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**Method for
Determining
Breakage Allowances
for Sheet Steel**

**SAE Recommended Practice
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METHOD FOR DETERMINING BREAKAGE ALLOWANCES FOR SHEET STEEL

1. **SCOPE:** This method is recommended for establishing breakage allowances for parts fabricated from cut lengths or blanks, or from coils processed directly into a progressive-die pressline, and is equitable to both the sheet producer and the fabricator.
2. **DEFINITION:** Breakage, for the purpose of this proposal, is defined as unrepairable parts, broken during forming and classed as scrap. Parts showing laminations, resulting from pipe, should be excluded provided they are separately identified. Broken parts which can be salvaged are not covered in this proposed method.
3. **METHOD:** This procedure is intended to establish a breakage allowance without the need for re-inspection of each broken stamping. It will apply to overall breakage on a given part (as calculated by the method outlined below) in excess of 1% up to and including 8%. Inherent variations in steel sheet and normal variables in the stamping operation normally preclude 100% satisfactory performance. Therefore, it is generally accepted that practical perfection is attained when 99% of the stampings are produced without breakage. When the overall breakage is in excess of 8%, it is considered to be the result of abnormal forming conditions, and this method does not apply.

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