

COPPER AND BRASS
TYPICAL CONTINUOUS CAST ALLOYS
Recommended Clean-up Allowances

| Nominal O.D. Rods and Tubes | I.D. | O.D. |
|--------------------------------|-------|-------|
| to 4" O.D. | 1/32" | 1/32" |
| 4" to 5" O.D. | 1/16" | 1/16" |
| over 5" O.D. | 3/32" | 3/32" |

Note: For a few alloys, and for some special cases, more clean-up allowance may be required.

Dimensional Tolerances
(Variation in Average Dimensions)

| Rods and Tubes | I.D. | O.D. |
|-------------------------|---------------|---------------|
| to 4" O.D. | + .012"-.033" | + .004"-.006" |
| 4" to 5" O.D. | + .016"-.046" | + .006"-.010" |
| over 5" O.D. | + .032"-.064" | + .032"-.032" |
| other shapes (any size) | + .032"-.064" | + .032"-.032" |

Tube O.D. and I.D. concentric within 1-1/2% of wall thickness.

Note: For a few alloys, and for some special cases, wider tolerances may be required.

Straightness:

All products — 1/4" maximum arc depth 5" length. Rods and Tubes are Medart straightened. This operation smooths, burnishes and straightens to the same standards employed for wrought products. Other shapes are hand or press straightened.