

INDUSTRY GEOMETRICAL TOLERANCES PART 1

STANDARD FORECREU BAR DIAMETER TOLERANCES

- Decarburization /Pollution /Surface defect = depth

Black finish products tolerance and max depth are indicated below :

Supply condition	Dimensions and tolerances		Max depth		Machining oversize on OD	
	mm	in	mm	in	mm	in
Ground OD	Ø 2.2 → Ø 30 ISO k9, h9 and js9	Ø 0.0866 → Ø 1.181 ISO k9, h9 and js9	none	none	-	-
Black finish OD	Ø 4.4 → Ø 17.5 -0.10 / +0.30	Ø 0.173 → Ø 0.689 -0.004 / +0.012	0.30	0.012	0.7	0.028
	Ø 18 → Ø 23.5 -0.15 / +0.50	Ø 0.551 → Ø 0.925 -0.006 / +0.02	0.40	0.016	1.0	0.039
	Ø 24 → Ø 30 -0.20 / +0.60	Ø 0.945 → Ø 1.181 -0.008 / +0.024	0.40	0.016	1.5	0.059
	Ø 31 → Ø 60 -0.30 / +0.70	Ø 1.26 → Ø 2.52 -0.012 / +0.028	0.65	0.0256	2.0	0.079

- Possible surface defects, cracks

Supply condition	OD	ID
Ground condition	none	- no penetrative defects. (each batch is individually tested)
Black finish	≤ OD tolerance	

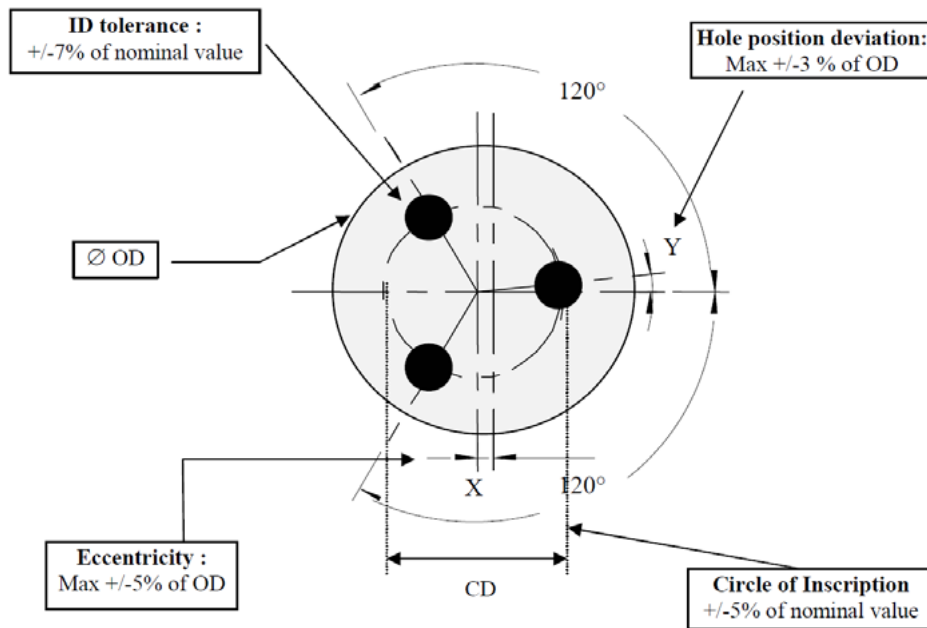
- Ovalization** : This defect is included in the OD tolerance.

Bar length : 1.8 to 3.9m - 5.9 to 12.8 ft

INDUSTRY GEOMETRICAL TOLERANCES PART 2

HOLE POSITION

• THREE HOLES



• CENTRAL HOLE

