

RECOMMENDED MACHINING ALLOWANCES

In selecting a feed stock bar size, it is recommended that the following allowances be added to the finish part size. Recommendations are for part lengths 4 times to diameter ratio. Longer components may require larger amounts.

BLACK BARS		HOT FINISHED
Feed Stock		Minimum allowance
Sizes mm		on diameter
	≤ 16	0.80
> 16	≤ 22	1.10
> 22	≤ 24	1.15
> 24	≤ 27	1.25
> 27	≤ 30	1.40
> 30	≤ 36	1.50
> 36	≤ 39	1.70
> 39	≤ 50	2.10
> 50	≤ 65	2.60
> 65	≤ 75	3.60
> 75	≤ 130	6.40
> 130	≤ 215	9.50
> 215	≤ 300	12.0
> 300	≤ 400	15.0
> 400	≤ 550	20.0

COLD SIZED BARS		Minimum allowance
Feed stock		on diameter
Sizes mm		
	≤ 20	0.55
> 20	≤ 25	0.60
> 25	≤ 30	0.70
> 30	≤ 35	0.75
> 35	≤ 40	0.85
> 40	≤ 50	1.10
> 50	≤ 70	1.30

PEELED BARS		Minimum allowance
Feed stock		on diameter
Sizes mm		
> 10	≤ 40	0.25
> 40	≤ 65	0.60
> 65	≤ 215	1.50
> 215	≤ 400	4.00
> 400	≤ 550	6.00