

## Ornamental Tube ASTM A554

### Standard Dimension

Outside Diameter		Wall Thickness(mm)		
ASTMA-554		1.00	1.20	1.50
in	mm			
0.500	12.70	●	○	
0.630	16.00	●	●	
0.748	19.00	●	●	
0.874	22.20	○	○	○
1.000	25.40	●	●	●
1.252	31.80	●	●	●
1.500	38.10		●	●
1.750	44.45		●	●
2.000	50.80		●	●
2.50	63.50		●	●
3.00	76.20		●	●
4.00	101.60			●

○ =Made to order ● =Usual production

Note:Other sizes required upon request

### Diameter, Wall,<sup>4</sup> and Ovality Tolerances for Tubing with Bead Removed

OD Size, in. (mm)	OD, ±		ID, ±	
	in	mm	in	mm
Up to 3/32 (2.4), excl	0.001	0.03	0.001	0.03
3/32 to 3/16 (2.4 to 4.8), excl	0.0015	0.038	0.0015	0.038
3/16 to 1/2 (4.8 to 12.7), excl	0.003	0.08	0.005	0.13
1/2 to 1 (12.7 to 25.4), excl	0.004	0.10	0.006	0.15
1 to 1 1/2 (25.4 to 38.1),excl	0.005	0.13	0.007	0.18
1 1/2 to 2 (38.1 to 50.8),excl	0.006	0.15	0.008	0.20
2 to 2 1/2 (50.8 to 63.5),excl	0.007	0.18	0.010	0.25
2 1/2 to 3 1/2 (63.5 to 88.9),excl	0.010	0.25	0.014	0.36
3 1/2 to 5 (88.9 to 127.0),incl	0.015	0.38	0.020	0.51

Over 5 to 16 (127.0 to 406.4), incl 0.00125 in./in. or mm/mm of circumference 0.0013 in./in. or mm/mm of circumference

A Wall tolerance is 610 % of specified wall thickness.

### Diameter, Wall,<sup>4</sup> and Ovality Tolerances (All Conditions Except Tubing with Bead Removed)

OD Size, in. (mm)	Wall Thickness		OD, ±	
	in	mm	in	mm
Under 1/2 (12.7)	0.020 to 0.049	0.51 to 1.24	0.004	0.10
1/2 to 1 (12.7 to 25.4)	0.020 to 0.065	0.51 to 1.65	0.005	0.13
1/2 to 1 (12.7 to 25.4)	over 0.065 to 0.134	over 1.65 to 3.40	0.010	0.25
Over 1 to 1 1/2 (25.4 to 38.1), incl	0.025 to 0.065	0.64 to 1.65	0.008	0.20
Over 1 to 1 1/2 (25.4 to 38.1), incl	over 0.065 to 0.134	over 1.65 to 3.40	0.010	0.25
Over 1 1/2 to 2 (38.1 to 50.8), incl	0.025 to 0.049	0.64 to 1.24	0.010	0.25
Over 1 1/2 to 2 (38.1 to 50.8), incl	over 0.049 to 0.083	over 1.24 to 2.11	0.011	0.28
Over 1 1/2 to 2 (38.1 to 50.8), incl	over 0.083 to 0.149	over 2.11 to 3.78	0.012	0.30
Over 2 to 2 1/2 (50.8 to 63.5), incl	0.032 to 0.065	0.81 to 1.65	0.012	0.30
Over 2 to 2 1/2 (50.8 to 63.5), incl	over 0.065 to 0.109	over 1.65 to 2.77	0.013	0.33
Over 2 to 2 1/2 (50.8 to 63.5), incl	over 0.109 to 0.165	over 2.77 to 4.19	0.014	0.36
Over 2 1/2 to 3 1/2 (63.5 to 88.9), incl	0.032 to 0.165	0.81 to 4.19	0.014	0.36
Over 2 1/2 to 3 1/2 (63.5 to 88.9), incl	over 0.165	over 4.19	0.020	0.51
Over 3 1/2 to 5 (88.9 to 127.0), incl	0.035 to 0.165	0.89 to 4.19	0.020	0.51
Over 3 1/2 to 5 (88.9 to 127.0), incl	over 0.165	over 4.19	0.025	0.64
Over 5 to 7 1/2 (127.0 to 190.5), incl	0.049 to 0.250	1.24 to 6.35	0.025	0.64
Over 5 to 7 1/2 (127.0 to 190.5), incl	over 0.250	over 6.35	0.030	0.76
Over 7 1/2 to 16 (190.5 to 406.4), incl	all	all	0.00125 in./in. or mm/mm of circumference	

### Product Marking

Civilian Procurement—Each box, bundle or lift, and piece (when individual pieces are shipped) shall be identified by a tag or stencil with the manufacturer's name or brand, specified size, purchaser's order number, this specification number, and grade. Bar coding is acceptable as a supplementary identification method. Bar coding should be consistent with the Automotive Industry Action Group (AIAG) standard prepared by the Primary Metals Subcommittee of the AIAG Bar Code Project Team.

### Surface Finish

- Tubes shall be free of scale.
- If special surface conditioning is required, they shall be stated in the order.

