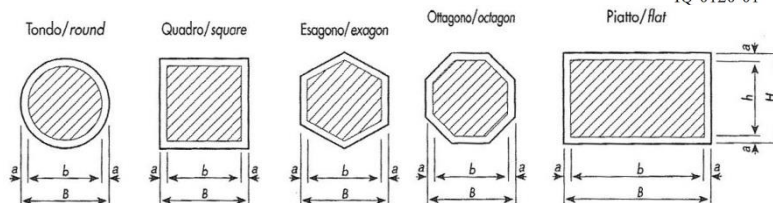


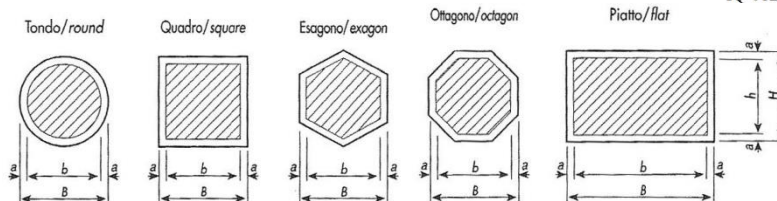
**HOT FORGED BARS**  
**ROUND, SQUARE, FLATS and HEXAGONALS**  
**Tolerances and Allowances,**  
**acc. to UNI 7486:75**



Finished dimensions b or h		Carbon Steels							
		Length L							
		Up to 3500 mm				Over 3500 mm up to 6000 mm			
		Allowances on b o h (2a)	Permissible variations B or H	Forging dimensions B or H		Allowances on b o h (2a)	Permissible variations B or H	Forging dimensions B or H	
over	up to			over	up to			over	up to
100	125	14	± 3,8	114	139	17	± 4,8	117	142
125	160	16	± 4,2	141	176	19	± 5,4	144	179
160	200	18	± 4,9	178	218	21	± 6,3	181	221
200	250	21	± 5,6	221	271	24	± 7,2	224	274
250	315	25	± 6,5	275	340	28	± 8,4	278	343
315	400	30	± 7,7	345	430	33	± 10,0	348	433
400	500	36	± 9,2	436	536	40	± 11,9	440	540
500	630	44	± 11,0	544	674	48	± 14,3	548	678
630	800	54	± 13,5	684	854	58	± 17,4	688	855
800	1000	66	± 16,3	866	1066	71	± 21,3	871	1071

Finished dimensions b or h		Alloyed Steels							
		Length L							
		Up to 3500 mm				Over 3500 mm up to 6000 mm			
		Allowances on b o h (2a)	Permissible variations B or H	Forging dimensions B or H		Allowances on b o h (2a)	Permissible variations B or H	Forging dimensions B or H	
over	up to			over	up to			over	up to
100	125	10	± 2,0	110	135	13	± 4,0	113	138
125	160	12	± 2,3	137	172	15	± 4,6	140	175
160	200	14	± 2,8	174	214	18	± 5,2	178	218
200	250	17	± 3,4	217	267	21	± 6,0	221	271
250	315	21	± 4,2	271	336	24	± 7,0	274	339
315	400	26	± 5,1	341	426	29	± 8,4	344	429
400	500	32	± 6,3	432	532	35	± 10,0	435	535
500	630	39	± 7,8	539	669	42	± 12,0	542	672
630	800	49	± 9,8	679	849	52	± 14,9	682	852
800	1000	61	± 12,1	861	1061	64	± 18,1	864	1064

**HOT FORGED BARS**  
**ROUND, SQUARE, FLATS and HEXAGONALS**  
Tolerances and Allowances,  
acc. to **UNI 7486:75**



Finished dimensions b or h		Tool Steels							
		Length L							
		Up to 3500 mm				Over 3500 mm up to 6000 mm			
		over	up to	Allowances on b o h (2a)	Permissible variations B or H over	Forging dimensions B or H		Allowances on b o h (2a)	Permissible variations B or H
over	up to					over	up to		
100	125	7	± 1,5	107	132	10	± 2,1	110	135
125	160	9	± 1,8	134	169	12	± 2,5	137	172
160	200	11	± 2,2	171	211	14	± 2,9	174	214
200	250	13	± 2,6	213	263	17	± 3,5	217	267
250	315	16	± 3,2	266	331	21	± 4,2	271	336
315	400	19	± 4,0	334	419	26	± 5,0	341	426
400	500	24	± 4,9	424	524	32	± 6,2	432	532
500	630	30	± 6,0	530	660	39	± 7,5	539	669
630	800	37	± 7,4	667	837	49	± 9,4	679	849
800	1000	46	± 9,3	846	1046	61	± 11,6	861	1061