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**Continuously hot-dipped coated steel  
sheet products — Dimensional and  
shape tolerances**

*Tôles en acier revêtues en continu par immersion à chaud —  
Tolérances sur dimensions et forme*

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## Foreword

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Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. ISO shall not be held responsible for identifying any or all such patent rights.

ISO 16163 was prepared by Technical Committee ISO/TC 17, *Steel*, Subcommittee SC 12, *Continuous mill flat rolled products*.

This fourth edition cancels and replaces the third edition (ISO 16163:2010), which has been technically revised.

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# Continuously hot-dipped coated steel sheet products — Dimensional and shape tolerances

## 1 Scope

This International Standard applies to dimensional and shape tolerances for all continuously hot-dipped coated steel sheet products.

## 2 Dimensional tolerances

Dimensional tolerances are given in Tables 1 to 9.

**Table 1 — Thickness tolerances for commercial, drawing, drawing aluminium-killed, extra deep drawing stabilized interstitial free, and structural quality coils and cut lengths**

Dimensions and tolerances in millimetres

Specified width	Thickness tolerances <sup>a,b,c,d,e,f,g</sup> for specified thicknesses										
	≤ 0,4	> 0,4 ≤ 0,6	> 0,6 ≤ 0,8	> 0,8 ≤ 1,0	> 1,0 ≤ 1,2	> 1,2 ≤ 1,6	> 1,6 ≤ 2,0	> 2,0 ≤ 2,5	> 2,5 ≤ 3,0	> 3,0 ≤ 4,0	> 4,0 ≤ 5,0
600 ≤ 1 200	±0,04	±0,05	±0,06	±0,08	±0,09	±0,10	±0,12	±0,15	±0,16	±0,18	±0,19
> 1 200 ≤ 1 500	±0,05	±0,06	±0,06	±0,08	±0,09	±0,11	±0,13	±0,15	±0,17	±0,19	±0,21
> 1 500 ≤ 1 800	—	±0,07	±0,07	±0,09	±0,11	±0,13	±0,15	±0,17	±0,20	±0,22	±0,23

NOTE 1 Thicknesses up to 1,6 mm are generally produced with a cold-rolled substrate.

NOTE 2 When International Standards that reference this standard permit slitting sheet to less than 600 mm in width to be considered as sheet, tolerances shall be subject to agreement.

<sup>a</sup> Thickness tolerances for sheet in coil form are the same as for sheet supplied in cut lengths but, in cases where welds are present, the tolerances shall be double those given over a length of 15 m in the vicinity of the weld.

<sup>b</sup> Given the difference in tolerances and physical properties of hot-rolled and cold-rolled sheet products, the user and the supplier may negotiate a specific type of substrate. The relationship between the coating mass, in grams per square metre, and the thickness, in micrometres, can be retrieved from the respective standards.

<sup>c</sup> For specified strength levels of  $R_e = 360$  MPa and greater, tolerances are increased by 10 %, applying normal rounding-off procedures.

<sup>d</sup> Tolerances for grade 550 shall be as agreed upon between the purchaser and the manufacturer.

<sup>e</sup> Thickness is measured at any point on the sheet not less than 25 mm from a side edge.

<sup>f</sup> The specified thickness range captions apply as a specific value.

<sup>g</sup> The tolerances provided in this table are based on normal thickness (tolerance over and under). For ordered thicknesses other than nominal, the total tolerance is twice the tabled value and may be distributed as agreed upon between the buyer and seller.

**Table 2 — Thickness tolerances for commercial, drawing, drawing aluminium-killed, extra deep drawing (stabilized interstitial free) and structural quality coils and cut lengths — hot rolled substrate**

Dimensions and tolerances in millimetres

Specified width	Thickness tolerances <sup>a,b,c,d,e,f,g</sup> for specified thicknesses				
	≤ 2,0	> 2,0 ≤ 2,5	> 2,5 ≤ 3,0	> 3,0 ≤ 4,0	> 4,0 ≤ 5,0
600 ≤ 1 200	±0,14	±0,15	±0,16	±0,18	±0,20
> 1 200 ≤ 1 500	±0,15	±0,16	±0,18	±0,19	±0,22
> 1 500 ≤ 1 800	±0,15	±0,18	±0,20	±0,22	±0,23
NOTE 1 Thicknesses up to 1,6 mm are generally produced with a cold-rolled substrate.					
NOTE 2 When International Standards that reference this standard permit slitting sheet to less than 600 mm in width to be considered as sheet, tolerances shall be subject to agreement.					
<p><sup>a</sup> Thickness tolerances for sheet in coil form are the same as for sheets supplied in cut lengths but, in cases where welds are present, the tolerances shall be double those given over a length of 15 m in the vicinity of the weld.</p> <p><sup>b</sup> For specified strength levels of <math>R_e = 360</math> MPa and greater, tolerances are increased by 10 %, applying normal rounding-off procedures.</p> <p><sup>c</sup> Tolerances for grade 550 shall be as agreed upon between the purchaser and the manufacturer.</p> <p><sup>d</sup> Thickness is measured at any point on the sheet not less than 25 mm from a side edge.</p> <p><sup>e</sup> The relationship between the coating mass, in grams per square metre, and the thickness, in micrometres, can be retrieved from the respective standards.</p> <p><sup>f</sup> The specified thickness range captions apply as a specific value.</p> <p><sup>g</sup> The tolerances provided in this table are based on normal thickness (tolerance over and under). For ordered thicknesses other than nominal, the total tolerance is twice the tabled value and may be distributed as agreed upon between the buyer and seller.</p>					

**Table 3 — Width tolerances for coils and cut lengths, not resquared**

Dimensions and tolerances in millimetres

Specified width	Tolerance
≤ 1 500	+ 7 0
> 1 500 ≤ 1 800	+ 10 0
NOTE For resquared material, more restrictive tolerances are subject to negotiation.	

**Table 4 — Length tolerances for cut lengths, not resquared**

Dimensions and tolerances in millimetres

Specified length	Tolerance
≤ 3 000	+ 20 0
> 3 000 ≤ 6 000	+ 30 0
> 6 000	+ 0,5 % × length 0
NOTE For resquared material, more restrictive tolerances are subject to negotiation.	

**Table 5 — Camber tolerances for coils and cut lengths, not resquared**

Dimensions and tolerances in millimetres

Form	Camber tolerance
Coils	20 in any 5 000 length
Cut lengths	0,4 % × length
NOTE Camber is the greatest deviation of a side edge from a straight line, the measurement being taken on the concave side with a straight edge as shown in Figure 1. For resquared material, more restrictive tolerances are subject to negotiation.	

**Table 6 — Out-of-square tolerance for cut lengths, not resquared**

Dimensions	Out-of-square tolerance
All thicknesses and all sizes	0,7 % × width
NOTE 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 as shown in Figure 2. It can also be measured as one-half the difference between the diagonals of a cut length sheet.	

**Table 7 — Out-of-square tolerances for resquared material**

Dimensions and tolerances in millimetres

Specified length	Specified width	Out-of-square tolerance
≤ 3 000	≤ 1 200	+1 0
	> 1 200	+2 0
> 3 000	All widths	+2 0
NOTE 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 as shown in Figure 2. It can also be measured as one-half the difference between the diagonals of the cut length sheet. When measuring material ordered to resquared tolerances, consideration may have to be given to extreme variations in temperature.		

Table 8 — Standard flatness tolerances for cut lengths

Dimensions and tolerances in millimetres

Specified thickness	Specified width	Flatness tolerance Specified strength level of $R_e$		
		< 220 MPa	$\geq 220 \leq 340$ MPa	> 340 MPa
$\leq 0,7$	$\leq 1\,200$	14	17	20
	$> 1\,200 \leq 1\,500$	17	20	23
	$> 1\,500$	21	24	29
$> 0,7 \leq 1,2$	$\leq 1\,200$	12	15	18
	$> 1\,200 \leq 1\,500$	14	17	21
	$> 1\,500$	19	22	27
$> 1,2 \leq 2,0$	$\leq 1\,200$	12	12	18
	$> 1\,200 \leq 1\,500$	14	15	21
	$> 1\,500$	19	21	27
$> 2,0 \leq 5,0$	$\leq 1\,200$	16	16	20
	$> 1\,200 \leq 1\,500$	20	20	30
	$> 1\,500$	25	25	40

NOTE 1 This table also applies to sheet cut to length from coils by the customer when agreed-upon flattening procedures are performed.

NOTE 2 Maximum deviation from a flat horizontal surface: with the sheet lying under its own weight on a flat surface, the maximum distance between the lower surface of the sheet and the flat horizontal surface is the maximum deviation from flatness as shown in Figure 3.

Table 9 — Restricted flatness tolerances for cut lengths

Dimensions and tolerances in millimetres

Specified thickness	Specified width	Flatness tolerance Specified strength level of $R_e$		
		< 220 MPa	$\geq 220 \leq 340$ MPa	> 340 MPa
$\leq 0,7$	$\leq 1\,200$	7	10	—
	$> 1\,200 \leq 1\,500$	8	11	—
	$> 1\,500$	10	14	—
$> 0,7 \leq 1,2$	$\leq 1\,200$	6	8	—
	$> 1\,200 \leq 1\,500$	7	10	—
	$> 1\,500$	9	12	—
$> 1,2 \leq 2,0$	$\leq 1\,200$	6	7	—
	$> 1\,200 \leq 1\,500$	7	8	—
	$> 1\,500$	8	11	—
$> 2,0 \leq 5,0$	$\leq 1\,200$	6	7	—
	$> 1\,200 \leq 1\,500$	7	8	—
	$> 1\,500$	8	11	—

NOTE 1 This table also applies to sheet cut to length from coils by the customer when agreed-upon flattening procedures are performed.

NOTE 2 Maximum deviation from a flat horizontal surface: with the sheet lying under its own weight on a flat surface, the maximum distance between the lower surface of the sheet and the flat horizontal surface is the maximum deviation from flatness as shown in Figure 3.

More restrictive tolerances may be negotiated.