

WHAT SIZE DO I NEED FOR MY FINISHED MACHINE SIZE

Hot Rolled Dia mm	Required Finished Size in mm	Hot Rolled Dia mm	Required Finished Size in mm	Forged Bar Dia mm	Required Finished Size in mm
20	18.91	70	66.53	305	280.00
21	19.87	71	67.49	320	295.00
22	20.83	72	68.45	330	305.00
23	21.79	73	69.41	350	325.00
24	22.75	74	70.37	360	335.00
25	23.71	75	71.33	380	355.00
26	24.67	76	71.71	405	375.00
27	25.54	80	75.55	430	400.00
28	26.50	85	80.35	460	430.00
29	27.46	90	85.15	480	450.00
30	28.42	95	89.76	510	475.00
31	29.38	100	94.56	535	500.00
32	30.34	105	99.36	560	525.00
33	31.30	110	104.16	585	550.00
34	32.26	115	108.96	610	575.00
35	33.22	120	113.76		
36	34.18	125	118.08		
37	35.14	130	122.88		
38	36.10	135	127.68		
39	36.96	140	132.48		
40	37.92	145	137.28		
41	38.88	150	142.08		
42	39.84	155	146.88		
43	40.80	160	151.68		
44	41.76	165	156.00		
45	42.72	170	160.80		
46	43.68	175	165.60		
47	44.64	180	170.40		
48	45.60	185	175.20		
49	46.56	190	180.00		
50	47.52	195	184.80		
51	48.48	200	189.60		
52	49.34	205	193.92		
53	50.30	210	198.72		
54	51.26	215	203.52		
55	52.22	220	208.32		
56	53.18	230	217.92		
57	54.14	240	227.52		
58	55.10	250	237.12		
59	56.06	255	241.92		
60	57.02	260	246.72		
61	57.98	270	256.32		
62	58.99	280	265.92		
63	59.90	290	275.52		
64	60.86	300	285.12		
65	61.73	300	285.12		
66	62.69	270	256.32		
67	63.65	280	265.92		
68	64.61	290	275.52		
69	65.57	300	285.12		

TOLERANCES FOR HOT ROLLED & ROUGH TURNED ROUND BAR AS PER BRITISH STANDARD BS970: PART 1Q 1996

Size	Permitted Variation		Permitted Variation		Permitted Variation
	Primary Rolled		Re Rolled		Forged Bar
	Diameter	Out of Section	Diameter	Out of Section	
mm	+/-mm	mm	+/-mm	mm	+/-mm
<16			0.2	0.3	
16-26			0.3	0.5	
26-38			0.4	0.6	
38-51			0.5	0.8	
51-64			0.6	0.9	
64-76			0.7	1.1	
76-90	1.3	2	0.7	1.1	
90-120	1.5	2.3	0.8	1.2	
120-160	2	3			
160-200	2.5	3.8			
201-275	3	4.5			
275-300	+/-1.25%	of Dia			
305-340					-8.4 / +10
341-459					-10.0 / +10
460-480					-11.9 / +10
481-559					-11.9 / +15
560-610					-14.3 / +15

CALL US NOW ON
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