



National
Bronze^{MFG.}
M I C H I G A N

CONTINUOUS CAST BRONZE BAR STOCK TOLERANCES

Stock Allowance and Tolerance Information for Continuous Cast Rectangles and Squares

Straightness Tolerances of Alloys C86300, C93200 & C95400

Product	Length (in Feet)	Max. Curvature
Round Rod or Tube	Up to 10'	¼" in any 5' portion
	Over 10'	½" in any 10' portion
Rectangle, Square or Shape	Any length	¼" in any 6' portion

As Cast Alloy C93200

Finished Width	Thickness	Width
Up to 3.999"	+ 0.047 + 0.079	+ 0.047 + 0.079
Over 4" to 5"	+ 0.078 + 0.110	+ 0.078 + 0.110
Over 5.001"	+ 0.109 + 0.141	+ 0.109 + 0.141

As Cast Alloys C95400 & C95500 LESS than 3" Thick

Finished Width	Thickness	Width
Up to 5 1/2"	+ 0.067 + 0.107	+ 0.043 + 0.083
Over 5 1/2" - 12"	+ 0.087 + 0.127	+ 0.063 + 0.113
Over 12"	+ 0.163 + 0.263	+ 0.125 + 0.225
MORE than 3" Thick	+ 0.163 + 0.263	+ 0.125 + 0.225



Stock Allowance Tubes and Solids Alloys C954, C955 & C959

Nominal OD	Stock on ID	Stock on OD
Up to 3"	-0.0505 -0.0955	+ 0.0525 + 0.0725
Over 3" to 4 1/2"	-0.090 -0.145	+ 0.079 + 0.109
Over 4 1/2" to 5 1/2"	-0.100 -0.165	+ 0.105 + 0.145
Over 5 1/2" to 9"	-0.135 -0.210	+ 0.163 + 0.213
Over 9"	Rough turned with stock to finish. Allowance may vary.	

Stock Allowance and Tolerance Information

Tubes and Solids Alloys C93200, C92200 & C93700

Nominal OD	Stock on ID	Stock on OD
Up to 1.999"	-0.019 -0.064	+0.029 +0.039
Over 2" to 3.999"	-0.019 -0.064	+0.034 +0.044
Over 4" to 5"	-0.047 -0.109	+0.055 +0.071
Over 5" to 9"	-0.062 -0.158	+0.078 +0.110
Over 9" to 12"	-0.078 -0.182	+0.094 +0.134
Over 12" to 16"	-0.102 -0.214	+0.118 +0.166
Over 16"	Rough turned with stock to finish.	

Tubes and Solids Alloy C86300

Nominal OD	Stock on ID	Stock on OD
Up to 3"	-0.0505 -0.0955	+ 0.0525 + 0.0725
Over 3" to 4 1/2"	-0.090 -0.145	+ 0.079 + 0.109
Over 4 1/2" to 5 1/2"	-0.100 -0.165	+ 0.105 + 0.145
Over 5 1/2" to 9"	-0.135 -0.210	+ 0.163 + 0.213
Over 9"	Rough turned with stock to finish. Allowance may vary.	

Solid Alloy C90300 CAST TO SIZE

If Bar Diameter is	Allow at Least
Up to 1.999"	.040
Over 2" to 3.999"	.044
Over 4" to 5"	.071
Over 5" to 9"	.110

Call toll free 800-375-3558 or visit nationalbronze.com