



# IRVON STANDARD TOLERANCES

At Irvon we take pride in being able to offer the highest standards of accuracy in our products.

Through modern production techniques, a high standard of experienced workmanship and exhaustive quality control procedures; we will typically offer the tolerances below.

## Shearing

Squareness tolerance (mm)

<i>Thk</i>	Lengths			
	<1000	1000+	5000+	12000+
<2	2	2	4	6
2+	2	4	4	6
5+	2	4	4	6
8+	4	4	6	8
10+	4	6	6	8
12+	6	6	6	8

Dimensional tolerance (mm)

<i>Thk</i>	Lengths			
	<1000	1000+	5000+	12000+
<2	±1	±1	±1	±2
2+	±1	±1	±2	±2
5+	±1	±1	±2	±2
8+	±1	±1	±2	±2
10+	±1	±1	±2	±3
12+	±1	±1	±2	±3

This document is intended as an indication of our typical production standards; however, the tolerances stated can vary and is dependent upon factors specific to certain jobs. Any tolerance requirements should be confirmed when placing an order.



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## 3D Plasma

Thk	Lengths			
	<1000	1000+	5000+	12000+
<5	±1	±1	±1	±2
5+	±1	±1	±2	±2
10+	±1	±1	±2	±2
15+	±1	±1	±2	±2
20+	±1	±1	±2	±3
25+	±2	±1	±2	±3

We can offer  $\pm 2^\circ$  on all bevel cuts. All lengths measured from bevelled edges will have an additional 1mm added onto the tolerances above.

## Plate Rolling

Thk	Diameter				
	<1000	1000+	2000+	3000+	4000+
<10	±3	±5	±6*	±8*	±10*
10+	±3	±5	±6	±8*	±10*
50+	±5	±5	±6	±8	±10*
100+	±5	±6	±6	±8	±10
150+	-	-	±6	±8	±10

These tolerances apply to full cylinders; Tolerances for segments are comparable but are **not measured or quoted as “diametric”**.

\*Parts that are thin relative to diameter are flexible during handling and transit.

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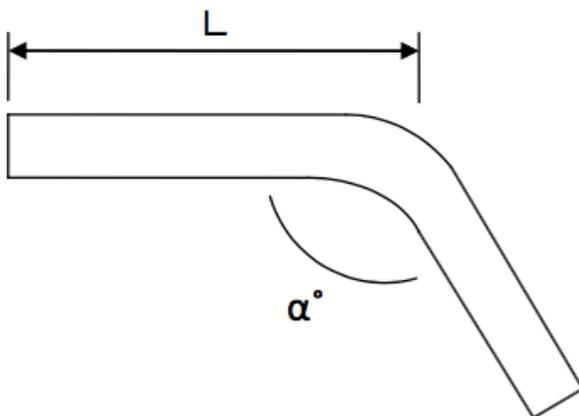


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Our press is the largest and most accurate in the country, rated at 1300 tons and able to offer pressings of up to 12.5m. We can therefore offer our customers unique specifications for pressed products. *Please enquire for more details.*

Leg Lengths (L)<sup>1</sup>

Thk	<1000	1000+	3000+
<2	±1	±1	±2
2+	±1	±1.5	±2
3+	±1	±1.5	±2
6+	±1	±1.5	±2
8+	±1.5	±2	±2
10+	±1.5	±2	±2.5
15+	±1.5	±2	±2.5
20+	±2	±2	±2.5
25+	±2	±2	±3
30+	±3	±3	±4
40+	±3	±3	±4



<sup>1</sup> All tolerances for the pressed legs apply to dimensions dependent upon at most 2 pressed angles.

In terms of angles ( $\alpha$ ), the above table implies to a rough guideline of at most  $\pm 1^\circ$  for typical pressed jobs.

<sup>2</sup> This is highly dependent upon the specifics of each job.

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