

## Gauge and Width Tolerances

### Hot Roll Gauge Tolerances

Ordered Minimum Gauges (+ Tolerances)

Restricted Tolerance Capability	0.0511-0.0570	0.0571-0.0710	0.0711-0.0980	0.0981-0.1799	0.1800-0.2299	0.2300-0.3130	0.3131-0.3750	0.3751-0.5000	0.5001-0.6250	0.6251-0.7500
30.000 - 40.000"	0.005	0.006	0.007	0.007	0.008	0.011	0.012	0.014	0.015	0.016
40.001 - 48.000"	0.006	0.006	0.007	0.008	0.009	0.012	0.013	0.014	0.015	0.016
48.001 - 53.000"	0.006	0.007	0.007	0.008	0.010	0.012	0.014	0.015	0.016	0.017

GAUGE ADJUSTMENT FACTORS (skew)	
HSLA	.0025" over the midpoint of tolerance
All others	.0015" over the midpoint of tolerance

### Cold Roll Gauge Tolerances

Standard Tolerance Capability	Under 0.014	0.014 - 0.019	0.0191 - 0.039	0.0391 - 0.057	0.0571 - 0.071	0.0711 - 0.098	0.0981 - 0.142
All Widths	0.001 (+/- .0005)	0.002 (+/- .001)	0.003 (+/- .0015)	0.004 (+/- .002)	0.005 (+/- .0025)	0.005 (+/- .0025)	0.006 (+/- .003)

Restricted Tolerance Capability	Under 0.014	0.014 - 0.019	0.0191 - 0.039	0.0391 - 0.057	0.0571 - 0.071	0.0711 - 0.098	0.0981 - 0.142
All Widths	0.001 (+/- .0005)	0.0015 (+/- .00075)	0.0015 (+/- .00075)	0.002 (+/- .001)	0.0025 (+/- .00125)	0.0025 (+/- .00125)	0.003 (+/- .0015)

(1/4 Standard)      (1/4 Standard)      (1/4 Standard)      (1/4 Standard)      (1/4 Standard)

NOTE: Inquire tolerances tighter than specified in the table above.

### Hot Roll Width Tolerances

EDGE	WIDTH	TOLERANCE
Mill	50" and below	1.125"
Mill	Over 50"	1.5"
Cut	48" and below	0.1875
Cut	Over 48"	0.25"

#### HR WIDTH ADJUSTMENT (OVER-ROLL)

Cut edge with a hot band thickness of .110" or above: **.25" above setpoint**  
 Else (default): **.50" above setpoint**

### Cold Roll Width Tolerances

EDGE	WIDTH	TOLERANCE
Cut	48" and below	0.1875
Cut	Over 48"	0.25"