

NOTICE: When Government drawings, specifications, or other data are used for any purpose other than in connection with a definitely related Government procurement operation, the United States Government thereby incurs no responsibility, nor any obligation, nor does it warrant that the data herein are correct, complete, or that the drawings, specifications, or other data are not in some manner infringing the holder's or other person's patent, trademark, or copyright, or conveying any rights or permission to manufacture, use, or sell any patented invention that may in any way be related thereto.

NOTE: This drawing was approved by Joint Action of the War and Navy Departments as the Army-Navy standard for this drawing. This drawing supersedes all antecedent standard drawings for this item that have been in effect for the past 12 months after the date of approval shown. It may be put into effect, however, at an earlier date after promulgation.

HOT ROLLED ALLOY STEEL SHEET WIDTH TOLERANCES. Table with columns for Specified Width, Mill Edge, and Sheared Edge, and rows for various width ranges from Up to 2 in. to Over 80.

HOT ROLLED ALLOY STEEL SHEET THICKNESS TOLERANCES. Table with columns for Specified Width and Specified Thickness, and rows for various thickness ranges from Up to 3-1/2 in. to Over 90.

Thickness measured at any point on the sheet, not less than 3/8 from edge.

Continued from Thickness Tolerances Table Above.

(a) HOT ROLLED ALLOY STEEL SHEET CAMBER TOLERANCES

Table with columns for Specified Width and Specified Thickness, showing camber tolerances for various thicknesses and widths.

Table with columns for Specified Length in Feet and Tolerance, showing camber tolerances for various lengths from Up to 4 in. to Over 30 to 40 in.

For sheets in coils, permissible camber not to exceed 1 inch in any 20 feet of length.

HOT ROLLED ALLOY STEEL SHEET LENGTH TOLERANCES

Table with columns for Specified Length and Tolerance (Sheets 0.0449 and Thicker, Sheets 0.0448 and Thinner), showing length tolerances for various lengths.

(b) HOT ROLLED ALLOY STEEL SHEET FLATNESS TOLERANCES

Table with columns for Specified Thickness, Specified Width, and Tolerance From Flat, showing flatness tolerances for various thicknesses and widths.

(a) Camber is defined as the greatest deviation of a side edge from a straight line; and the measurement is taken on the convex side with a straightedge.

(b) The flatness of sheet or strip is measured by laying the sheet or strip on a true flat surface and measuring the maximum elevation above that true flat surface to any point on the bottom surface of the sheet or strip.

ALL DIMENSIONS AND TOLERANCES IN INCHES, UNLESS OTHERWISE SPECIFIED.

ARMY-NAVY AERONAUTICAL DESIGN STANDARD TOLERANCES-ALLOY STEEL SHEET AND STRIP

AND 10367 SHEET 1 OF 2 SHEETS

NOT A PART NUMBER

APPROVED TO 309-47 REVISED 1 9 59 49

NOTE: This drawing was approved by joint action of the War and Navy Departments as the Army-Navy standard for the design of aircraft. This drawing supersedes all antecedent standard drawings for the same product and shall be used for the procurement of aircraft supplies, for use in new designs, not later than 6 months after the date of approval shown. It may be put into effect, however, at an earlier date after promulgation.

NOTE: When Government drawings, specifications, or other data are used for any purpose other than in connection with a definitely related Government procurement operation, the United States Government thereby incurs no responsibility, nor any obligation, and it is to be understood that neither the Government nor the manufacturer, distributor, or contractor, in any way, is authorized to reproduce or to retransmit, in any form, or by any means, or by any name, or in any way, to disseminate information, or to identify any other person or persons, or to convey any rights or privileges, or to sell any patented invention that may in any way be related thereto.

**HOT ROLLED ALLOY STEEL STRIP THICKNESS TOLERANCES**

Specified Width	Specified Thickness															
	0.2499 to 0.1910 incl.	0.1909 to 0.1875 incl.	0.1874 to 0.1420 incl.	0.1419 to 0.1180 incl.	0.1179 to 0.1090 incl.	0.1089 to 0.0972 incl.	0.0971 to 0.0822 incl.	0.0821 to 0.0710 incl.	0.0709 to 0.0610 incl.	0.0609 to 0.0540 incl.	0.0539 to 0.0509 incl.	0.0508 to 0.0410 incl.	0.0409 to 0.0389 incl.	0.0388 to 0.0350 incl.	0.0349 to 0.0314 incl.	0.0313 to 0.0250 incl.
Up to 3-1/2 incl.	—	—	—	—	—	±0.004	±0.004	±0.004	±0.004	±0.004	±0.003	±0.003	±0.003	±0.003	±0.003	±0.003
Over 3-1/2 to 5 incl.	—	—	—	—	—	±0.005	±0.005	±0.005	±0.005	±0.005	±0.005	±0.005	±0.005	±0.005	±0.005	±0.005
Over 5 to 6 incl.	—	—	—	—	—	±0.005	±0.005	±0.005	±0.005	±0.005	±0.005	±0.005	±0.005	±0.005	±0.005	±0.005
Over 6 to 10 incl.	±0.007	±0.006	±0.006	±0.006	±0.005	±0.005	±0.005	±0.005	±0.005	±0.005	±0.005	±0.004	±0.004	±0.004	±0.004	±0.004
Over 10 to 15 incl.	±0.008	±0.007	±0.007	±0.007	±0.006	±0.006	±0.006	±0.006	±0.006	±0.006	±0.006	±0.006	±0.006	±0.006	±0.006	±0.006
Over 15 to 24 excl.	±0.009	±0.008	±0.008	±0.008	±0.007	±0.007	±0.007	±0.007	±0.007	±0.007	±0.007	±0.007	±0.007	±0.007	±0.007	±0.007

Thickness measurements are taken 3/8 from edge of strip.

**HOT ROLLED ALLOY STEEL STRIP WIDTH TOLERANCES**

Specified Width	Tolerance											
	Mill Edge						Sheared Edge					
	0.2499 to 0.1091 incl.	0.1090 to 0.0621 incl.	0.0620 to 0.0540 incl.	0.0539 to 0.0410 incl.	0.0409 to 0.0344 incl.	0.0343 to 0.0250 incl.	0.2499 to 0.1091 incl.	0.1090 to 0.0621 incl.	0.0620 to 0.0540 incl.	0.0539 to 0.0410 incl.	0.0409 to 0.0344 incl.	0.0343 to 0.0250 incl.
Up to 2 incl.	—	±1/32	±1/32	±1/32	±1/32	±1/32	—	±0.008	±0.008	±0.008	±0.008	±0.008
Over 2 to 3-1/2 incl.	—	±3/64	±3/64	±3/64	±3/64	±3/64	—	±0.008	±0.008	±0.008	±0.008	±0.008
Over 3-1/2 to 5 incl.	—	±3/64	±3/64	±3/64	±3/64	±3/64	—	±0.008	±0.008	±0.008	±0.008	±0.008
Over 5 to 6 incl.	—	±1/16	±1/16	±1/16	±1/16	±1/16	—	±0.010	±0.010	±0.010	±0.010	±0.010
Over 6 to 10 incl.	±1/16	±1/16	±1/16	±1/16	—	—	±0.016	±0.010	±0.010	±0.010	—	—
Over 10 to 15 incl.	±3/32	±3/32	±3/32	—	—	—	±0.016	±0.016	±0.016	—	—	—
Over 15 to 20 incl.	±1/8	±1/8	—	—	—	—	±0.016	±0.016	—	—	—	—
Over 20 to 24 excl.	±5/32	±5/32	—	—	—	—	±1/32	±1/32	—	—	—	—

**HOT ROLLED ALLOY STEEL STRIP LENGTH TOLERANCES**

Specified Length	Specified Width		
	3 or Under	Over 3 to 6 incl.	Over 6 to 24 excl.
Up to 40 incl.	+ 1/4	+ 3/8	+ 1/2
Over 40 to 60 incl.	+ 1/4	+ 3/8	+ 1/2
Over 60 to 96 incl.	+ 3/8	+ 1/2	+ 3/4
Over 96 to 120 incl.	+ 3/8	+ 1/2	+ 3/4
Over 120 to 156 incl.	+ 1/2	+ 5/8	+ 1
Over 156 to 180 incl.	+ 1/2	+ 5/8	+ 1
Over 180 to 192 incl.	+ 1/2	+ 5/8	+ 1
Over 192 to 240 incl.	+ 1/2	+ 5/8	+ 1
Over 240 to 360 incl.	+ 3/4	+ 3/4	+ 1-1/4
Over 360 to 480 incl.	+ 1	+ 1	+ 1-1/2
Over 480	+ 1-1/2	+ 1-1/2	+ 1-3/4

**HOT ROLLED ALLOY STEEL STRIP GROWN TOLERANCES**

Specified Width	Tolerance
Up to 2 incl.	0.002
Over 2 to 5 incl.	0.003
Over 5 to 10 incl.	0.004
Over 10 to 15 incl.	0.005
Over 15 to 24 excl.	0.006

Strip steel may be thicker at the center than at the edge by the amounts shown above.

**HOT ROLLED ALLOY STEEL STRIP FLATNESS TOLERANCES**

Flatness Not to Exceed 1/2 inch in any 8 feet

(a) **HOT ROLLED ALLOY STEEL STRIP CAMBER TOLERANCES**

1/4 inch in any 8 feet

ALL DIMENSIONS AND TOLERANCES IN INCHES, UNLESS OTHERWISE SPECIFIED.

ARMY-NAVY AERONAUTICAL DESIGN STANDARD TOLERANCES-ALLOY STEEL SHEET AND STRIP	AND 10367
SHEET 2 OF 2 APPROVED	NOT A PART NUMBER

APPROVED 10 Jun 47 REVISED 1 FOR CHANGES SEE SHEET 1.