

RECOMMENDED STOCK REMOVAL FOR HOT ROLLED OR COLD DRAWN ALLOY STEEL BARS SUBJECT TO MAGNETIC PARTICLE INSPECTION†

Hot Rolled Size	Minimum Stock Removal From Surface	Cold Drawn Size
To 1/2" incl.030" To 7/16" incl.
Over 1/2" to 3/4" incl.045" Over 7/16" to 11/16" incl.
Over 3/4" to 1" incl.060" Over 11/16" to 15/16" incl.
Over 1" to 1-1/2" incl.075" Over 15/16" to 1-7/16" incl.
Over 1-1/2" to 2" incl.090"	.. Over 1-7/16" to 1-15/16" incl.
Over 2" to 2-1/2" incl.125"	.. Over 1-15/16" to 2-7/16" incl.
Over 2-1/2" to 3-1/2" incl. ..	.156" Over 2-7/16" to 3-3/8" incl.
Over 3-1/2" to 4-1/2" incl. ..	.187" Over 3-3/8" to 4-3/8" incl.
Over 4-1/2" to 6" incl.250"	

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

Recommended Stock Removal for Cold Drawn Steel Bars **Not** Subject to Magnetic Particle Inspection.

To 5/8" inclusive — .010" per side.

Larger sizes — add .001" per side for each 1/16" increase in diameter.