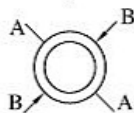




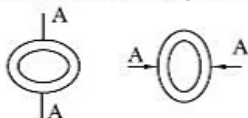
TOLERANCES ON DIAMETER(INSIDE & OUTSIDE) OF EXTRUDED STRUCTURAL TUBES

ALLOWABLE DEVIATION OF MEAN DIA. FROM SPECIFIED DIA. (SIZE TOLERANCE)



Difference between $\frac{1}{2}(AA+BB)$ and specified Diameter

ALLOWABLE DEVIATION OF DIA. AT ANY POINT FROM SPECIFIED DIA. (OVALTY TOLERANCE)



Difference between AA and Specified Diameter

SPECIFIED DIAMETER OUTSIDE OR INSIDE	Allowable Deviation of Mean diameter $1/2(AA+BB)$ from specified dia	Allowable Deviation of dia at any point from specified dia(ovalness tol)
From 9.0 up to 18 mm	0.25 mm	0.50 mm
Above 18 up to 30 mm	0.30 mm	0.60 mm
Above 30 up to 40 mm	0.36 mm	0.80 mm
Above 40 up to 50 mm	0.45 mm	0.90 mm
Above 50 up to 60 mm	0.54 mm	1.00 mm
Above 60 up to 80 mm	0.60 mm	1.30 mm
Over 80 mm	1% of dia	2.5% of dia

TOLERANCES ON WALL THICKNESS OF EXTRUDED STRUCTURAL TUBE

Specified Wall Thickness	Outside Diameter	
	Class 1	Class 2
	\pm	\pm
upto 1.2	0.30	—
1.60	0.30	—
1.80	0.30	—
2.00	0.30	—
2.24	0.30	—
2.50	0.33	—
2.80	0.36	—
3.15	0.40	0.90
3.55	0.43	0.94
4.00	0.48	0.97
4.50	0.51	1.02
5.00	0.56	1.07
5.50	0.61	1.12
6.30	0.67	1.18
7.10	0.76	1.27
8.00	0.97	1.47
9.00	1.10	1.60
10.00	1.22	1.73
11.20	1.28	1.79
12.50	1.35	1.85

NOTE

- 1.For Al-Zn-Mg, Al-Mg and Al-Cu alloys, Class 2 tolerances shall apply.
- 2.For Al, Al-Mn and Al-Mg-Si alloys, Class 1 tolerances shall apply.