



Standard Tolerances

Stainless Steel Sheet - Forms Finishes and Tolerances

ATI sheet stainless steels are flat-rolled products produced by continuous mill rolling, available in coils or cut lengths. Thicknesses range from 0.018" to 0.1874" and widths range from 24" to 48". For thicknesses lighter than 0.018" refer to the mill.

Size Tolerances

Roller Leveled – Not Resquared				
Thickness Inch	Nominal Length Inches	Length Tolerance Inch	Nominal Width Inches	Width Tolerance Inch
Under 0.131	120 and under	+1/8 -0	48 and under	+1/16 -0
Under 0.131	Over 120	+1/4 -0	48 and under	+1/16 -0
0.131 and over	All	+1/4 -0	48 and under	+1/16 -0

Requirements for more restrictive tolerances should be referred to the mill.

Stretcher Leveled and Resquared				
Thickness Inch	Nominal Length Inches	Length Tolerance Inch	Nominal Width Inches	Width Tolerance Inch
Under 0.131	120 and under	+1/16 -0	48 and under	+1/16 -0
Under 0.131	Over 120	+1/8 -0	48 and under	+1/16 -0
0.131 and over	All	+1/8 -0	48 and under	+1/16 -0

Requirements for more restrictive tolerances should be referred to the mill.

Camber Tolerances

Width Inches	Maximum Camber (inches in 8 Feet)
24 to 36 inclusive	1/8
Over 36 to 48 inclusive	3/32

Camber is the greatest deviation of a side edge from a straight line, the measurement being taken on the concave side by placement against an 8-foot straight edge.

Flatness Tolerances

Roller Leveled – Annealed Temper		
Thickness Inch	Width Inches	Flatness Tolerance* (Maximum Deviation From Horizontal Flat Surface), Inch
0.018 – 0.1874	24 to 48 incl.	1/2

*Suitable for leveling to 1/4-inch max. on cut line equipment.



Standard Tolerances

Stretcher Leveled – Annealed Temper			
Thickness Inch	Width Inches	Length Inches	Flatness Tolerance (Maximum Deviation From Horizontal Flat Surface) Inch
Under 3/16	To 48	To 96	1/8
Under 3/16	To 48	Over 96	1/4

Standard Gage Tolerances

Thickness-Inch Under Including	Gage Number	Tolerance* - Inch +/-
0.1875 to 0.1451	8 & 9	0.007
0.1451 to 0.1301	10	0.006
0.1301 to 0.1141	11	0.005
0.1141 to 0.0981	12	0.005
0.0981 to 0.0831	13	0.004
0.0831 to 0.0721	14	0.004
0.0721 to 0.0581	15 & 16	0.003
0.0581 to 0.0401	17 to 19	0.003
0.0401 to 0.0291	20 to 22	0.002
0.0291 to 0.0160	23 to 27	0.0015

*Width through 48" maximum

Standard Finishes

#1 – Hot Rolled, annealed and pickled.

#2B – Cold rolled on polished rolls, annealed, pickled, and skin passed on polished rolls.

#2D– Cold rolled, annealed, pickled, and skin passed with dull blasted rolls or may be ordered without the dull skin pass for formability or surface considerations.

#3 – Polish

#4 – Polish

Coatings

Adhesive vinyl coverings are available with a range of adhesive strengths for various applications.