

## Standard Diameter Tolerances

Grade	Finish	Diameter Range	Tolerances
A2-D2-S7-01-H13 A6, H13, 420, CPM M4, CPM 10V, CPM 9V	THRU 4"-DCF OVER 4"-RT	1/4" TO U 1 1/2"	+0.010"/. 015"
		1 1/2" TO U 3-1/16"	+0.020"/. 035"
		3 1/16" TO U 4-1/16"	+0.040"/. 070"
		4 1/16" TO U 6-1/16"	+0.060"/. 125"
		6 1/16" TO U 10"	+0.090"/. 135"
		10" TO U 14"	+. 100"/. 150"
		14" & OVER	+. 125"/. 225"
Bars 2" diameter and under will have a surface finish of 80 rms or better and bars over 2" diameter a surface finish of 125 rms or better.			
4140HR*HT	Hot Finish (on size)	>5/8" THRU 7/8"	-.008"/+.008"
		>7/8" THRU 1"	-.009"/+.009"
		>1" THRU 1 1/8"	-.010"/+.010"
		>1-1/8" THRU 1- 1/4"	-.011"/+.011"
		>1-1/4" THRU 1-3/8"	-.012"/+.012"
		>1-3/8" THRU 1- 1/2"	-.014"/+.014"
		>1-1/2" THRU 2"	-.0156"/+.0156"
		>2" THRU 2-1/2"	-.000"/+.0312"
		>2-1/2" THRU 3-1/2"	-.000"/+.0469"
		>3-1/2" THRU 4-1/2"	-.000"/+.0625"
		>4-1/2" THRU 5-1/2"	-.000"/+.0781"
		>5-1/2" THRU 6-1/2"	-.000"/+. 125"
		>6-1/2" THRU 8-1/2"	-.000"/+.156"
		>8-1/2" THRU 9-1/2"	-.000"/+. 1875"
>9-1/2"	+.1875"/.250"		

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Grade	Finish	Diameter Range	Tolerances
Precision Drill Rod		.124" AND SMALLER .125" THRU .499" .500" THRU 3.000"	+/- .0003" +/- .0005" +/- .001"