

General Requirements: Sheet, Strip, Cold Rolled Sheet, Cold Rolled Strip**1. SCOPE**

1.1 This standard covers the general requirements for steel sheet and strip in coils and cut lengths. It applies to carbon steel and high strength, low alloy steel furnished as sheet, strip, cold rolled sheet and cold rolled strip. Tolerances on dimensions are also included.

1.2 In case of any conflict in requirements, the requirements of the purchase order, the individual material standard, and this general standard shall prevail in the sequence named.

1.3 This standard applies to inch or Imperial size material as well as metric size material.

NOTE: Metric equivalents included in the Inch Tables are supplied for reference purposed only, and shall not replace the actual metric size data given in Tables 3M and 31M.

1.4 Pickled and oiled (P&O) material may be substituted for material specified as hot-rolled (non-P&O) material. Hot-rolled (non-P&O) material may not be substituted for material specified as P&O material, unless written approval is received through the deviation process.

2. RELATED SPECIFICATIONS**2.1 REFERENCE STANDARDS**

The following standards are also applicable to steel sheet and strip.

ASTM A568—Steel, Carbon and High Strength, Low Alloy, Hot Rolled Sheet and Strip, and Cold Rolled Sheet and Strip, General Requirements

ASTM A568M—Steel, Carbon and High Strength Low Alloy and Cold Rolled Sheet, General Requirements (Metric)

ASTM A370—Mechanical Testing of Steel Products

ASTM A749M—Steel, Carbon and High Strength Low Alloy Strip, General Requirements (Metric)

3. DESCRIPTION OF TERMS

For the purpose of this standard the following definitions for steel types will apply:

3.1 Carbon Steel is the designation for steel, when no minimum content is specified or required for aluminum, chromium, cobalt, columbium, molybdenum, nickel, titanium, tungsten, vanadium, zirconium, or any element added to obtain a desired alloying effect; when the specified minimum for copper does not exceed 0.40 percent; or when the maximum content specified for any of the following elements does not exceed percentages noted: manganese 1.65, silicon 0.60, or copper 0.60. Carbon content shall not exceed 0.25 percent.

Small quantities of residual elements such as copper, nickel, molybdenum, chromium, etc., are considered incidental and need not be reported in the chemical analysis.

3.2 High Strength Low Alloy Steel is a specific group in which higher strength, and in some cases additional resistance to atmospheric corrosion are obtained by the addition of moderate amounts of one or more alloying elements.

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3.2.1 Hot rolled high strength low alloy steel sheet is commonly available by size as follows:

INCH	
Width, in.	Thickness, in.
Over 12 to 48, inc.	0.0710 to 0.2299, inc.
Over 48	0.0710 to 0.1799, inc.

For the purposes of this standard the following product types will apply:

3.3 Hot Rolled Sheet is manufactured by hot rolling slabs in a continuous mill to the required thickness and can be supplied in coils or cut

INCH	
Coils and Cut Length	
Width, in.	Thickness, in.
Over 12 to 48, inc.	0.0449 to 0.2299, inc.
Over 48	0.0449 to 0.1799, inc.
Coils Only	
Over 12 to 48, inc.	.2300 to 0.5000, inc.
Over 48	.1800 to 0.5000, inc.

3.4 Hot Rolled Strip is manufactured by hot rolling billets or slabs to the required thickness. It may be produced single width or by rolling multiple width and slitting to the desired width. It can be supplied in coils or lengths as specified.

INCH	
Coils and Cut Length	
Width, in.	Thickness, in.
Up to 3.5, inc.	0.0255 to 0.2030, inc.
Over 3.5 to 6, inc.	0.0344 to 0.02030, inc.
Over 6 to 12, inc.	0.0499 to 0.2299, inc.
Coils Only	
Over 8 to 12, inc.	0.2300 to 0.5000, inc.

METRIC	
Width, mm	Thickness, mm
Over 300 to 1200, inc.	1.8 to 6.0, inc.
Over 1200	1.8 to 4.5, inc.

lengths as specified by the appropriate bulk material code.

3.3.1 Hot rolled carbon steel is commonly available by size as follows:

METRIC	
Coils and Cut Length	
Width, mm	Thickness, mm
Over 300 to 1200, inc.	1.2 to 6.0, inc.
Over 1200	1.2 to 4.5, inc.
Coils Only	
Over 300 to 1200, inc.	Over 6.0 to 12.5, inc.
Over 1200	Over 4.5 to 12.5, inc.

3.4.1 Hot rolled carbon strip is commonly available by sizes as follows:

METRIC	
Coils and Cut Length	
Width, mm	Thickness, mm
Up to 100, inc.	Over 0.65 to 5.0, inc.
Over 100 to 200, inc.	Over 0.9 to 5.0, inc.
Over 200 to 300, inc.	Over 1.2 to 6.0, inc.
Coils Only	
Over 200 to 300, inc.	Over 6.0 to 12.5, inc.



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3.4.2 Hot rolled high strength low alloy strip is commonly available by size as follows:

INCH	
Coil and Cut Length	
Width, in.	Thickness, in.
Up to 6, inc.	0.0710 to 0.2030, inc.
Over 6 to 12, inc.	0.0710 to 0.2299, inc.

METRIC	
Coil and Cut Length	
Width, mm	Thickness, mm
Up to 200, inc.	Over 1.8 to 5.0, inc.
Over 200 to 300, inc.	Over 1.8 to 6.0, inc.

3.5 Cold rolled sheet is manufactured from descaled coils by cold reducing to the desired thickness, generally followed by annealing to recrystallize the grain structure. If the sheet is not annealed after cold reduction, it is known as full hard with a hardness of Rockwell B84 minimum

and can be used for certain end use applications where ductility and flatness are not required.

3.5.1 Cold rolled carbon sheet steel is commonly available by size as follows:

INCH	
Width, in.	Thickness, in.
Over 2 to 12, inc. ^A	0.0142 to 0.0821, inc.
Over 12 to 23 15/16, inc. ^B	0.0142 and thicker
Over 23 15/16	0.0142 and thicker

^A Cold rolled sheet coils and cut lengths, slit from wider coils with cut edge (only) and in thicknesses 0.0142 in (0.36 mm) to 0.0821 in (2.0 mm), inc. carbon 0.25 percent maximum by heat analysis.

^B When no special edge or finish (other than matte, commercial bright, or luster finish) or single strand rolling of widths, or both, under 24 in. (160 mm) is not specific or required.

METRIC	
Width, mm	Thickness, mm
Over 50 to 300, inc. ^A	.35 to 2.0, inc.
Over 300, inc. ^B	.35 and over

^A Cold rolled sheet coils and cut lengths, slit from wider coils with cut edge (only) and in thicknesses 0.35 mm. to 2.0 mm., inc. carbon 0.25 percent maximum by heat analysis.

^B When no special edge or finish (other than matte, commercial bright, or luster finish) or single strand rolling of widths, or both, up to and including 600 mm is not specific or required.

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3.5.2 Cold rolled high strength low alloy sheet steel is commonly available by size as follows:

INCH	
Width, in.	Thickness, in.
Over 2 to 12, inc.	0.0195 to 0.0821, inc.
Over 12	0.0284 and thicker

METRIC	
Width, mm	Thickness, mm
50 to 300, inc. ^A	0.5 to 2.0, inc.
Over 300, inc. ^B	0.7 and Over

^A Cold rolled sheet coils and cut lengths, slit from wider coils with cut edge (only) and in thicknesses 0.50 to 2.0 mm., inc. carbon 0.25 percent maximum by heat analysis.

^B When no special edge or finish (other than matte, commercial bright, or luster finish) or single strand rolling of widths, or both, up to and including 600 mm is not specific or required.

4. REQUIREMENTS

4.1 CHEMICAL REQUIREMENTS—LIMITS

4.1.1 The chemical composition shall be in accordance with the applicable bulk material standard. However, if other compositions are required for carbon steel, they shall be prepared in accordance with the standard chemical ranges and limits as prescribed in Table 1.

4.1.2 Where material is used for fabrication by welding, care must be exercised in selection of chemical composition or mechanical properties to assure compatibility with the welding process and its effect on altering the properties.

4.2 MECHANICAL PROPERTIES

4.2.1 The mechanical property requirements shall be accordance with the applicable Versatile Engineering Standard for the product.

4.2.2 Mechanical testing shall be conducted in accordance with ASTM A370.

4.2.3 Unless otherwise specified in the applicable product standard, test specimens must be prepared in accordance with ASTM A370.

4.3 FINISH

The finish shall be supplied as identified by the appropriate bulk material code and related

Versatile Engineering Standards. Since hot rolled sheet and strip have surfaces with an oxide or scale resulting from the hot rolling operation, the oxide or scale shall be removed by pickling or blast cleaning when required for press-work operations or welding. This shall be identified by the appropriate bulk material code specifying the pickled condition.

4.3.1 Hot rolled sheet can be supplied with mill edges or cut edges as specified.

4.3.1.1 Milled Edges—The natural edges resulting from the hot rolling operation. They may also contain some edge imperfections, the more common types of which are cracked edges, thin edges, (feather), and damaged edges due to handling or processing and which should not extend in beyond the ordered width. These edge conditions are detrimental when joining of mill edges by welding is practiced. When the sheet is to be used in applications involving shearing or blanking, sufficient width allowance should be made to assure obtaining the desired contour and size of the pattern sheet.

4.3.1.2 Cut Edges—The normal edges which result from the shearing, slitting, or trimming of mill edge sheet.

The ends of plain mill edge coils are irregular in shape and are referred to as uncropped ends. The ends shall be uncropped such as pickled or blast cleaned are supplied with square cut ends.

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4.3.2 Hot rolled strip can be supplied with mill edge, square edge, or slit (cut) edges as specified by the appropriate bulk material code.

Square Edges are the edges resulting from rolling through vertical edging rolls during the hot rolling operation. These edges are square and smooth, with the corners slightly rounded.

4.3.3 Cold rolled carbon and low alloy sheet shall be supplied with a matte finish, unless otherwise specified.

Matte Finish is a dull finish, without luster, produced by rolling on rolls which have been roughened by mechanical or chemical means to various degrees of surface texture depending upon the end use. With some surface preparation matte finish is suitable for decorative painting. It is not generally recommended for bright painting.

4.3.4 The cold rolled products covered by this specification are furnished with cut ends, unless otherwise specified.

4.4 OILING

4.4.1 Plain hot rolled sheet and strip is customarily furnished dry, not oiled. Oiling shall be specified by bulk material code, when required.

4.4.2 Hot rolled pickled or descaled sheet and strip product is customarily furnished oiled. If the product is not to be oiled, it shall be specified by the bulk material code.

4.4.3 Cold rolled products covered by this specification can be furnished oiled or not oiled (dry) as specified by the bulk material code.

5. DIMENSIONS

Dimensions, tolerances, and allowances applicable to products covered by this standard are contained in Tables 3 to 32 and Tables 3M to 31M.

6. IDENTIFICATION

MARKING—as a minimum requirement, the material shall be identified by having the manufacturer's name, Versatile Bulk Material Code, weight, purchase order number, and material identification legibly stenciled or shown on a tag attached to each coil or shipping unit.

7. INSPECTION AND TESTING

7.1 HEAT OR CAST ANALYSIS

An analysis of each cast or heat of steel shall be made by the steel manufacturer. In the event that the steel is actually supplied through a steel service center or other distribution center. It is the responsibility of the distribution agency to ensure that the heat is identifiable and the chemical analysis is available as required.

7.2 WORKMANSHIP

7.2.1 Cut lengths shall have a workmanlike appearance and shall not have defects of a nature or degree of the product, the grade, and the quality ordered, that will be detrimental to the fabrication of the finished part.

7.2.2 Coils may contain some abnormal imperfections which render a portion of the coils unusable, however, these should be limited.

7.3 GENERAL

The steel sheets and strips shall meet all specifications in this standard as well as any other requirements for applicable standards.

8. PACKING AND LOADING PRACTICES

8.1 PACKAGE WEIGHT

8.1.1 The package weight shall be shown on the shipping documents.

8.1.2 The maximum package weight, except for coils shall be 10,000 lbs. (4500 kg).

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8.1.3 The maximum package weight for coils shall be 5,000 lbs. (2300 kg).

8.2 PROTECTION REQUIREMENTS

Unless otherwise unspecified, steel strip and sheet shall be shipped uncovered.

8.3 TYPE OF DELIVERY CARRIER

8.3.1 Truck shipments shall be by flat stake trailer.

8.3.2 Rail shipments shall be by covered gondola.

8.4 PLACEMENT OF DELIVERY CARRIER

8.4.1 Package length shall be parallel to carrier length.

8.4.2 Spacing shall be 6 in. (15.2 cm) lengthwise and crosswise between packages if applicable.

8.4.3 Coils shall have the eye horizontal and crosswise to carrier length.

8.4.4 Skids shall be placed lengthwise, and shall have a height of 3 in. (7.6 cm)

8.5 COIL SIZES

8.5.1 The maximum coil O.D. shall be 42 in. (107 cm).

8.5.2 The maximum and minimum coil I.D.s shall be 21 in. (53.3 cm) and 19 in. (48.3 cm), respectively.

8.6 DOCUMENTATION

The appropriate bulk material code shall appear on all documents. All necessary documents requested herein or on the purchase order must be forwarded to the Manager of Quality Assurance; Versatile mfg., prior to, or concurrent with the shipment of steel sheet or strip.

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**Index of Tables for Dimensions, Tolerances, and Allowances
(Inch and Metric)**

Dimensions	Inch Table No.		Metric Table No.	
	Carbon Steel	HSLA	Carbon Steel	HSLA
HOT ROLLED SHEET AND STRIP				
Allowances in width and length	15	N. A.	16 M	N. A.
Camber tolerances, sheet	10	10	11 M	11 M
Diameter tolerances and sheared circles	9	9	10 M	10 M
Flatness tolerances, sheet	13, 14	13, 14	14 M, 15 M	14 M, 15 M
Length tolerances, sheet	8	8	9 M	9 M
Out of square tolerances, sheet	11	11	12 M	12 M
Resquared tolerances, sheet	12	12	13 M	13 M
Thickness tolerances, sheet	3, 3A	3A, 4	3 M, 4 M	5 M, 6 M
Width tolerances of cut edge, sheet	7	7	8 M	8 M
Width tolerances of mill edge, sheet	5	6	7 M	7 M
Camber tolerances, strip	21	21	30 M	30 M
Crown tolerances, strip	17	18	29 M	29 M
Flatness tolerances, strip	22	22	31 M	31 M
Length tolerances, strip	20	20	28 M	28 M
Thickness tolerances, strip	16	16, 16A	25 M, 26 M	25 M, 26 M
Width tolerances, strip	19	19	27 M	27 M
COLD ROLLED SHEET AND STRIP				
Allowances in width and length	32	32	16 M	16 M
Camber tolerances	27, 27A	27, 27A	11 M, 22 M	11 M, 22 M
Diameter tolerances of sheared circles	26	26	10 M	10 M
Flatness tolerances	30, 31	30, 31	23 M, 24 M	23 M, 24 M
Length tolerances	25, 25A	25, 25A	19 M, 20 M	19 M, 20 M
Out of square tolerances	28	28	12 M	12 M
Resquared tolerances	29	29	13 M	13 M
Thickness tolerances, sheet and strip	23, 23A, 23B, 36	23, 23A, 23B	17 M, 18 M	17 M, 18 M
Width tolerances	24, 24A, 33, 34, 35	24, 24A	8 M, 21 M	8 M, 21 M
Crown tolerances	37			
ALL CATEGORIES				
Standard Chemical Ranges and Limits	1	1	1	1
Tolerances for Product Analysis	2	2	2	2



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Table 1: Standard Chemical Ranges and Limits

Carbon Steels Only, Cast or Heat Analysis			
Element	Minimum of Specified Element, %	Range	Lowest Maximum
Carbon (see note)	to 0.15, inc.	0.05	0.08
	over 0.15 to 0.30, inc.	0.06	
	over 0.30 to 0.40, inc.	0.07	
	over 0.40 to 0.60, inc.	0.08	
	over 0.60 to 0.80, inc.	0.11	
	over 0.80 to 1.35, inc.	0.14	
Manganese	to 0.50, inc.	0.20	0.40
	over 1.15 to 1.65, inc.	0.35	
Phosphorus	to 0.08, inc.	0.03	0.04*
	over 0.08 to 0.15, inc.	0.05	
Sulfur	to 0.08, inc.	0.03	0.05*
	over 0.08 to 0.15, inc.	0.05	
	over 0.15 to 0.23, inc.	0.07	
	Over 0.23 to 0.33, inc,	0.10	
Silicon	to 0.15, inc.	0.08	0.10
	Over 0.15 to 0.30, inc.	0.15	
	Over 0.30 to 0.60, inc.	0.30	
Copper	When copper is required 0.20 min. is commonly specified.		

NOTE: The carbon ranges shown in the Range column apply when the specified maximum limit for manganese does not exceed 1.00%. When the maximum manganese limit exceeds 1.00%, all 0.01 to the carbon ranges shown.

* Certain individual specifications provide for lower standard limits for phosphorus and sulfur.

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Table 2: Tolerances for Product Analysis

Element	Limit or Maximum of Specified Element, %	Tolerance	
		Under Minimum Limit	Over Maximum Limit
Carbon	to 0.15, inc.	0.02	0.03
	Over 0.15 to 0.40, inc.	0.03	0.04
	Over 0.40 to 0.80, inc.	0.03	0.05
	Over 0.80	0.03	0.06
Manganese	to 0.60, inc.	0.03	0.03
	Over 0.60 to 1.15, inc.	0.04	0.04
	Over 1.15 to 1.65, inc.	0.05	0.05
Phosphorus			0.01
Sulfur			0.01
Silicon	to 0.30 inc.	0.02	0.03
	Over 0.30 to 0.60, inc.	0.05	0.05
Copper		0.02	

Table 3: Thickness Tolerances of Hot Rolled Sheet (Carbon Steel)
(Coils and Cut Lengths, Including Pickled)

Specified Width, in. (mm)	Thickness Tolerances for Widths & Thicknesses Over/Under, in. (mm), Specified Thickness, in. (mm)					
	0.2299 to 0.1800 (5.84 to 4.57)	0.1799 to 0.0972 (4.57 to 2.47)	0.0971 to 0.0710 (2.46 to 1.80)	0.0709 to 0.0568 (1.79 to 1.44)	0.0567 to 0.0509 (1.43 to 1.29)	0.0508 to 0.0449 (1.28 to 1.14)
Over 12 (300) to 20 (510), inc.	0.007 (0.18)	0.007 (0.18)	0.006 (0.15)	0.006 (0.15)	0.005 (0.13)	0.005 (0.13)
Over 20 (510) to 40 (1020), inc.	0.008 (0.020)	0.007 (0.18)	0.007 (0.018)	0.006 (0.15)	0.005 (0.13)	0.005 (0.13)

NOTE 1: Thickness is measured at any point across the width not less than 3/8 in. (9.5 mm) from a cut edge and not less than 3/4 in. (19 mm) from a mill edge. This table does not apply to the uncropped ends of mill edge coils.

NOTE 2: Regardless of whether total thickness tolerance is specified equally or unequally, over and under the total tolerance should be equal to twice the tabular tolerances.

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Table 3: Thickness Tolerances of Hot Rolled Sheet (Carbon Steel)
(Coils and Cut Lengths, Including Pickled) (Continued)

Specified Width, in. (mm)	Thickness Tolerances for Widths & Thicknesses Over/Under, in. (mm), Specified Thickness, in. (mm)					
	0.2299 to 0.1800 (5.84 to 4.57)	0.1799 to 0.0972 (4.57 to 2.47)	0.0971 to 0.0710 (2.46 to 1.80)	0.0709 to 0.0568 (1.79 to 1.44)	0.0567 to 0.0509 (1.43 to 1.29)	0.0508 to 0.0449 (1.28 to 1.14)
Over 40 (1020) to 48 (1220), inc.	0.009 (0.23)	0.008 (0.20)	0.007 (0.18)	0.006 (0.15)	0.006 (0.15)	0.005 (0.13)
Over 48 (1220) to 60 (1520), inc.		0.008 (0.20)	0.007 (0.18)	0.007 (0.18)	0.006 (0.15)	
Over 60 (1520) to 72 (1830), inc.		0.008 (0.20)	0.008 (0.20)	0.007 (0.18)	0.007 (0.18)	
Over 72 (1830)		0.008 (0.20)	0.008 (0.20)			

Table 3A: Thickness Tolerance of Hot Rolled Sheet Ordered to Theoretical Minimum Weight
(Carbon Steel and HSLA)

Nominal Thickness, inches	Gage Thickness	Maximum Width, inches	Thickness, inches	
			Minimum	Maximum
0.375		60.0	0.355	0.383
0.312		60.0	0.295	0.319
0.250		60.0	0.235	0.259
0.188		60.0	0.180	0.196
0.179	7 gage	60.0	0.170	.0186
0.164	8 gage	60.0	0.155	0.171
0.157		60.0	0.149	0.165
0.135	10 gage	60.0	0.126	0.142
0.120	11 gage	60.0	0.111	.0127
0.105	12 gage	60.0	0.096	0.110
0.090	13 gage	60.0	0.082	0.096
0.075	14 gage	60.0	0.069	0.083
0.060	16 gage	60.0	0.054	0.066

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Table 4: Thickness Tolerances of Hot Rolled Sheet (High Strength Low Alloy Steel)
(Coils and Cut Lengths, Including Pickled)

Specified Width, in. (mm)	Thickness Tolerances for Widths & Thicknesses Over/Under, in. (mm), Specified Thickness, in. (mm)			
	0.2299 to 0.1800 (5.84 to 4.57)	0.1799 to 0.0972 (4.57 to 2.47)	0.0971 to 0.0822 (2.46 to 2.09)	0.0821 to 0.0710 (2.08 to 1.80)
Over 12 (300) to 15 (380), inc.	0.007 (0.18)	0.007 (0.18)	0.006 (0.15)	0.006 (0.15)
Over 15 (380) to 20 (510), inc.	0.008 (0.20)	0.008 (0.20)	0.007 (0.18)	0.007 (0.18)
Over 20 (510) to 32 (810), inc.	0.009 (0.23)	0.008 (0.20)	0.007 (0.18)	0.007 (0.18)
Over 32 (810) to 40 (1020), inc.	0.009 (0.23)	0.009 (0.23)	0.008 (0.20)	0.007 (0.18)
Over 40 (1020) to 48 (1220), inc.	0.010 (0.25)	0.010 (0.25)	0.008 (0.20)	0.007 (0.18)
Over 48 (1220) to 60 (1520), inc.		0.010 (0.25)	0.008 (0.20)	0.007 (0.18)
Over 60 (1520) to 72 (1830), inc.		0.011 (0.28)	0.009 (0.23)	0.008 (0.20)
Over 72 (1830) to 80 (2030), inc.		0.012 (0.30)	0.009 (0.23)	0.008 (0.20)
Over 80 (2030)		0.012 (0.30)	0.010 (0.25)	

NOTE 1: Thickness is measured at any point across the width not less than 3/8 in. (9.5 mm) from a cut edge and not less than 3/4 in. (19 mm) from a mill edge. This table does not apply to the uncropped ends of mill edge coils.

NOTE 2: Regardless of whether total thickness tolerance is specified equally or unequally, over and under the total tolerance should be equal to twice the tabular tolerances.

Table 5: Width Tolerances* of Hot Rolled Mill Edge Sheet (Carbon Steel)
(Coils and Cut Lengths, Including Pickled)

Specified Width, in. (mm)	Tolerance Over Specified Width (No Tolerance Under)	
	in.	mm
Over 12 (300) to 14 (360), inc.	7/16	11.1
Over 14 (360) to 17 (430), inc.	1/2	12.7
Over 17 (430) to 19 (480), inc.	9/16	14
Over 19 (480) to 21 (530), inc.	5/8	16
Over 21 (530) to 24 (610), inc.	11/16	17
Over 24 (610) to 26 (660), inc.	13/16	21
Over 26 (660) to 30 (760), inc.	15/16	24
Over 30 (760) to 50 (1270), inc.	1 1/8	29
Over 50 (1270) to 78 (1980), inc.	1 1/2	38
Over 78 (1980)	1 7/8	48

* The above tolerances do not apply to the uncropped ends of mill edge coils.

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Table 6: Width Tolerances* of Hot Rolled Mill Edge Sheet (High Strength Low Alloy)
(Coils and Cut Lengths, Including Pickled)

Specified Width, in. (mm)	Tolerance Over Specified Width (No Tolerance Under)	
	in.	mm
Over 12 (300) to 14 (360), inc.	7/16	11.1
Over 14 (360) to 17 (430), inc.	1/2	12.7
Over 17 (430) to 19 (480), inc.	9/16	14
Over 19 (480) to 21 (530), inc.	5/8	16
Over 21 (530) to 24 (610), inc.	11/16	17
Over 24 (610) to 26 (660), inc.	13/16	21
Over 26 (660) to 30 (710), inc.	15/16	24
Over 28 (710) to 35 (890), inc.	1 1/8	29
Over 35 (890) to 50 (1270), inc.	1 1/4	32
Over 50 (1270) to 60 (1520), inc.	1 1/2	38
Over 60 (1520) to 65 (1650), inc.	1 5/8	41
Over 65 (1650) to 70 (1789), inc.	1 3/4	44
Over 70 (1780) to 80 (2030), inc.	1 7/8	48
Over 80 (2030)	2	50

* The above tolerances do not apply to the uncropped ends of mill edge coils.

Table 7: Width Tolerances of Hot Rolled Cut Edge Sheet (High Strength Low Alloy)
(Not Resquared, Coils and Cut Lengths, Including Pickled)

Specified Width, in. (mm)	Tolerance Over Specified Width (No Tolerance Under)	
	in.	mm
Over 12 (300) to 30 (760), inc.	1/8	3.2
Over 30 (760) to 48 (1220), inc.	3/16	4.8
Over 48 (1220) to 60 (1520), inc.	1/4	6.4
Over 60 (1520) to 80 (2030), inc.	5/16	7.9
Over 80 (2030)	3/8	9.5

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