	<2100	0.60	0.68	0.68	0.75	0.90	0.98	1.13	1.35	1.80	2.63
≥2100	<2700	0.75	0.75	0.83	0.90	0.98	1.125	1.28	1.50	1.95	-
≥2700		-	0.98	1.05	1.13	1.20	1.35	1.43	-	-	-

- Notes: 1. Measurement can be conducted anywhere on plate.  
2. All dimensions are in millimetres.

### WIDTH TOLERANCE TRIMMED EDGE PLATE

Table 2:

THICKNESS	<16		≥16 <50		≥50	
WIDTH	PLUS	MINUS	PLUS	MINUS	PLUS	MINUS
<1520	20	0	25	0	25	0
≥1520	20	0	30	0	30	0

Note: All dimensions are in millimetres.

## UNTRIMMED EDGE PLATE

Table 3:

WIDTH (ALL THICKNESS)	PLUS	MINUS
$\leq 1500$	40	0

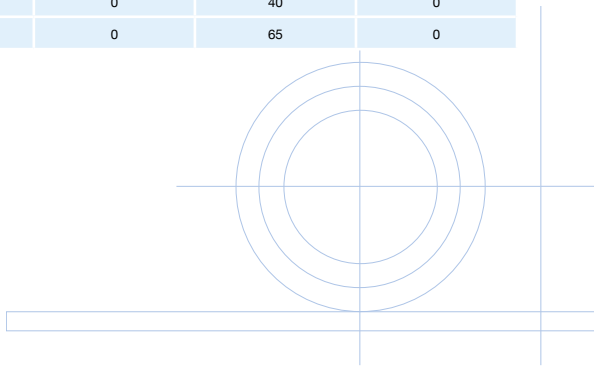
Note: All dimensions are in millimetres.

## LENGTH TOLERANCE

Table 4:

ALL THICKNESS	<25		$\geq 25$	
LENGTH	PLUS	MINUS	PLUS	MINUS
<6000	25	0	30	0
$\geq 6000 < 12000$	30	0	40	0
$\geq 12000$	50	0	65	0

Note: All dimensions are in millimetres.



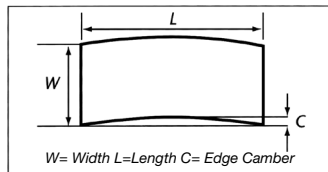
## CAMBER EDGE CAMBER TOLERANCE

Table 5:

SPECIFIED WIDTH	TRIMMED EDGE	UNTRIMMED EDGE
ALL	4	6

Note: All dimensions are in millimetres

Figure 1:



Note: All dimensions are in millimetres

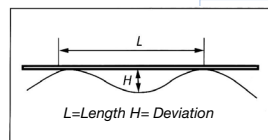
Edge Camber shall be limited so that it shall be possible to inscribe the dimensions of the ordered plate within the delivered size.

## FLATNESS

Measurement of flatness tolerance should be made when the product, resting under its own mass, is placed on a flat horizontal surface.

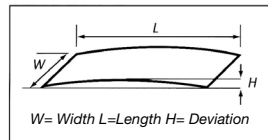
A straight edge shall be placed on the plate and the maximum vertical distance from the plate shall be measured (H).

Figure 2a:



Measurement of Flatness - Waviness.

Figure 2b:



Measurement of Flatness - Bowing.

## BISALLOY MANUFACTURING TOLERANCES

Table 6:

SPECIFIED THICKNESS PLATE (mm)	DISTANCE BETWEEN POINTS OF CONTACT (mm)	SPECIFIED WIDTH OF PLATE (mm)				
		<1500	≥1500 <1800	≥1800 <2400	≥2400 <3000	≥3000
≤6	1000	8	8	8	10	15
	2000	15	15	15	25	30
>8 ≤12	1000	6	6	8	10	15
	2000	10	10	15	20	25
>12 ≤25	1000	6	6	6	10	10
	2000	8	10	12	16	16
>25	1000	6	6	6	6	6
	2000	8	8	10	10	10

### Notes:

1. The tolerances apply when measured at least 20mm from the longitudinal edges and 100mm from the transverse edges.
2. Where the distance between the points of contact is between 500mm and 1000mm, the permissible deviation is obtained as follows.

$$\frac{\text{DISTANCE BETWEEN POINTS OF CONTACT} \times H}{1000}$$

Where H = allowable deviation for 1000mm

Note: This table is an extract of the AS1365 (table 3.4).

However Bisalloy internal manufacturing tolerances are considerably more restrictive.

3. All dimensions are in millimetres.

