

BAR TOLERANCE AND MACHINING ALLOWANCE FOR HOT ROLLED ALLOY BARS†

Specified Sizes (Rounds or Squares)	Variation from Size		Out of Round or Square	Machining Allowance: Minimum Stock Removal*
	Over	Under		
To 5/16" incl.005"	.005"	.008"	.016"
Over 5/16" to 7/16" incl.006"	.006"	.009"	.016"
Over 7/16" to 1/2" incl.007"	.007"	.010"	.016"
Over 1/2" to 5/8" incl.007"	.007"	.010"	.016"
Over 5/8" to 3/4" incl.008"	.008"	.012"	.021"
Over 3/4" to 7/8" incl.008"	.008"	.012"	.021"
Over 7/8" to 1" incl.009"	.009"	.013"	.023"
Over 1" to 1-1/8" incl.010"	.010"	.015"	.025"
Over 1-1/8" to 1-1/4" incl.011"	.011"	.016"	.028"
Over 1-1/4" to 1-3/8" incl.012"	.012"	.018"	.030"
Over 1-3/8" to 1-1/2" incl.014"	.014"	.021"	.033"
Over 1-1/2" to 2" incl.	1/64"	1/64"	.023"	.042"
Over 2" to 2-1/2" incl.	1/32"	0"	.023"	.052"
Over 2-1/2" to 3-1/2" incl.	3/64"	0"	.035"	.072"
Over 3-1/2" to 4-1/2" incl.	1/16"	0"	.046"	.090"
Over 4-1/2" to 5-1/2" incl.	5/64"	0"	.058"	.110"
Over 5-1/2" to 6-1/2" incl.	1/8"	0"	.070"	.125"
Over 6-1/2" to 8-1/4" incl.	5/32"	0"	.085"	.155"
Over 8-1/4" to 9-1/2" incl.	3/16"	0"	.100"	.203"

*Double the amount shown for proper stock removal on diameter or cross section.

†When length of parts exceeds 6", an additional allowance must be added to eliminate camber.