



Shop Standard Cut/Grinding Tolerances

SHEAR – SHEET/PLATE		
Thickness	Tolerance	Notes
Up to 0.100" incl.	+0.062"/-0"	
0.100" excl. to 0.250" incl.	+0.125"/-0"	
PLATE SAW - PLATE		
Thickness	Tolerance	Notes
0.250" incl. to 2.000" incl.	+0.187"/-0"	
2.000" excl. and above	+0.250"/-0"	
BANDSAW - PLATE		
Thickness	Tolerance	Notes
Up to 0.750" incl.	+0.062"/-0"	
0.750" excl. to 2.000" incl.	+0.125"/-0"	
2.000" excl. and above	+0.187"/-0"	
BAND SAW - BAR		
Diameter	Tolerance	Notes
Up to 6" incl.	+1/8"/-0"	
6" excl. to 10" incl.	+1/4"/-0"	
10" excl. and above	+3/8"/-0"	
ABRASIVE SAW - BAR		
Diameter	Tolerance	Notes
Up to 1.500" incl.	+1/8"/-0"	
STOCK - BAR		
Diameter	Tolerance	Notes
0.125"Ø to 0.3125"Ø excluding	+0.001"/-0.001"	This table references AMS 2241T Table 4a for centerless-ground or polished bars for Steel Alloys. This table references AMS 2261J Table 7A for centerless-ground or polished bars for Nickel/Cobalt Alloys.
0.3125"Ø to 0.500"Ø excluding	+0.0015"/-0.0015"	
0.500"Ø to 1.000"Ø excluding	+0.002"/-0.002"	
1.000"Ø to 1.500"Ø including	+0.0025"/-0.0025"	
Over 1.500"Ø to 3.250"Ø including	+0.003"/-0.003"	
Over 3.250"Ø to 4.062"Ø	+0.005"/-0.005"	

Please note: If the diameter is larger than what is listed on this form, contact the salesperson. If the customer is requesting a tighter tolerance, contact the salesperson. (Custom tolerances will require additional selling costs).



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WATERJET – ALL FLATS (NON-PREMIUM)			
Thickness	Tolerance	Notes	
Up to 0.375" incl.	+0.062"/-0"	All tolerances should be agreed upon between Buyer and Sales on any material that is drawn into a part. Otherwise, the shop will use the following tolerances by thickness of material.	
0.375" excl. to 1.500" incl.	+0.125"/-0"		
1.500" excl. to 3.000" incl.	+0.187"/-0"		
3.000" excl. and above	+0.250"/-0"		
WATERJET – ALL FLATS (PREMIUM)			
Thickness	Tolerance		Notes
	Not ID/Arc	ID/Arc	
Up to 0.5" excl.	+0.005"/-0.005"	+0.010"/-0.010"	Discuss lead-in and lead-out with customer.
0.5" incl. to 1" excl.	+0.010"/-0.010"	+0.015"/-0.015"	
1" incl. to 2" excl.	+0.015"/-0.015"	+0.020"/-0.020"	
2" incl. to 3" excl.	+0.030"/-0.030"	+0.030"/-0.030"	
3" incl. to 3.5" incl.	+0.050"/-0.050"	+0.050"/-0.050"	
PLASMA CUTTER – RINGS			
Thickness	Tolerance		Notes
	Not ID/Arc	ID/Arc	
Up to 0.375" incl.	+0.187"/-0"	-0.187"/-0"	
0.375" excl. to 1.000" incl.	+0.250"/-0"	-0.250"/-0"	
PLASMA CUTTER – SHEET/PLATE/DISKS			
Thickness	Tolerance	Notes	
Up to 0.500" incl.	+0.187"/-0"	Plasma cutting creates a beveled edge. Most material is set to cut at +0.125" on top in order to meet the required tolerance on bottom. Maximum pierce is 1.25" in order to have a good pierce as well as a successful cut.	
0.500" excl. to 1.000" incl.	+0.250"/-0"		
1.000" excl. to 2.500" incl.	+0.375"/-0"		

Please note: If the diameter is larger than what is listed on this form, contact the salesperson. If the customer is requesting a tighter tolerance, contact the salesperson. (Custom tolerances will require additional selling costs).