



Permissible Variations in Round Bar

	<u>Size</u>	<u>Over</u>	<u>Under</u>	<u>Straightness</u>
Smooth turned	1/8" to under 5/16"	0.001"	0.001"	.0625" in 5ft
Smooth turned	5/16" to under 1/2"	0.0015"	0.0015"	.0625" in 5ft
Smooth turned	1/2" to under 1"	0.002"	0.002"	.0625" in 5ft
Smooth turned	1" to under 1-1/2"	0.0025"	0.0025"	.0625" in 5ft
Smooth turned	1-1/2" to 4" incl.	0.003"	0.003"	.0625" in 5ft
Centerless Ground	.8750" - .9999"	0.0"	0.002"	.0625" in 5ft
Centerless Ground	1.000" - 1.499"	0.0"	0.0025"	.0625" in 5ft
Centerless Ground	1.500" - 3.499"	0.0"	0.003"	.0625" in 5ft
Centerless Ground	3.500" - 7.000"	0.0"	0.004"	.0625" in 5ft
Pump Shaft	.8750" - .9999"	0.0"	0.002"	0.0312" in 5ft
Pump Shaft	1.000" - 1.499"	0.0"	0.0025"	0.0312" in 5ft
Pump Shaft	1.500" - 3.499"	0.0"	0.003"	0.0312" in 5ft
Pump Shaft	3.500" - 7.000"	0.001"	0.003"	0.0312" in 5ft
Hot Finished	Over 3-1/2" to 4-1/2"	0.0625	0.0"	0.125" in 5ft
Hot Finished	Over 4-1/2" to 5-1/2"	0.0781	0.0"	0.125" in 5ft
Hot Finished	Over 5-1/2" to 6-1/2"	0.125	0.0"	0.125" in 5ft
Hot Finished	Over 6-1/2" to 8"	0.1563	0.0"	0.125" in 5ft
Hot Finished	Over 8" to 12"	0.1875	0.0"	0.125" in 5ft
Hot Finished	Over 12" to 15"	0.2188	0.0"	0.125" in 5ft
Hot Finished	Over 15" to 25"	0.25	0.0"	0.125" in 5ft