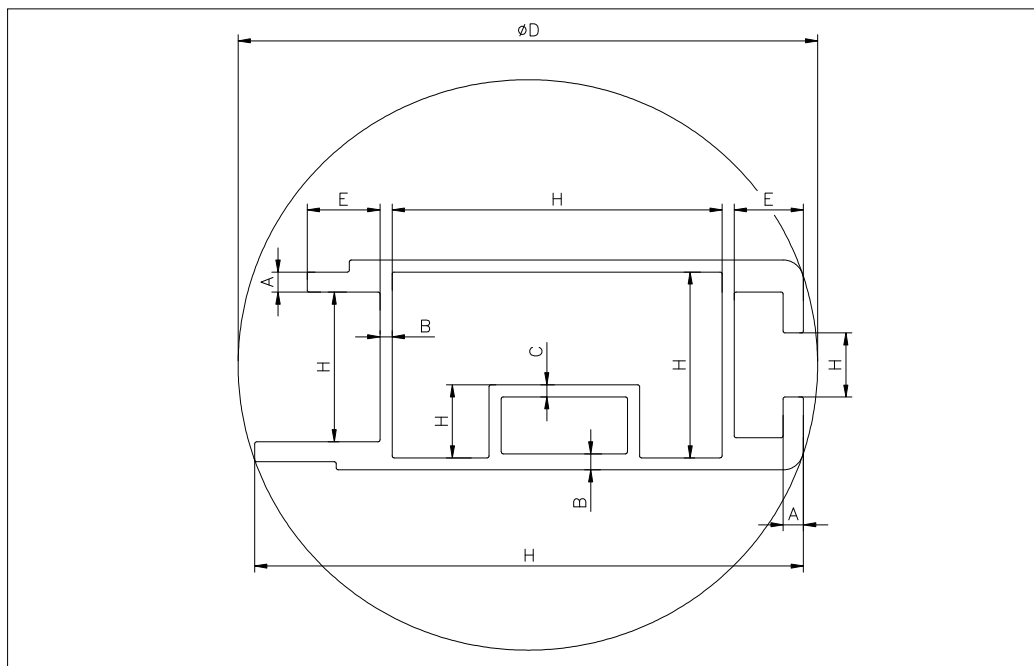


Alloys : EN AW-6060, EN AW-6063, EN AW-6101A, EN AW-6005A, EN AW-1050A

Dimension H		Tolerances on H for circumscribing circle D ±				
Over	Up to & incl.	D ≤ 100	100 < D ≤ 200	200 < D ≤ 300	300 < D ≤ 500	500 < D ≤ 800
-	10	0,25	0,30	0,35	0,40	0,50
10	25	0,30	0,40	0,50	0,60	0,70
25	50	0,50	0,60	0,80	0,90	1,0
50	100	0,70	0,90	1,1	1,3	1,5
100	150	-	1,1	1,3	1,5	1,7
150	200	-	1,3	1,5	1,8	2,0
200	300	-	-	1,7	2,1	2,4
300	450	-	-	-	2,8	3,0

Dimension E		Add.tol. on H for dim. across end of open end prof	Dimension E		Add.tol. on H for dim. across end of open end prof
Over	Up to & incl.		Over	Up to & incl.	
-	20	-	100	125	0,80
20	30	0,15	125	150	1,0
30	40	0,25	150	180	1,2
40	60	0,40	180	210	1,4
60	80	0,50	210	250	1,63
80	100	0,60	250	-	1,8

Nominal wall thickness A , B or C		Tolerance on wall thickness ± Circumscribing circle diameter max 300 mm.					
		Wall thickness A Circumscribing circle		Wall thickness B Circumscribing circle		Wall thickness C Circumscribing circle	
Over	Up to & incl.	D ≤ 100	100 < D ≤ 300	D ≤ 100	100 < D ≤ 300	D ≤ 100	100 < D ≤ 300
-	1,5	0,15	0,20	0,20	0,30	0,25	0,35
1,5	3	0,15	0,25	0,25	0,40	0,30	0,50
3	6	0,20	0,30	0,40	0,60	0,50	0,75
6	10	0,25	0,35	0,60	0,80	0,75	1,0
10	15	0,30	0,40	0,80	1,0	1,0	1,2
15	20	0,35	0,45	1,2	1,5	1,5	1,9
20	30	0,40	0,50	1,5	1,8	1,9	2,2



Tolerances on dimension and form EN 755-9, profiles

Alloys : EN AW-6060, EN AW-6063, EN AW-6101A, EN AW-6005A, EN AW-1050A

Convexity – concavity tolerances

Width W		Deviation $f \pm$ mm		
Over	Up to & incl.	Hollow profiles		Solid profiles
		$s \leq 5$	$s > 5$	
-	30	0,30	0,20	0,20
30	60	0,40	0,30	0,30
60	100	0,60	0,40	0,40
100	150	0,90	0,60	0,60
150	200	1,2	0,80	0,80
200	300	1,8	1,2	1,2

If the profile has different wall thickness in the measurement range the thinnest wall thickness shall be taken into account.

Local deviation may not exceed 0,7 mm / 100 mm.

Angularity tolerances

Width W		Deviation $f \pm$ mm
Over	Up to & incl.	
-	30	0,4
30	50	0,7
50	80	1,0
80	120	1,4
120	180	2,0
180	240	2,6
240	300	3,1

In case of unequal side lengths the tolerances on angularity shall be measured on the shorter side of the angle.

The maximum allowable deviation α for angles other than right shall be $\pm 1^\circ$.

Straightness tolerances

Length of profile mm	$1 \leq 1000$	$1000 < 1 \leq 2000$	$2000 < 1 \leq 3000$	$3000 < 1 \leq 4000$	$4000 < 1 \leq 5000$	$5000 < 1 \leq 6000$
Deviation mm	1,5	3,0	4,5	6,0	7,5	9,0

Dev. from straightness shall be meas. with the profile placed on a horiz. baseplate so that its mass decreases the deviation. The straightness tolerance shall not exceed 1,5 mm/m length. Local deviation shall not exceed 0,6 mm/300 mm length.

Twist tolerances

Width W		Twist tolerance T for a length L		
Over	Up to & incl.	Per 1000 mm of length	On total profile length	
			$l \leq 6000$	$l > 6000$
-	30	1,2	2,5	3,0
30	50	1,5	3,0	4,0
50	100	2,0	3,5	5,0
100	200	2,5	5,0	7,0
200	350	2,5	6,0	8,0

Twist tolerance for lengths less than 1 000 mm shall be subject to agreement between purchaser and supplier.

Tolerances on fixed length

Circumscribing circle diameter D		Tolerances on fixed length L mm			
Over	Up to & incl.	$1 \leq 2000$	$2000 < 1 \leq 5000$	$5000 < 1 \leq 10000$	$10000 < 1 \leq 15000$
		-	100	+ 5 0	+ 7 0
100	200	+ 7 0	+ 9 0	+ 12 0	+ 18 0
200	450	+ 8 0	+ 11 0	+ 14 0	+ 20 0

The squareness of cut ends shall be within half of the fixed length tolerance range specified in above table, e.g. for a fixed length tolerance of +10/-0 mm, the squareness of cut ends shall be within 5 mm.