



AEROSPACE MATERIAL

Society of Automotive Engineers, Inc.
400 COMMONWEALTH DRIVE, WARRENDALE, PA. 15096

SPECIFICATION

AMS 2252B

Superseding AMS 2252A

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TOLERANCES

Low-Alloy Steel Sheet, Strip, and Plate

1. **SCOPE:** This specification covers established manufacturing tolerances for low-alloy steel sheet, strip, and plate. These tolerances apply to all conditions and are based on individual measurements, unless otherwise noted. The term "excl" is used to apply only to the higher figure of the specified range. Tolerances for product sizes not listed herein shall be as agreed upon by purchaser and vendor.
2. **THICKNESS:** Tolerances apply to measurement made at any point on widths less than 1 in. (25 mm), at any point not less than 3/8 in. (9.5 mm) from a cut edge or not less than 3/4 in. (19 mm) from a mill edge on widths 1 in. (25 mm) and over, and at a point 3/8 - 3/4 in. (9.5 - 19 mm) from the longitudinal edge of rectangular sheared plates. Regardless of whether thickness tolerances for sheet and strip are specified equally or unequally, plus and minus, the total tolerance shall be equal to the arithmetic sum of the tabular plus and minus tolerances (twice the tabular tolerances when specified equally plus and minus).

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2.1 Hot Rolled Sheets, Coils and Cut Lengths:

TABLE I

Tolerance, Inch, Plus and Minus
For Width Ranges, Inches

Specified Thickness Inch	Tolerance, Inch, Plus and Minus For Width Ranges, Inches				
	Over 32 to 40, incl	Over 40 48, incl	Over 48 to 60, incl	Over 60 to 72, incl	Over 72 to 80, incl
Over 0.0567 to 0.0709, incl	0.006	0.007	0.008	0.009	--
Over 0.0709 to 0.0821, incl	0.007	0.008	0.009	0.009	--
Over 0.0821 to 0.0971, incl	0.008	0.010	0.010	0.010	0.011
Over 0.0971 to 0.1799, incl	0.009	0.011	0.011	0.011	0.012
Over 0.1799 to 0.2299, incl	0.010	0.012	--	--	--
					Over 80 to 90, incl
					Over 90

TABLE I (SI)

Tolerance, Millimetre, Plus and Minus
For Width Ranges, Millimetres

Specified Thickness Millimetres	Tolerance, Millimetre, Plus and Minus For Width Ranges, Millimetres				
	Over 813 to 1016, incl	Over 1060 to 1219, incl	Over 1219 to 1524, incl	Over 1524 to 1829, incl	Over 1829 to 2032, incl
Over 1.440 to 1.800, incl	0.15	0.18	0.23	--	--
Over 1.800 to 2.085, incl	0.18	0.20	0.23	0.23	--
Over 2.085 to 2.466, incl	0.20	0.23	0.25	0.25	0.28
Over 2.466 to 4.569, incl	0.23	0.25	0.28	0.28	0.30
Over 4.569 to 5.839, incl	0.25	0.28	--	--	--
					Over 2032 to 2286, incl
					Over 2286

2.2 Cold Rolled Sheets, Coils and Cut Lengths:

TABLE II

Tolerance, Inch, Plus and Minus
For Width Ranges, Inches

Specified Thickness Inch	Tolerance, Inch, Plus and Minus For Width Ranges, Inches					
	Over 24 to 32, incl	Over 32 to 40, incl	Over 40 to 48, incl	Over 48 to 60, incl	Over 60 to 70, incl	Over 70 to 80, incl
0.0195 to 0.0313, incl	0.003	0.003	0.003	0.003	--	--
Over 0.0313 to 0.0508, incl	0.004	0.004	0.004	0.004	0.005	--
Over 0.0508 to 0.0567, incl	0.005	0.005	0.005	0.005	0.006	--
Over 0.0567 to 0.0709, incl	0.005	0.005	0.005	0.006	0.006	--
Over 0.0709 to 0.0821, incl	0.005	0.006	0.006	0.006	0.007	--
Over 0.0821 to 0.0971, incl	0.006	0.007	0.007	0.008	0.009	--
Over 0.0971 to 0.1419, incl	0.007	0.008	0.009	0.010	0.010	0.012
Over 0.1419 to 0.1799, incl	0.008	0.009	0.010	0.010	0.011	0.012
Over 0.1799 to 0.2299, incl	0.008	0.009	0.010	--	--	--

TABLE II (SI)

Tolerance, Millimetre, Plus and Minus
For Width Ranges, Millimetres

Specified Thickness Millimetres	Tolerance, Millimetre, Plus and Minus For Width Ranges, Millimetres					
	Over 610 to 813, incl	Over 813 to 1016, incl	Over 1016 to 1219, incl	Over 1219 to 1524, incl	Over 1524 to 1778, incl	Over 1778 to 2032, incl
0.495 to 0.795, incl	0.08	0.08	0.08	0.08	--	--
Over 0.795 to 1.290, incl	0.10	0.10	0.10	0.10	0.13	--
Over 1.290 to 1.440, incl	0.13	0.13	0.13	0.13	0.15	--
Over 1.440 to 1.801, incl	0.13	0.13	0.13	0.15	0.15	--
Over 1.801 to 2.085, incl	0.13	0.15	0.15	0.15	0.18	--
Over 2.085 to 2.466, incl	0.15	0.18	0.18	0.20	0.23	--
Over 2.466 to 3.604, incl	0.18	0.20	0.23	0.25	0.28	0.30
Over 3.604 to 4.569, incl	0.20	0.23	0.25	0.25	0.30	0.30
Over 4.569 to 5.839, incl	0.20	0.23	0.25	--	--	--

2.3 Hot Rolled Strip, Coils and Cut Lengths, Including Crowns:

TABLE III

Specified Thickness Inch	Tolerance, Inch							
	For Width Ranges, Inches							
	Up to 1, incl	Over 1 to 3-1/2, incl	Over 3-1/2 to 6, incl	Over 6 to 12, incl	Over 12 to 15, incl	Over 15 to 20, incl	Over 20 to 23-15/16, incl	
0.0568 to 0.0709, incl	+0.005 -0.005	+0.007 -0.005	+0.008 -0.005	+0.009 -0.005	+0.011 -0.006	+0.012 -0.006	+0.012 -0.006	
Over 0.0709 to 0.0971, incl	+0.005 -0.005	+0.007 -0.005	+0.008 -0.005	+0.009 -0.005	+0.011 -0.006	+0.013 -0.007	+0.013 -0.007	
Over 0.0971 to 0.1120, incl	+0.005 -0.005	+0.007 -0.005	+0.008 -0.005	+0.009 -0.005	+0.012 -0.007	+0.014 -0.008	+0.014 -0.008	
Over 0.1120 to 0.1419, incl	+0.005 -0.005	+0.007 -0.005	+0.008 -0.005	+0.010 -0.006	+0.012 -0.007	+0.014 -0.008	+0.014 -0.008	
Over 0.1419 to 0.1718, incl	+0.005 -0.005	+0.007 -0.005	+0.008 -0.005	+0.010 -0.006	+0.012 -0.007	+0.014 -0.008	+0.015 -0.009	
Over 0.1718 to 0.1874, incl	+0.006 -0.006	+0.008 -0.006	+0.009 -0.006	+0.010 -0.006	+0.012 -0.007	+0.015 -0.009	+0.015 -0.009	
Over 0.1874 to 0.2030, incl	+0.006 -0.006	+0.008 -0.006	+0.009 -0.006	+0.010 -0.006	+0.013 -0.008	+0.015 -0.009	+0.015 -0.009	
Over 0.2030 to 0.2299, incl	-	-	-	+0.011 -0.007	+0.013 -0.008	+0.015 -0.009	+0.015 -0.009	

TABLE III (SI)

Specified Thickness Millimetres	Tolerance, Millimetre For Width Ranges, Millimetres					
	Up to 25, incl	Over 25 to 89, incl	Over 89 to 152, incl	Over 152 to 305, incl	Over 305 to 381, incl	Over 381 to 508, incl
1.442 to 1.801, incl	+0.13	+0.18	+0.20	+0.23	+0.28	+0.30
	-0.13	-0.13	-0.13	-0.13	-0.15	-0.15
Over 1.801 to 2.466, incl	+0.13	+0.18	+0.20	+0.23	+0.28	+0.33
	-0.13	-0.13	-0.13	-0.13	-0.15	-0.18
Over 2.466 to 2.845, incl	+0.13	+0.18	+0.20	+0.23	+0.30	+0.36
	-0.13	-0.13	-0.13	-0.13	-0.18	-0.20
Over 2.845 to 3.604, incl	+0.13	+0.18	+0.20	+0.25	+0.30	+0.36
	-0.13	-0.13	-0.13	-0.15	-0.18	-0.20
Over 3.604 to 4.364, incl	+0.13	+0.18	+0.20	+0.25	+0.30	+0.36
	-0.13	-0.13	-0.13	-0.15	-0.18	-0.20
Over 4.364 to 4.760, incl	+0.15	+0.20	+0.23	+0.25	+0.30	+0.38
	-0.15	-0.15	-0.15	-0.15	-0.18	-0.23
Over 4.760 to 5.156, incl	+0.15	+0.20	+0.23	+0.25	+0.33	+0.38
	-0.15	-0.15	-0.15	-0.15	-0.20	-0.23
Over 5.156 to 5.839, incl	-	-	-	+0.28	+0.33	+0.38
	-	-	-	-0.18	-0.20	-0.23

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2.4 Cold Rolled Strip, Coils and Cut Lengths:

TABLE IV

Specified Thickness Inch		Tolerance, Inch, Plus and Minus For Width Ranges, Inches									
		Up to 1, excl	1 to 3, excl	3 to 6, incl	Over 6 to 9, incl	Over 9 to 12, incl	Over 12 to 16, incl	Over 16 to 20, incl	Over 20 to 23-15/16, incl		
0.010		0.001	0.001	0.001	0.001	0.001	0.001	0.0015	0.0015	0.0015	0.0015
0.011		0.001	0.001	0.001	0.001	0.001	0.0015	0.0015	0.0015	0.0015	0.0015
0.012		0.001	0.001	0.001	0.001	0.0015	0.0015	0.0015	0.0015	0.0015	0.0015
Over 0.012 to 0.016, incl		0.001	0.001	0.001	0.001	0.0015	0.0015	0.002	0.002	0.002	0.002
Over 0.016 to 0.019, incl		0.001	0.001	0.001	0.001	0.0015	0.002	0.002	0.002	0.0025	0.0025
Over 0.019 to 0.025, incl		0.001	0.001	0.0015	0.002	0.002	0.002	0.0025	0.0025	0.0025	0.0025
Over 0.025 to 0.028, incl		0.001	0.0015	0.0015	0.002	0.002	0.002	0.0025	0.0025	0.003	0.003
Over 0.028 to 0.034, incl		0.0015	0.0015	0.002	0.0025	0.0025	0.0025	0.003	0.003	0.003	0.003
Over 0.034 to 0.039, incl		0.002	0.002	0.0025	0.003	0.003	0.003	0.003	0.003	0.004	0.004
Over 0.039 to 0.049, incl		0.002	0.002	0.0025	0.003	0.003	0.003	0.003	0.003	0.004	0.004
Over 0.049 to 0.068, incl		0.002	0.002	0.003	0.003	0.003	0.003	0.003	0.004	0.004	0.004
Over 0.068 to 0.099, incl		0.002	0.002	0.003	0.003	0.003	0.003	0.004	0.004	0.005	0.005
Over 0.099 to 0.160, incl		0.002	0.003	0.003	0.004	0.004	0.004	0.005	0.005	0.006	0.006
Over 0.160 to 0.187, incl		0.002	0.0035	0.004	0.004	0.004	0.005	0.006	0.006	0.006	0.006

TABLE IV (SI)
Tolerance, Millimetre, Plus and Minus
For Width Ranges, Millimetres

Specified Thickness Millimetres	Up to	25 to	76 to	Over 152 to	Over 229 to	Over 305 to	Over 406 to	Over 508 to
0.25	0.03	0.03	0.03	0.03	0.03	0.03	0.038	0.038
0.28	0.03	0.03	0.03	0.03	0.03	0.038	0.038	0.038
0.30	0.03	0.03	0.03	0.03	0.038	0.038	0.038	0.038
Over 0.30 to 0.41, incl	0.03	0.03	0.03	0.038	0.038	0.038	0.05	0.05
Over 0.41 to 0.48, incl	0.03	0.03	0.03	0.038	0.038	0.05	0.05	0.05
Over 0.48 to 0.64, incl	0.03	0.03	0.038	0.038	0.05	0.05	0.064	0.064
Over 0.64 to 0.71, incl	0.03	0.038	0.038	0.05	0.05	0.05	0.064	0.08
Over 0.71 to 0.86, incl	0.03	0.038	0.05	0.064	0.064	0.064	0.08	0.08
Over 0.86 to 0.99, incl	0.05	0.05	0.064	0.08	0.08	0.08	0.08	0.08
Over 0.99 to 1.24, incl	0.05	0.05	0.064	0.08	0.08	0.08	0.10	0.10
Over 1.24 to 1.73, incl	0.05	0.05	0.08	0.08	0.08	0.08	0.10	0.10
Over 1.73 to 2.51, incl	0.05	0.05	0.08	0.08	0.08	0.10	0.10	0.10
Over 2.51 to 4.06, incl	0.05	0.08	0.08	0.10	0.10	0.10	0.13	0.13
Over 4.06 to 4.75, incl	0.05	0.089	0.10	0.10	0.10	0.13	0.15	0.15

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2.5 Rectangular Sheared Plates: Minus tolerance for all sizes shall be 0.010 in. (0.25 mm); plus tolerances shall be as specified in Table V.

TABLE V

	Tolerance, Inch, Plus For Width Ranges, Inches							
	Over 48 to to		60 to 72, excl	72 to 84, excl	84 to 96, excl	96 to 108, excl	108 to 120, excl	
Specified Thickness Inches	Up to 0.250, excl	0.016	0.016	0.020	0.020	0.024	0.028	0.032
	0.250 to 0.312, excl	0.016	0.020	0.020	0.024	0.028	0.032	0.036
	0.312 to 0.375, excl	0.020	0.020	0.024	0.024	0.028	0.032	0.036
	0.375 to 0.437, excl	0.020	0.024	0.024	0.028	0.032	0.036	0.040
	0.437 to 0.500, excl	0.024	0.024	0.028	0.028	0.032	0.036	0.040
	0.500 to 0.625, excl	0.024	0.028	0.028	0.032	0.036	0.040	0.040
	0.625 to 0.750, excl	0.028	0.028	0.032	0.032	0.036	0.040	0.044
	0.750 to 1.000, excl	0.032	0.032	0.036	0.036	0.040	0.044	0.048
	1.000 to 1.250, excl	0.040	0.044	0.048	0.048	0.048	0.052	0.056
	1.250 to 1.500, excl	0.052	0.052	0.056	0.056	0.056	0.064	0.068
	1.500 to 1.750, excl	0.060	0.060	0.064	0.064	0.064	0.072	0.080
	1.750 to 2.000, incl	0.068	0.068	0.072	0.076	0.076	0.086	0.094

TABLE V (SI)

	Tolerance, Millimetres, Plus						
	For Width Ranges, Millimetres						
	Over						
	Up to	1219 to	1524 to	1829 to	2134 to	2438 to	
Specified Thickness Millimetres	1219, incl	1524, excl	1829, excl	2134, excl	2438, excl	2743, excl	
Up to 6.35, excl	0.41	0.41	0.51	0.51	0.61	0.71	
6.35 to 7.92, excl	0.41	0.51	0.51	0.61	0.71	0.81	
7.92 to 9.52, excl	0.51	0.51	0.61	0.61	0.71	0.81	
9.52 to 11.10, excl	0.51	0.61	0.61	0.71	0.81	0.91	
11.10 to 12.70, excl	0.61	0.61	0.71	0.71	0.81	0.91	
12.70 to 15.88, excl	0.61	0.71	0.71	0.81	0.91	1.02	
15.88 to 19.05, excl	0.71	0.71	0.81	0.81	0.91	1.02	
19.05 to 25.40, excl	0.81	0.81	0.91	0.91	1.02	1.12	
25.40 to 31.75, excl	1.02	1.12	1.22	1.22	1.32	1.42	
31.75 to 38.10, excl	1.32	1.32	1.42	1.42	1.42	1.63	
38.10 to 44.45, excl	1.52	1.52	1.63	1.63	1.63	1.83	
44.45 to 50.80, incl	1.73	1.73	1.83	1.93	1.93	2.18	

2.5.1 For Thickness measured at any location other than that specified in Section 2, the permissible maximum plus tolerance shall be increased by 75%.

3. WIDTH:3.1 Cut Edge for Hot Rolled or Cold Rolled Sheets, Coils and Cut Lengths:TABLE VI

Specified Width Inches	Tolerance, Plus Only, Inch
24 to 30, incl	1/8
Over 30 to 48, incl	3/16
Over 48 to 60, incl	1/4
Over 60 to 80, incl	5/16
Over 80	3/8

TABLE VI (SI)

Specified Width Millimetres	Tolerance, Plus Only, Millimetres
610 to 762, incl	3.2
Over 762 to 1219, incl	4.8
Over 1219 to 1524, incl	6.4
Over 1524 to 2032, incl	7.9
Over 2032	9.5

3.2 Hot Rolled Strip, Coils and Cut Lengths, Except as Noted:3.2.1 Mill Edge: Width measurements on mill edge strip include the mill edge.TABLE VII

Specified Width Inches	Tolerance, Inch Plus and Minus
Up to 2, incl	1/32
Over 2 to 5, incl	1/16
Over 5 to 9, incl	3/32
Over 9 to 12, incl	1/8
Over 12 to 20, incl	1/4
Over 20 to 23-15/16, incl	3/8

TABLE VII (SI)

Specified Width Millimetres	Tolerance, Millimetres Plus and Minus
Up to 51, incl	0.8
Over 51 to 127, incl	1.6
Over 127 to 229, incl	2.4
Over 229 to 305, incl	3.2
Over 305 to 508, incl	6.4
Over 508 to 608, incl	9.5

3.2.2 Slit Edge:

TABLE VIII

Specified Width Inches	Tolerance, Inch, Plus and Minus For Thickness Ranges, Inch	
	Up to 0.109, incl	Over 0.109
Up to 2, incl	0.010	0.016
Over 2 to 5, incl	0.010	0.020
Over 5 to 9, incl	0.016	0.024
Over 9 to 12, incl	0.016	0.031
Over 12 to 20, incl	0.020	0.031
Over 20 to 23-15/16, incl	0.031	0.031

TABLE VIII (SI)

Specified Width Millimetres	Tolerance, Inch, Plus and Minus For Thickness Ranges, Inch	
	Up to 2.77, incl	Over 2.77
Up to 51, incl	0.25	0.41
Over 51 to 127, incl	0.25	0.51
Over 127 to 229, incl	0.41	0.61
Over 229 to 305, incl	0.41	0.79
Over 305 to 508, incl	0.51	0.79
Over 508 to 608, incl	0.79	0.79

3.2.3 Sheared Edge, Cut Lengths Only: Tolerance shall be +1/8 in. (+3.2 mm), -0 for all sizes.

3.3 Cold Rolled Strip, Coils and Cut Lengths, No. 3 Slit Edge:

TABLE IX

Specified Width Inches	Tolerance, Inch, Plus and Minus For Thickness Ranges, Inch			
	Over 0.0099 to 0.068, incl	Over 0.068 to 0.099, incl	Over 0.099 to 0.160, incl	Over 0.160 to 0.187, incl
Up to 1/2 excl	0.005	0.068	0.010	--
Over 1/2 to 6, incl	0.005	0.008	0.010	0.016
Over 6 to 9, incl	0.005	0.010	0.016	0.020
Over 9 to 12, incl	0.010	0.010	0.016	0.020
Over 12 to 20, incl	0.016	0.016	0.020	0.031
Over 20 to 23-15/16, incl	0.020	0.020	0.020	0.031

TABLE IX (SI)

Specified Width Millimetres	Tolerance, Millimetre, Plus and Minus For Thickness Ranges, Millimetres			
	Over 0.251 to 1.73, incl	Over 1.73 to 2.51, incl	Over 2.51 to 4.06, incl	Over 4.06 to 4.75, incl
Up to 13, excl	0.13	0.20	0.25	--
Over 13 to 152, incl	0.13	0.20	0.25	0.41
Over 152 to 229, incl	0.13	0.25	0.41	0.51
Over 229 to 305, incl	0.25	0.25	0.41	0.51
Over 305 to 508, incl	0.41	0.41	0.51	0.79
Over 508 to 608, incl	0.51	0.51	0.51	0.79

- 3.4 Hot Rolled or Thermally Treated Plate, Sheared or Gas Cut: Minus tolerance shall be 1/4 in. (6.4 mm) for all sizes; plus tolerance shall be as specified in Table X.

TABLE X

Specified Width Inches	Specified Length Inches	Tolerance, Inches, Plus For Thickness Ranges, Inches			
		Up to 3/8, excl	3/8 to 5/8, excl	5/8 to 1, excl	1 to 2, incl
Up to 60, excl	Up to 120, excl	3/8	7/16	1/2	5/8
60 to 84, excl	Up to 120, excl	7/16	1/2	5/8	3/4
84 to 108, excl	Up to 120, excl	1/2	5/8	3/4	1
108 and over	Up to 120, excl	5/8	3/4	7/8	1-1/8
Up to 60, excl	120 to 240, excl	3/8	1/2	5/8	3/4
60 to 84, excl	120 to 240, excl	1/2	5/8	3/4	7/8
84 to 108, excl	120 to 240, excl	9/16	11/16	13/16	1
108 and over	120 to 240, excl	5/8	3/4	7/8	1-1/8

TABLE X (SI)

Specified Width Millimetres	Specified Length Millimetres	Tolerance, Millimetres, Plus For Thickness Ranges, Millimetres			
		Up to 9.5, excl	9.5 to 15.9, excl	15.9 to 25.4, excl	25.4 to 50.8, incl
Up to 1524, excl	Up to 3048, excl	9.5	11.1	12.7	15.9
1524 to 2134, excl	Up to 3048, excl	11.1	12.7	15.9	19.0
2134 to 2743, excl	Up to 3048, excl	12.7	15.9	19.0	25.4
2743 and over	Up to 3048, excl	15.9	19.0	22.2	28.6
Up to 1524, excl	3048 to 6096, excl	9.5	12.7	15.9	19.0
1524 to 2134, excl	3048 to 6096, excl	12.7	15.9	19.0	22.2
2134 to 2743, excl	3048 to 6096, excl	14.3	17.5	20.6	25.4
2743 and over	3048 to 6096, excl	15.9	19.0	22.2	28.6

4. LENGTH:

4.1 Hot Rolled or Cold Rolled Sheet:

TABLE XI

Specified Length Inches	Tolerance, Inches, Plus Only
24 to 30, incl	1/4
Over 30 to 60, incl	1/2
Over 60 to 120, incl	3/4
Over 120 to 156, incl	1
Over 156 to 192, incl	1-1/4
Over 192 to 240, incl	1-1/2
Over 240	1-3/4

TABLE XI (SI)

Specified Length Millimetres	Tolerance, Millimetres, Plus Only
610 to 762, incl	6.4
Over 762 to 1524, incl	12.7
Over 1524 to 3048, incl	19.0
Over 3048 to 3962, incl	25.4
Over 3962 to 4877, incl	31.8
Over 4877 to 6096, incl	38.1
Over 6096	44.4

4.2 Hot Rolled Strip:

TABLE XII

Specified Length Inches	Tolerance, Inches, Plus Only		
	For Width Ranges, Inches		
	Up to 3, incl	Over 3 to 6, incl	Over 6 to 23-15/16, incl
Up to 60, incl	1/4	3/8	1/2
Over 60 to 120, incl	3/8	1/2	3/4
Over 120 to 240, incl	1/2	5/8	1
Over 240 to 360, incl	3/4	3/4	1-1/4
Over 360 to 480, incl	1	1	1-1/2
Over 480	1-1/2	1-1/2	1-3/4

TABLE XII (SI)

Specified Length Millimetres	Tolerance, Millimetres, Plus Only		
	For Width Ranges, Millimetres		
	Up to 76, incl	Over 76 to 152, incl	Over 152 to 608, incl
Up to 1524, incl	6.4	9.5	12.7
Over 1524 to 3048, incl	9.5	12.7	19.0
Over 3048 to 6096, incl	12.7	15.9	25.4
Over 6096 to 9144, incl	19.0	19.0	31.8
Over 9144 to 12192, incl	25.4	25.4	38.1
Over 12192	38.1	38.1	44.4