



Standard Workmanship Tolerances

ACAD-016a Rev 2

FREIGHT DAMAGE

Upon receipt of material, if anything appears to be damaged (skid, packaging, and / or metal itself), the Bill of Lading must be signed and noted as "Received Damaged". Photographs must be taken while still in the truck or container. ACA will not open up any freight claims unless the BOL is signed as described above, and photographs are supplied. For freight collect, it is the customer's responsibility to file a transit claim.

PROBLEMS DISCOVERED IN COILS OR SKIDS OF SHEETS

If a quality issue is discovered when a coil is first put up, or within a stack of sheets, the customer is authorized to go 10% into the coil or skid to see if the problem clears up. If the issue does clear up, the discrepant material will be credited, pending verification of the defect by ACA personnel. If the problem does not clear up after going in 10%, the customer must stop processing the coil or sheets, and initiate a claim with ACA. No credit will be given for material which has been sheeted (from coil) or formed (from coil or sheets) beyond the 10%. The reason for this is that we may be able to salvage such material for another use.

CONDITIONS SPECIFIC TO COILED MATERIAL

Coiled material may have non-conforming material at the very outer or very inner wraps. This is inherent to coil processing and should not be cause for rejection. Additionally, there may be splices within the protective masking applied to the metal anywhere within the coil. This will typically be for a relatively short length, and again, is not cause for rejection.

TERMS AND CONDITIONS

The above notes are not meant to be all inclusive. Please refer to the Terms and Conditions of Sale.

GAUGE TOLERANCE (+/-)

| Specified Gauge | | Non-Etched* | | Etched** | |
|-----------------|---------|-------------|-----------|----------|---------|
| Over | Through | ≤39.37" | >39.37" | ≤39.37" | >39.37" |
| 0.002" | 0.0059" | 10% gauge | 10% gauge | N/A | N/A |
| 0.0059" | 0.010" | 0.0010" | 0.0015" | N/A | N/A |
| 0.010" | 0.016" | 0.0010" | 0.0015" | 0.0025" | 0.0030" |
| 0.016" | 0.025" | 0.0015" | 0.0020" | 0.0035" | 0.0040" |
| 0.025" | 0.032" | 0.0015" | 0.0020" | 0.0035" | 0.0040" |
| 0.032" | 0.039" | 0.0020" | 0.0020" | 0.0040" | 0.0040" |
| 0.039" | 0.047" | 0.0020" | 0.0020" | 0.0040" | 0.0040" |
| 0.047" | 0.063" | 0.0020" | 0.0030" | 0.0040" | 0.0050" |

*Mill tolerance as received - Nominal values. Varies slightly from mill to mill. Please inquire for specific values.

**Dependent upon the level of desired etch (kiss etch, light, medium, heavy)

WIDTH TOLERANCE (+/-), FULL WIDTH COIL FROM MILL, all gauges to 0.063"

Please inquire; mill and width specific.

For bright sheet, edge trimmed coils in the range 0.008" ~ 0.040", typical width tolerance is +0.059/-0"

For bright sheet, rolled edge coils in the range 0.008" ~ 0.040", typical width tolerance is +0.118/-0"



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WIDTH TOLERANCE (+/-), SLIT COILED SHEET, all gauges to 0.063"

| Specified Width | | 60" Slitter |
|-----------------|---------|-------------|
| Over | Through | |
| | 12" | 0.005" |
| 12" | 24" | 0.015" |
| 24" | 48" | 0.020" |
| 48" | 60" | 0.030" |

LENGTH TOLERANCE (+/-), SHEARED FLAT SHEET, all gauges to 0.063"

| Specified Length | | RBI Sheeting Line | L&F Blanking Line |
|------------------|---------|-------------------|-------------------|
| Over | Through | | |
| | 30" | 0.030" | 0.015" |
| 30" | 60" | 0.040" | 0.020" |
| 60" | 120" | 0.060" | 0.030" |
| 120" | 144" | 0.080" | ----- |

SQUARENESS TOLERANCE (+/-), SHEARED FLAT SHEET, (allowable difference of two diagonals), all gauges to 0.063"

| Specified Length | | RBI Sheeting Line | L&F Blanking Line |
|------------------|---------|-------------------|-------------------|
| Over | Through | | |
| | 48" | 0.020" | 0.020" |
| 48" | 96" | 0.040" | 0.032" |
| 96" | 144" | 0.060" | 0.032" |

BURR TOLERANCE, all equipment

Max. 10% of metal thickness,
not to exceed 0.003"

LATERAL BOW (CAMBER), all equipment (up to 0.063" gauge)

| Specified Width | | inches bow in 4 foot length | equivalent ACA Standard inches bow in 6 foot length |
|-----------------|---------|-----------------------------|--|
| Over | Through | | |
| | 2" | 0.250" | 0.5625" |
| 2" | 4" | 0.1667" | 0.375" |
| 4" | | 0.090" | 0.2025" |

LATERAL BOW (CAMBER) - Tannenbaum all equipment (up to 0.064" gauge)

All Widths

inches bow in 48 inch length
0.045"

equivalent ACA Standard
inches bow in 6 foot length
0.100"



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TRANSVERSE BOW (CROSS BOW), RBI Sheeting Line, all gauges through 0.063"

| Specified Width | | RBI Sheeting Line | | Embossed |
|-----------------|---------|-------------------|--------------|----------|
| Over | Through | ≤ 24" | > 24" | |
| 0.0059" | 0.020" | By Agreement | By Agreement | 0.750" |
| 0.020" | 0.063" | 0.125" | 0.250" | 0.750" |

FLATNESS, RBI Sheeting Line, all gauges through 0.063"

Distance Between Waves

| Over | Through | allowable deviation from flat |
|------|---------|-------------------------------|
| | <8" | wavelength < 8" not allowed |
| 8" | 32" | wavelength / 100 (25 I-Units) |
| 32" | | 0.32" max |

NOTE: Flatness criteria DO NOT apply to material supplied in coil form, or material which is only run through a straightener at the customer's location. If a customer has a corrective leveler, and finds that they cannot level the material, they should contact ACA for instructions.