



FORGINGS

1. Forging allowance and section dimensional tolerances, in accordance with UNI 7486 – DIN 7527, column concerning “Unalloyed or low-alloyed steel products” with lengths up to 3500 mm. Dimensions, finishing conditions and relevant dim. tolerances shall be indicated in the order, as per ASTM A788.
2. Min. acceptable tolerance: sections $\leq 400 \pm 5$ mm - sections $\leq 500 \pm 7.5$ mm - sections $\leq 800 \pm 10$ mm
3. Shape error: (ovality or out-of-roundness, for round sections only) shall not be higher than the tolerance foreseen for that diameter. Please refer to UNI 7226 part 1: in case of out-of-squareness for square sections, please refer to UNI 7063.
4. Camber: 2.5 mm/m
5. Internal defects: UT 100% $\varnothing < 400$ mm F. eq. ≤ 2 mm - \varnothing from 401÷500 mm F. eq. ≤ 3 mm - \varnothing 501÷800 mm F. eq. ≤ 5 mm
6. Surface defects: 1% max. of the section or according to the order, checked with at-sight method, unless otherwise indicated. Conditioning with sampling only for dealers with repairing within dimensional tolerances for users (same cycle as for rolled products).

SECTIONS FROM ÷ TO mm	TOL. UNI - DIN mm (Internal)	OVALITY mm	ARROW mm/m max.	ALLOWANCES TURNED (mm)	ALLOWANCES GROUND (mm)
210÷250 (only for turned/ground)	±5.6 (±5)	11.2	2.5	20	10
251÷315	±6.5 (±5)	13	2.5		
316÷370	±7.7 (±5)	15.4	2.5		
371÷400	±7.7 (±5)	15.4	2.5		
401÷500	±9.2 (±7.5)	18.4	-	30	20
501÷630	±11 (±10)	22	-		
631÷800 *	±13.5 (±10)	27	-		
* For turned/ground products this range is reduced to 770÷780				1 RUN=18 mm a.	1 RUN=3/10 mm a.
				Allowances applicable only on cambers	

PLEASE NOTE THAT FOR SECTIONS NOT CONSIDERED HERE, YOU SHOULD REFER TO UNI 7063 REMARK - THE MIN. AND MAX. DIMENSIONS OF THE SECTIONS ARE NOT OBLIGATORY. THEY ARE THE ONES AGREED AND FEASIBLE TO DATE.