



MANUFACTURING
TOLERANCE



MANUFACTURING TOLERANCE

All manufacturing tolerances for Bisalloy products conform to AS/NZS1365

THICKNESS TOLERANCE

Width (mm)		Thickness (+/- mm)									
		≤6	>6 ≤8	>8 ≤10	>10 ≤13	>13 ≤18	>18 ≤22	>22 ≤30	>30 ≤42	>42 ≤63	>63
	<1600	0.53	0.60	0.60	0.68	0.83	0.90	1.05	1.28	1.73	2.55
≥1600	<12100	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

Thickness (mm)	<16		≥16 <50		≥50	
	Plus	Minus	Plus	Minus	Plus	Minus
<1520	20	0	25	0	25	0
≥1520	20	0	30	0	30	0

Notes:

All dimensions are in millimetres

UNTRIMMED EDGE PLATE

Width (mm) All Thickness	Plus	Minus
≤1500	40	0

Notes:

All dimensions are in millimetres

LENGTH TOLERANCE

Width (mm) All Thickness	<25		≥25	
	Plus	Minus	Plus	Minus
Length				
<6000	25	0	30	0
≥6000 <1200	30	0	40	0
≥1200	50	0	65	0

Notes:

All dimensions are in millimetres

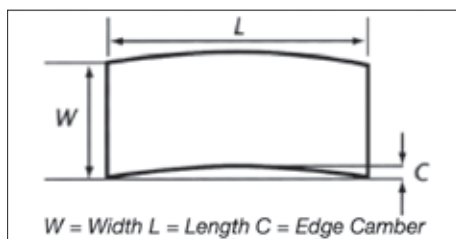
EDGE CAMBER TOLERANCE

Specified Width (mm)	Max Edge Camber C for Trimmed Edge	Max Edge Camber C for Untrimmed Edge
All	0.2% of the length of the plate	0.3% of the length of the plate

Notes:

All dimensions are in millimetres

Figure 1:



Notes:

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 TOLERANCE

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

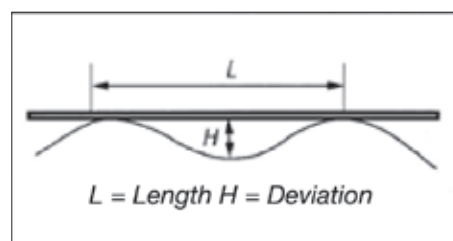
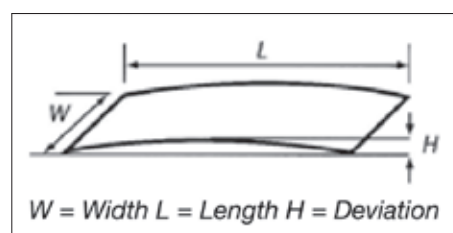


Figure 2b: Measurement of Flatness - Bowing



FLATNESS TOLERANCE TABLE

Specified Thickness Plate (mm)	Distance Between Points of Contact (mm)	Specified Width (mm) of Plate				
		<1500	≥1500 <1800	≥1800 <2400	≥2400 <3000	≥3000
≤8	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 20 mm from the longitudinal edges and 100 mm from the transverse edges
2. Where the distance between the points of contact is between 500 mm and 1000 mm, the permissible deviation is obtained as follows:

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

Where H = allowable deviation for 1000 mm

Note:

This table is an extract of the AS1365

However Bisalloy internal manufacturing tolerances are considerably more restrictive

3. All dimensions are in millimetres