
**Wrought aluminium and aluminium
alloys — Sheets, strips and plates —**

Part 3:

**Strips: Tolerances on shape and
dimensions**

*Aluminium et alliages d'aluminium corroyés — Tôles, bandes et tôles
épaisses —*

Partie 3: Bandes: Tolérances sur forme et dimensions



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Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards bodies (ISO member bodies). The work of preparing International Standards is normally carried out through ISO technical committees. Each member body interested in a subject for which a technical committee has been established has the right to be represented on that committee. International organizations, governmental and non-governmental, in liaison with ISO, also take part in the work. ISO collaborates closely with the International Electrotechnical Commission (IEC) on all matters of electrotechnical standardization.

International Standards are drafted in accordance with the rules given in the ISO/IEC Directives, Part 2.

The main task of technical committees is to prepare International Standards. Draft International Standards adopted by the technical committees are circulated to the member bodies for voting. Publication as an International Standard requires approval by at least 75 % of the member bodies casting a vote.

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. ISO shall not be held responsible for identifying any or all such patent rights.

ISO 6361-3 was prepared by Technical Committee ISO/TC 79, *Light metals and their alloys*, Subcommittee SC 6, *Wrought aluminium and aluminium alloys*.

This second edition cancels and replaces the first edition (ISO 6361-3:1985), which has been technically revised.

ISO 6361 consists of the following parts, under the general title *Wrought aluminium and aluminium alloys — Sheets, strips and plates*:

- *Part 1: Technical conditions for inspection and delivery*
- *Part 2: Mechanical properties*
- *Part 3: Strips: Tolerances on shape and dimensions*
- *Part 4: Sheets and plates: Tolerances on shape and dimensions*
- *Part 5: Chemical composition*

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Wrought aluminium and aluminium alloys — Sheets, strips and plates —

Part 3: Strips: Tolerances on shape and dimensions

1 Scope

This part of ISO 6361 specifies the tolerances on shape and dimensions for wrought aluminium and aluminium alloy strip by cold-rolling for general engineering applications.

It applies to products with a thickness over 0,15 mm up to and including 16 mm.

It does not apply to semi-finished rolled products in coiled form to be subjected to further rolling (reroll stock) or to special products such as those that are corrugated or embossed.

Technical conditions for inspection and delivery of products covered by this part of ISO 6361 are specified in ISO 6361-1.

2 Normative references

The following referenced documents are indispensable for the application of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

ISO 6361-1, *Wrought aluminium and aluminium alloys — Sheets, strips and plates — Part 1: Technical conditions for inspection and delivery*

3 Dimensional tolerances

3.1 Thickness

Thickness tolerances shall be in accordance with Tables 1 and 2.

When the tolerance is specified as either all plus or minus side, the value in Table 1 or in Table 2 shall be doubled.

Tolerances for the products exceeding the range of specified thickness and width shall be agreed upon between the purchaser and the supplier.

Table 1 — Thickness tolerances

Dimensions in millimetres

Specified thickness		Alloy number					
		1050, 1050A, 1070, 1070A, 1080, 1080A, 1085, 1100, 1200, 1100A, 1230A, 3003, 3103, 3203, 3005, 3105, 4006, 4007, 4015, 5005, 5010, 5110A, 5050, 8011A, 8021, 8079					
Over	Up to and including	Specified width					
		Up to and including 450	Over 450, up to and including 900	Over 900, up to and including 1 400	Over 1 400, up to and including 1 800	Over 1 800, up to and including 2 300	Over 2 300 up to and including 2 600
Tolerance							
≥0,15	0,20	±0,03	±0,03	±0,05			
0,20	0,25	±0,03	±0,04	±0,05			
0,25	0,45	±0,04	±0,04	±0,05	±0,06		
0,45	0,70	±0,04	±0,05	±0,06	±0,08		
0,70	0,90	±0,05	±0,05	±0,06	±0,09	±0,13	
0,90	1,1	±0,05	±0,06	±0,08	±0,10	±0,13	
1,1	1,7	±0,06	±0,08	±0,10	±0,13	±0,15	
1,7	1,9	±0,06	±0,08	±0,10	±0,15	±0,20	
1,9	2,4	±0,08	±0,08	±0,10	±0,15	±0,20	
2,4	2,7	±0,09	±0,10	±0,13	±0,18	±0,23	
2,7	3,6	±0,11	±0,11	±0,13	±0,18	±0,23	±0,25
3,6	4,5	±0,15	±0,15	±0,20	±0,23	±0,28	±0,30
4,5	5,0	±0,18	±0,18	±0,23	±0,28	±0,33	±0,38
5,0	6,5	±0,23	±0,23	±0,28	±0,33	±0,38	±0,43
6,5	8,0	±0,33	±0,33	±0,33	±0,38	±0,43	±0,51
8,0	11	±0,48	±0,48	±0,48	±0,48	±0,58	±0,66
11	16	±0,64	±0,64	±0,64	±0,64	±0,76	±0,89

Table 2 — Thickness tolerances

Dimensions in millimetres

Specified thickness		Alloy number											
		2014, 2014A, 2017, 2017A, 2219, 2024, 2124,2618A, 3004, 3104, 5021, 5026, 5040, 5042, 5049, 5052, 5059, 5070, 5449, 5251, 5154, 5154A, 5254, 5383, 5454, 5754, 5456,5082, 5182, 5083, 5086, 6016, 6025, 6061, 6082, 7204, 7010, 7020, 7021, 7022, 7050,7075, 7475, 7178											
		Specified width											
Over	Up to and including	Up to and including 450	Over 450, up to and including 900	Over 900, up to and including 1 200	Over 1 200, up to and including 1 400	Over 1 400, up to and including 1 500	Over 1 500, up to and including 1 700	Over 1 700, up to and including 1 800	Over 1 800, up to and including 2 000	Over 2 000, up to and including 2 100	Over 2 100, up to and including 2 300	Over 2 300, up to and including 2 400	Over 2 400, up to and including 2 600
		Tolerance											
≥0,20	0,25	±0,03	±0,04	±0,06	±0,06								
0,25	0,45	±0,04	±0,04	±0,06	±0,09								
0,45	0,70	±0,04	±0,05	±0,06	±0,09	±0,10	±0,10	±0,10					
0,70	0,90	±0,05	±0,05	±0,06	±0,10	±0,13	±0,13	±0,13	±0,15				
0,90	1,1	±0,05	±0,06	±0,08	±0,10	±0,13	±0,13	±0,13	±0,15				
1,1	1,7	±0,06	±0,08	±0,10	±0,13	±0,15	±0,15	±0,15	±0,18				
1,7	1,9	±0,08	±0,08	±0,10	±0,13	±0,15	±0,15	±0,15	±0,18				
1,9	2,4	±0,09	±0,09	±0,10	±0,13	±0,15	±0,15	±0,15	±0,18	±0,18	±0,30		
2,4	2,7	±0,10	±0,10	±0,13	±0,13	±0,18	±0,18	±0,18	±0,20	±0,20	±0,41		
2,7	3,2	±0,11	±0,11	±0,13	±0,13	±0,18	±0,18	±0,18	±0,20	±0,20	±0,41	±0,46	±0,51
3,2	3,6	±0,11	±0,11	±0,13	±0,13	±0,18	±0,25	±0,30	±0,33	±0,36	±0,41	±0,46	±0,51
3,6	4,5	±0,15	±0,15	±0,20	±0,20	±0,23	±0,30	±0,36	±0,38	±0,41	±0,43	±0,48	±0,58
4,5	5,0	±0,18	±0,18	±0,25	±0,25	±0,28	±0,36	±0,41	±0,43	±0,43	±0,43	±0,56	±0,66
5,0	6,5	±0,23	±0,23	±0,28	±0,28	±0,33	±0,41	±0,46	±0,46	±0,46	±0,46	±0,61	±0,71
6,5	8,0	±0,33	±0,33	±0,33	±0,33	±0,38	±0,46	±0,51	±0,51	±0,51	±0,51	±0,64	±0,76
8,0	11	±0,48	±0,48	±0,48	±0,48	±0,51	±0,51	±0,58	±0,58	±0,64	±0,64	±0,66	±0,84
11	16	±0,64	±0,64	±0,64	±0,64	±0,64	±0,64	±0,64	±0,76	±0,76	±0,76	±0,89	±0,89

3.2 Width

Width tolerances shall be in accordance with Table 3.

When the tolerance is specified as either all plus or minus side, the value in Table 3 shall be doubled.

Tolerances for the products exceeding the range of specified thickness and width shall be agreed upon between the purchaser and the supplier.

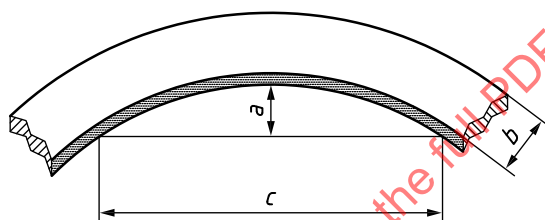
Table 3 — Width tolerance for strip

Dimensions in millimetres

Specified thickness		Specified width					
Over	Up to and including	Up to and including 150	Over 150, up to and including 300	Over 300, up to and including 600	Over 600, up to and including 1 200	Over 1 200, up to and including 1 500	Over 1 500, up to and including 2 600
Tolerance							
≥0,15	3,2	±0,3	±0,4	±0,8	±1,2	±1,6	±3,2
3,2	5,0	±0,3	±0,8	±0,8	±1,6	±2,4	
5,0	6,3	±0,4	±0,8	±1,2	±2,4	±3,2	

4 Shape tolerances

The lateral curvature is the depth of the arc for any 2 000 mm basis length; see Figure 1.



Key

- a* deviation from straightness (maximum value)
b width
c 2 000 mm

Figure 1 — Lateral curvature of strip

When tested with the strip resting on a flat surface, against a straight edge, the lateral curvature shall not exceed the values given in Table 4 for a value of length $L = 2\,000$ mm.

The maximum value for the products exceeding the range of specified thickness and width shall be agreed upon between the purchaser and the supplier.

Table 4 — Lateral curvature tolerances for strip

Dimensions in millimetres

Specified thickness		Specified width				
Over	Up to and including	15 or over, up to and including 25	Over 25, up to and including 50	Over 50, up to and including 100	Over 100, up to and including 250	Over 250, up to and including 2 600
Maximum value (in any 2 000 length)						
≥0,15	1,6	19	15	10	7	5
1,6	3,2			10	7	5