



RECTANGULAR BLOOMS – BL 900 ROLLED SIZES

SIZES REQUIRED BY CUSTOMER mm x mm	SIZES WIDTHxTHICKNESS mm x mm	WEIGHT kg/mt	WIDTH TOLERANCE mm		THICKNESS TOLERANCE mm		RADIUS mm
200 x 80	212 X 86	142.15	+ 5	- 5	+ 5	- 5	12
200 x 100	212 X 107	176.55	+ 5	- 5	+ 5	- 5	15
200 x 120	212 X 127	209.84	+ 5	- 5	+ 5	- 5	15
200 x 150	216 X 158	264.64	+ 5	- 5	+ 5	- 5	22
200 x 180	217 X 188	316.04	+ 5	- 5	+ 5	- 5	25
250 x 80	262 X 86	175.91	+ 5	- 5	+ 5	- 5	12
250 x 100	262 X 107	218.55	+ 5	- 5	+ 5	- 5	15
250 x 120	262 X 127	259.68	+ 5	- 5	+ 5	- 5	15
250 x 150	266 X 158	326.66	+ 5	- 5	+ 5	- 5	22
250 x 180	267 X 188	389.83	+ 5	- 5	+ 5	- 5	25
250 x 200	267 X 208	431.75	+ 5	- 5	+ 5	- 5	25
300 X 80	313 X 86	210.34	+ 6	- 6	+ 5	- 5	12
300 X 100	313 X 107	261.39	+ 6	- 6	+ 5	- 5	15
300 X 120	313 X 127	310.53	+ 6	- 6	+ 5	- 5	15
300 X 150	317 X 158	389.91	+ 6	- 6	+ 5	- 5	22
300 X 180	318 X 188	465.09	+ 6	- 6	+ 5	- 5	25
300 X 200	318 X 208	515.02	+ 6	- 6	+ 5	- 5	25
300 X 250	323 X 260	650.99	+ 6	- 6	+ 5	- 5	35
350 X 80	364 X 86	244.77	+ 7	- 7	+ 5	- 5	12
350 X 100	364 X 107	304.23	+ 7	- 7	+ 5	- 5	15
350 X 120	364 X 127	361.37	+ 7	- 7	+ 5	- 5	15
350 X 150	368 X 158	453.17	+ 7	- 7	+ 5	- 5	22
350 X 180	369 X 188	540.36	+ 7	- 7	+ 5	- 5	25
350 X 200	369 X 208	598.29	+ 7	- 7	+ 5	- 5	25
350 X 250	374 X 260	755.08	+ 7	- 7	+ 5	- 5	35
400 X 80	415 X 86	279.20	+ 8	- 8	+ 5	- 5	12
400 X 100	415 X 107	347.06	+ 8	- 8	+ 5	- 5	15
400 X 120	415 X 127	412.22	+ 8	- 8	+ 5	- 5	15
400 X 150	419 X 158	516.42	+ 8	- 8	+ 5	- 5	22
400 X 180	420 X 188	615.62	+ 8	- 8	+ 5	- 5	25
400 X 200	420 X 208	681.56	+ 8	- 8	+ 5	- 5	25
400 X 250	425 X 260	859.17	+ 8	- 8	+ 5	- 5	35
450 X 80	466 X 86	313.63	+ 9	- 9	+ 5	- 5	12
450 X 100	466 X 107	389.90	+ 9	- 9	+ 5	- 5	15
450 X 120	466 X 127	463.06	+ 9	- 9	+ 5	- 5	15
450 X 135	460 X 140	514.35	+ 9	- 9	+ 5	- 5	~18
450 X 150	470 X 158	579.68	+ 9	- 9	+ 5	- 5	22
450 X 180	471 X 188	690.89	+ 9	- 9	+ 5	- 5	25
450 X 200	471 X 208	764.84	+ 9	- 9	+ 5	- 5	25
450 X 250	476 X 260	963.26	+ 9	- 9	+ 5	- 5	35



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SIZES REQUIRED BY CUSTOMER mm x mm	SIZES WIDTHxTHICKNESS mm x mm	WEIGHT kg/mt	WIDTH TOLERANCE mm		THICKNESS TOLERANCE mm		RADIUS mm
500 X 80	517 X 86	348.06	+ 10	- 10	+ 5	- 5	12
500 X 100	517 X 107	432.74	+ 10	- 10	+ 5	- 5	15
500 X 120	517 X 127	513.91	+ 10	- 10	+ 5	- 5	15
500 X 150	521 X 158	642.93	+ 10	- 10	+ 5	- 5	22
500 X 180	522 X 188	766.16	+ 10	- 10	+ 5	- 5	25
500 X 200	522 X 208	848.11	+ 10	- 10	+ 5	- 5	25
500 X 250	527 X 260	1067.35	+ 10	- 10	+ 5	- 5	35
550 X 80	568 X 86	382.49	+ 11	- 11	+ 5	- 5	15
550 X 100	568 X 107	475.58	+ 11	- 11	+ 5	- 5	15
550 X 120	568 X 127	564.75	+ 11	- 11	+ 5	- 5	22
550 X 150	572 X 158	706.19	+ 11	- 11	+ 5	- 5	25
550 X 180	573 X 188	841.42	+ 11	- 11	+ 5	- 5	25
550 X 200	573 X 208	931.38	+ 11	- 11	+ 5	- 5	35
550 X 250	578 X 260	1171.44	+ 11	- 11	+ 5	- 5	35
600 X 80	619 X 86	416.92	+ 12	- 12	+ 5	- 5	15
600 X 100	619 X 107	518.41	+ 12	- 12	+ 5	- 5	15
600 X 120	623 X 127	615.60	+ 12	- 12	+ 5	- 5	22
600 X 150	624 X 158	769.45	+ 12	- 12	+ 5	- 5	25
600 X 180	624 X 188	916.69	+ 12	- 12	+ 5	- 5	25
600 X 200	629 X 208	1014.66	+ 12	- 12	+ 5	- 5	35
600 X 250	629 X 260	1275.53	+ 12	- 12	+ 5	- 5	35
650 X 80	670 X 86	451.35	+ 13	- 13	+ 5	- 5	12
650 X 100	670 X 107	561.25	+ 13	- 13	+ 5	- 5	15
650 X 120	674 X 127	666.44	+ 13	- 13	+ 5	- 5	15
650 X 150	675 X 158	832.70	+ 13	- 13	+ 5	- 5	22
650 X 180	675 X 188	991.95	+ 13	- 13	+ 5	- 5	25
650 X 200	680 X 208	1097.93	+ 13	- 13	+ 5	- 5	25
650 X 250	680 X 260	1397.62	+ 13	- 13	+ 5	- 5	35
700 X 80	713 X 86	480.00	+ 10	- 10	+ 5	- 5	15
700 X 100	713 X 107	597.00	+ 10	- 10	+ 5	- 5	20
700 X 120	715 X 127	708.00	+ 10	- 10	+ 5	- 5	23
700 X 150	715 X 158	883.00	+ 10	- 10	+ 5	- 5	25
700 X 180	720 X 188	1051.00	+ 10	- 10	+ 5	- 5	32
700 X 200	720 X 208	1169.00	+ 13	- 13	+ 5	- 5	35
700 X 250	720 X 260	1461.00	+ 13	- 13	+ 5	- 5	36



700 ROUND – CORNERED SQUARES

SIDE mm	RADIUS mm	Dia. Tol. UNI 7063	Dia. Tol. DIN 1014 pt. 1
80	15	± 2% x Lato	± 1.0 mm
85	15		
86	15		
90	14	particular channels not ABS STD	± 1.3 mm
92	14	particular channels not ABS STD	
94	14		
95	14		
96	14	particular channels not ABS STD	
100	13		
100	18		
105	13		
105	18		
106	13	particular channels not ABS STD	± 1.5 mm
106	18		
110	18		
115	18		
120	18		
120	22		
125	18		
125	22		
130	22		
135	22		
137	22.5	not ABS STD	not indicated, ABS guarantee: ± 2% x Side
140	23		
145	23		
ARROW UNI 7063 (normal):10mm/mt (average) - 20 mm/mt (localized); (guarantee of arrow obtainable after repairing)			
WARPING: UNI 7063 = 4°/mt with 15° max for lengths≤6 mt and 20° max for lengths>6 mt			
SIDE (inches)	TOL.	DIAGONAL (mm)	TOL. (mm)
3½"	± 1 %	115.7	± 1.3
4¼"	± 1 %	140.7	± 1.6
5"	± 1 %	164.7	± 1.8
5"	± 1 %	161.4	± 1.8
5½"	± 1 %	179.4	± 2
ASTM A29 (normal) ¼"/5 feet=4 mm/mt (guarantee of arrow obtainable after repairing)			



900 ROUND - CORNERED SQUARES

SIDE mm	RADIUS mm	Dia. Tol. UNI 7063	Dia. Tol.. DIN 1014 pt.1
150	23	± 2% x Side	NOT INDICATED (ABS guarantee ± 2% x Side)
155	23		
160	23		
160	23		
160	23		
160	22		
160	23		
165	25		
170	23		
170	25		
170	23		
170	23		
180	23		
180	25		
185	25		
190	26		
195	26		
200	26		
200	25		
215	30		
220	30		
225	28		
225	31		
230	30		
250	30		
250	34		
250	35		
300	40		
300	36		
300	38		
310	40		
310	46		
315	35		
320	35		
355	48		
420	50		
500	=		
ARROW: UNI 7063 (normal): 10mm/mt (average)-20 mm/mt (localized); (guarantee of arrow obtainable after repairing)			
WARPING: UNI 7063 = 4°/mt width 15° max. for lengths≤6 mt and 20° max. for lengths>6 mt			
SIDE (inches)	TOL. (mm)	DIAGONAL (mm)	TOL. (mm)
* 6"	± 2.5	270	± 3.5
* 8"	± 2.5	200.6	± 3.5
ASTM A29 (normal) ¼"/5 feet=4 mm/mt (guarantee of arrow obtainable after repairing)			

* : CHANNELS WITH PARTICULAR TOLERANCES



ROUNDS - REV. 700 DIAMETERS

NOMINAL DIAMETER mm	Dim. Tol. UNI 7620/a mm	Tdim. Tol. DIN 1013 mm
110	± 1.4	± 1.8
115	± 1.4	± 1.8
120	± 1.4	± 1.8
125	± 1.8	± 1.8
130	± 1.8	± 2.0
135	± 1.8	± 2.0
140	± 1.8	± 2.0
145	± 1.8	± 2.0
150	± 1.8	± 2.0
155	± 1.8	± 2.0
160	± 2.3	± 2.5
166 *	± 2.3	± 2.5
170	± 2.3	± 2.5
180	± 2.3	± 2.5
185	± 2.3	± 2.5
190 *	± 2.3	± 2.5
200	± 2.3	± 2.5

* : CHANNELS WITH SPECIAL CROSS SECTIONS
ARROW: UNI 7620 (restricted): 2 mm/m max. up to 160 mm max. over (n. internal) 2.5 mm/m (guarantee of arrow obtainable after repairing)
OVALITY= 80% TOLERANCE ON DIAMETER – E.g. ovality UNI ø 160 mm=[(2.3 X 2) X 0.8]= 3.7 mm
REMARK: the shrinkage ratio (between hot and cold dimension) is = 1.014



ROUNDS – BLOOMING 900 DIAMETERS

NOMINAL DIAMETER mm	Dim. Tol. UNI 7620/a mm	Dim. Tol. DIN 1013 mm
210 *	± 2.3	not indicated, ABS guarantee: ± 1.5%
220 *		
230	not indicated ABS guarantee: ± 1.5% Tolerances rederred tol cold dia.	
240		
250		
260		
270		
280		
300		
320		
370		
405		
* CHANNELS WITH SPECIAL CROSS SECTIONS		
CAMBER (n. internal): 2.5 mm/m (guarantee of camber obtainable after repairing)		
OVALITY = 80% TOLERANCE ON DIAMETER – E.g. ovality UNI ø 160 mm=[(2.3 X 2) X 0.8]=3.7 mm		



ROUNDS IN INCHES

NOMINAL DIAMETERS IN INCHES	DIA. CONVERSION TO mm	DIM. TOL. ON NOMINAL DIA. IN INCHES (ASTM A29)		DIM. TOL. ON NOMINAL DIA. IN mm (ASTM A29)	
4 1/2"	114.3	+ 1/16	- 0	+ 1.587	- 0
4 3/4"	120.7	+ 5/64	- 0	+ 1.984	- 0
5"	127.0	+ 5/64	- 0	+ 1.984	- 0
5 1/2"	139.7	+ 5/64	- 0	+ 1.984	- 0
6 1/4"	158.8	+ 1/8	- 0	+ 3.175	- 0
6 1/2"	165.1	+ 1/8	- 0	+ 3.175	- 0
7"	177.8	+ 5/32	- 0	+ 3.969	- 0
7 1/4"	184.2	+ 5/32	- 0	+ 3.969	- 0
8 1/4"	209.6	+ 5/32	- 0	+ 3.969	- 0
9"	228.6	+ 3/16	- 0	+ 4.762	- 0
9 3/4"	247.7	+ 1/4	- 0	+ 6.350	- 0
10 1/2"	266.7	ABS guarantee ± 1.5 %		ABS guarantee ± 1.5 %	
11"	279.4				
11 3/4"	298.5				
12 1/2"	317.5				
14 1/2"	368.3				
15 3/4"	400.03	ANOMALOUS CROSS SECTION			

ASTM A29 (normal) 1/4"/5 feet=4 mm/m (guarantee of camber obtainable after repairing)