

**STANDARD ASTM MILL TOLERANCES
FLATNESS**

**Hot Dipped Metallic-Coated Sheet
Cut Lengths Over 12" in Width
Non-Tension Levelled
(ASTM 924/97A)**

Specified Minimum Thickness, Inch	Specified Width, Inches	Flatness Tolerances (Maximum Deviation from a Horizontal Flat Surface)
Thru 0.048 And thinner	Thru 36 incl	3/8 or .375
	Over 36 thru 60 incl Over 60 thru 72 incl	5/8 or .625 7/8 or .875
Over .048	12 Thru 36 incl	1/4 or .250
	36 Thru 60 incl	3/8 or .375
	60 Thru 72 incl	5/8 or .625

Note 1: The above table also applies to lengths cut from coils by the consumer when adequate flattening measures are performed
Note 2: The above table does not apply to structural steel . ASTM A-653/96

**STANDARD ASTM MILL TOLERANCES
FLATNESS**

**Hot Dipped Metallic-Coated Sheet
Cut Lengths Over 12" in Width
Specified to Tenion Levelled
Standard of Flatness
(ASTM 924/97A)**

Specified Minimum Thickness, Inch	Specified Width, Inch	Specified Length, Inch	Specified Minimum Thickness, Inch
Over .019 thru .032 incl	Thru 36	Thru 120	1/4 or .25
	Wider or Longer		3/8 or .375
Over .032	Thru 45	Thru 120	1/8 or .125
	Wider or Longer		1/4 or .25

**STANDARD ASTM MILL TOLERANCES
CAMBER**

**Hot Dipped/Metallic-Coated Sheet
Over 12 Inches Wide
(ASTM 924/97A)**

Camber is the deviation of a side edge from a straight line, the measurement being taken on the concave side with a straightedge. The camber tolerances for sheet in cut lengths, not resquared, are as shown in this table.

Cut Length	Camber Tolerances Inches
Thru 4 incl.	1/8 or .125
4 Thru 6 incl.	3/16 or .1875
Over 6 Thru 8 incl.	1/4 or .250
Over 8 Thru 10 incl.	5/16 or .3125
Over 10 Thru 12 incl.	3/8 or .375
Over 12 Thru 14 incl.	1/2 or .500
Over 14 Thru 16 incl.	5/8 or .625
Over 16 Thru 18 incl.	3/4 or .725
Over 18 Thru 20 Incl.	7/8 or .875
Over 20 Thru 30 incl.	1-1/4 or 1.250
Over 30 Thru 40 incl.	1-1/2 or 1.500

The Camber Tolerance for coils is one (1) inch to any 20 feet.

**STANDARD ASTM MILL TOLERANCES
CAMBER**

**Narrow Widths for
Hot Dipped/Metallic-Coated Sheet in Coils
(ASTM 924/97A)**

1/4 inch in any 8 feet

This table applies to widths produced by slitting from wider sheets

**STANDARD ASTM MILL TOLERANCES
OUT—OF—SQUARE**

**Hot Dipped Metallic-Coated Sheet
Over 12 Inches Wide
Not Resquared
(ASTM 924/97A)**

Out-of-square is the greatest deviation of an end edge from a straight line at right angles to a side and touching one corner. It is also obtained by measuring the difference between the diagonals of the cut length. The out-of-square deviation is one half of that difference. The tolerance for all thicknesses and all sizes is 1/16 inch (.0625) per 6 inches of width or fraction thereof.