

TOLE RANCES
Copper and Copper Alloy Bars and Rods

THIS REVISION CONTAINS ONLY EDITORIAL CHANGES.

1. SCOPE: This specification covers established inch/pound manufacturing tolerances applicable to bars and rods of copper and copper alloys ordered to inch/pound dimensions. These tolerances apply to all conditions, unless otherwise noted. The term "excl" is used to apply only to the higher figure of a specified range. MAM 2221, specified in metric (SI) dimensions, is the equivalent of this AMS.
- 1.1 If the tolerance is expressed as a percentage of a specified dimension, the tolerance so calculated shall be rounded to the nearest 0.001 inch to obtain the permissible tolerance.
2. DIAMETER OR THICKNESS:
- 2.1 Cold Finished:
- 2.1.1 Rods; Rounds, Hexagons, and Octagons:

TABLE I

Specified Diameter or Distance Between Parallel Surfaces Inches	Tolerance, Inch, Plus and Minus			
	Non-refractory		Refractory	
	Round	Hexagonal Octagonal	Round	Hexagonal Octagonal
Up to 0.150, incl	0.0013	0.0025	0.002	--
Over 0.150 to 0.500, incl	0.0015	0.003	0.002	0.004
Over 0.500 to 1.00, incl	0.002	0.004	0.003	0.005
Over 1.00 to 2.00, incl	0.0025	0.005	0.004	0.006
Over 2.00	0.15%	0.30%	0.20%	0.40%

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2.1.2 Bars; Squares and Rectangles:2.1.2.1 Copper:

TABLE II

Specified Thickness Inches	Thickness Tolerance, Inch, Plus and Minus Width Ranges, Inches					
	Up to 0.500, incl	Over 0.500 to 1.250, incl	Over 1.250 to 2.00, incl	Over 2.00 to 4.00, incl	Over 4.00 to 8.00, incl	Over 8.00 to 12.00, incl
Over 0.188 to 0.500, incl	0.003	0.003	0.0035	0.004	0.0045	0.0055
Over 0.500 to 1.00, incl	--	0.004	0.004	0.0045	0.005	0.006
Over 1.00 to 2.00, incl	--	0.0045	0.0045	0.005	0.006	--
Over 2.00 to 4.00, incl	--	--	--	0.30%	--	--

2.1.2.2 Non-Refractory Alloys:

TABLE III

Specified Thickness Inches	Thickness Tolerance, Inch, Plus and Minus Width Ranges, Inches					
	Up to 0.500, incl	Over 0.500 to 1.250, incl	Over 1.250 to 2.00, incl	Over 2.00 to 4.00, incl	Over 4.00 to 8.00, incl	Over 8.00 to 12.00, incl
Over 0.188 to 0.500, incl	0.0035	0.004	0.0045	0.0045	0.006	0.008
Over 0.500 to 1.00, incl	--	0.0045	0.005	0.005	0.007	0.009
Over 1.00 to 2.00, incl	--	0.005	0.005	0.006	0.008	--
Over 2.00 to 4.00, incl	--	--	--	0.30%	--	--

2.1.2.3 Refractory Alloys:

TABLE IV

Specified Thickness Inches	Thickness Tolerance, Inch, Plus and Minus Width Ranges, Inches					
	Up to 0.500, incl	Over 0.500 to 1.250, incl	Over 1.250 to 2.00, incl	Over 2.00 to 4.00, incl	Over 4.00 to 8.00, incl	Over 8.00 to 12.00, incl
Over 0.188 to 0.500, incl	0.005	0.005	0.006	0.007	0.009	0.012
Over 0.500 to 1.00, incl	--	0.006	0.007	0.008	0.010	0.013
Over 1.00 to 2.00, incl	--	0.006	0.007	0.009	0.011	--
Over 2.00 to 4.00, incl	--	--	--	0.50%	--	--

2.2 Extruded Round, Hexagonal, Octagonal, Square, and Rectangular Shapes:

TABLE V

Specified Diameter or Distance Between Parallel Surfaces Inches	Tolerance, Inch, Plus and Minus	
	Non-refractory	Refractory
Up to 1.00, incl	0.010	0.020
Over 1.00 to 2.00, incl	0.015	0.030
Over 2.00 to 3.00, incl	0.025	0.050
Over 3.00 to 3.50, incl	0.035	0.070
Over 3.50 to 4.00, incl	0.060	0.120

2.3 Hot Finished Rounds:

TABLE VI

Specified Diameter Inches	Tolerance, Inch	
	plus	minus
0.250 only	0.020	0.010
Over 0.250 to 0.750, incl	0.015	0.015
Over 0.750 to 1.25, incl	0.020	0.020
Over 1.25 to 1.50, incl	0.030	0.030
Over 1.50 to 3.00, incl	0.0625	0.0625
Over 3.00	0.125	0.125

3. WIDTH:3.1 Rectangles, Not Including Squares:

TABLE VII

Specified Width Inches	Tolerance, Inch, Plus and Minus	
	Copper and Non-Refractory	Refractory
Over 0.188 to 0.500, incl	0.0035	0.005
Over 0.500 to 1.25, incl	0.005	0.007
Over 1.25 to 2.00, incl	0.008	0.010
Over 2.00 to 4.00, incl	0.012	0.015
Over 4.00 to 12.00, incl	0.30%	0.50%

4. LENGTH: Cold finished bars and rods shall not vary from the ordered length by more than -0, +0.375 inches when specific lengths are ordered or by more than -0, +1.0 inch when specific lengths with ends or when stock lengths with or without ends are ordered. No length tolerances are established for extruded and hot rolled rod.

5. STRAIGHTNESS:5.1 Cold Finished Rods; Hexagons, Octagons:

TABLE VIII

Length Feet	Maximum Curvature (Depth of Arc) Inch
Up to 2, excl	1/32
2 to 5, excl	1/32 in any 2 ft of total length
5 to 10, excl	1/8 in any 5 ft of total length
10 and over	1/2 in any 10 ft of total length

- 5.2 Bars; Squares and Rectangles: When supplied in straight lengths, in rolls, or on bucks, shall be of such straightness that the maximum edgewise curvature (depth of arc) shall be not greater than 0.50 inch in any 6 feet of length, or 0.083 inch x length in feet for shorter lengths.

6. FLATNESS: No requirements for AMS.

7. SPECIAL TOLERANCES:

- 7.1 If tolerances specified herein are plus and minus and if all plus or all minus are desired, use the sum of the plus and minus values specified, neglecting the signs.