

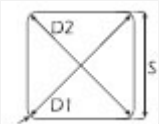



Rolled Products

Section	Range	Tolerance (IS 3739 Gr. I : 1987)			Indicative Sketch	
		Over	Under	Ovality		
Round Bars (Outsourced)	14,15,16,17,18,19,20,21,22 23,24,25,26,26.2,26.3,26.5 27,28,28.4,28.5,29.5,30,30.2 30.3,30.3,301.5,32,32.5,33.5 34,34.5,35,36,36.5,38 38.5,39,42,48,53,68,83	+0.18 +0.20 +0.24 +0.25 +0.36 +0.40	-0.18 -0.20 -0.24 -0.25 -0.36 -0.40	0.25 0.30 0.35 0.40 0.60 0.60	 D = Nominal Dia D1 =Max. Dia. At a given c/s D2 =Min. Dia. At the same c/s D1 – D2 =Ovality(Out of Round)	
Rolled In-house	40,45, 50 55,56.5,60,63 65,70,75,80,85, 90,95,100,105,110 115,120,125,130,135 140,150,160 220	+0.40 +0.80 +0.80 +1.20 +1.60 +2.00 +3.20 +4.00	-0.40 -0.00 -0.00 -0.00 -0.00 -0.00 -0.00 -0.00	0.60 0.80 0.80 0.80 1.20 1.50 2.00 2.50		
Round Cornered Square Bars	Bulged Profile	48 - 50 50.5 - 64 (Any intermediate sizes can be rolled)	+0.60 +1.20 +1.80	-0.60 -1.20 -0.00	0.60 0.80 1.30	 S = Length across Bulged Face
	Regular Profile					
	Fixed Profile	75 - 89 (Intermediate sizes 90 - 114 can be rolled in 115 - 340 5 mm increments)	+1.80 +2.40 +3.00	-0.00 -0.00 -0.00	1.30 1.80 2.50	 S = Length of side D1,D2= Length Across Diagonal Corners D1 – D2 =Out of Square R = Corner Radius
		182(Corner Radius: 25+/-3 mm)	+3.00	-0.00	2.50	
		287(Corner Radius: 48+/-5 mm)	+3.00	-0.00	2.50	
		300(Corner Radius: 50+/-5 mm)	+3.00	-0.00	2.50	
	340(Corner Radius: 58+/-5 mm)					
Rectangle (Slabs)	Thickness: 35 – 150 Width: 150 – 540 (Intermediate sizes can be rolled in 5 mm increments)	+2.00 +10.00	-4.00 -0.00	- -	 W = Width T = Thickness	