

## Plasma Cutting

### *Tolerance Guidelines:*

*Material tolerances not listed below shall be in accordance with the ASTM, ASME, or AMS specification to which the material was produced and certified.*

### **Southern Service Center (USA)**

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|                         |                                    |
|-------------------------|------------------------------------|
| Thickness:              | 0.187" to 1.50"                    |
| Bed size:               | 110" x 300"                        |
| Minimum width/length:   | 2× thickness with a minimum of 1". |
| Minimum cut shape size: | 2× thickness with a minimum of 1". |
| Minimum hole size:      | 2× thickness with a minimum of 1". |
| Kerf:                   | Approximately 0.50"                |

**Standard plasma cutting tolerances that apply to both the top and bottom surfaces are as follows:**

- Up to 0.250" thick: + 0.125", -0 OD/ID + 0.125"/-0 OD & +0/-0.125" ID
- .250" to 1.00" thick: + 0.1875", -0 OD/ID + 0.1875"/-0 OD & +0/-0.1875" ID
- >1.00" thick: + 0.250", -0 OD/ID + 0.250"/-0 OD & +0/-0.250" ID
- Diagonal tolerance: 3/16" maximum on plasma cut items.
- Over 1.50" thick will be waterjet cut at outside source; please refer to [waterjet tolerances](#).

If you require tighter tolerances, please contact one of our [sales representatives](#).