

# Machining allowance and thickness tolerances for bar stock

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FVSEAA-X0000-B001-00

## Machining allowance based on DIN 7527 page 6 Forged round bars

Finished dimension (mm)		Ø	Forged size		Allow. tolerance
From	to	Allowance			
63	80	7	70	87	+/- 1,5
80	100	8	88	108	+/- 2
100	125	10	110	135	+/- 2
125	160	12	137	172	+/- 2,5
160	200	14	174	214	+/- 3
200	250	17	217	267	+/- 3,5
215	315	21	271	336	+/- 4,5
315	400	26	341	426	+/- 5,5

## Thickness tolerance for rods

(hot-rolled, not straightened)

Ø	Tolerance
12,5 – 15,5 mm	+0,50 / -0,1 mm
15,6 – 25 mm	+0,50 / -0,1 mm
25 – 35 mm	+0,60 / -0,1 mm
35 – 50 mm	+0,75 / -0,1 mm
50 – 80 mm	+1,00 / -0,1 mm

Attention:

Hot rolled, not straightened is undefined!

Deviations < 5 mm/m can be assumed.

Tolerances also apply to other materials.

Materials except 50% CoFe such as VACOFLUX® 50 can be straightened. A straightness of  $\leq 2$  mm/m then applies.

Materials peeled, straightened. A straightness of  $\leq 1$  mm/m then applies.

Materials drawn, straightened. A straightness of  $\leq 1,5$  mm/m then applies.



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