

PLASMA CUTTING		FLAME CUTTING		LASER CUTTING		BEVELING	ROLLING	MACHINING	FORMING
Max Plate Size 12' W X 75' L		Max Plate Size 12' W X 60' L		Max Plate Size 14' W X 50' L		Max Plate Size Application Specific	Max Plate Size Application Specific	Max Part Size Application Specific	Max Part Size Application Specific
<b>Hypertherm HPR260XD</b>		<b>10 Torch - Oxy-Fuel</b>		<b>4000-8000W</b>		<b>Mechanical Bevel</b>	<b>Plate Rolling</b>	<b>VMC</b>	<b>75 Ton – 1500 Ton</b>
TOLERANCE	THICKNESS	TOLERANCE	THICKNESS	TOLERANCE	THICKNESS	Max Bevel Depth	<b>Large Roll</b> - Max 10' long Max 1-5/8" thick	Max Part Size 18" X 37" Max Lift 1000 lbs Max Height 7"	Bend Length up to 30' DIMENSIONAL TOLERANCE +/- 1/16" per bend
+/- 0.040	11GA-1-1/8"	+/- 1/16"	<1-1/2"	+/- 0.005	< 1/4"	1/2" @ 25° to 45°			
<b>HPR400XD</b>		+/- 3/32"	1-5/8" < 2-1/2"	+/- 0.010	>1/4" – 5/8"	Min Bevel Depth	Max ID 120" - Min ID 20"	TOLERANCE	ANGULAR TOLERANCE +/- 1°
TOLERANCE	THICKNESS	+/- 1/8"	2-5/8" < 4"	+/-0.030	>5/8"-1"	1/8" @ 25° to 55°	<b>Small Roll</b> - Max 8' long Max 5/8" thick		
+/- 0.040"	11GA" -2"	+/- 3/16"	4-1/4" < 7"			ANGULAR TOLERANCE +/- 1°		Bores +/- 0.0005	<b>FLATTENING</b>
Kerf Angle +/- 1° to 3° as plate thickness increases		+/-1/4"	7-1/4" < 12"			<b>Flame Bevel</b>	Max ID 120" - Min ID 14"	Position +/- 0.001	Part thickness .080" – 3.5" Max. part width 120" Max. part length 650"
<b>True Hole Technology</b>		Kerf Angle +/- 2°		<b>SAW CUTTING</b>		Max Bevel Depth Application Specific	TOLERANCE +/- 1/8" on diameter	<b>Manual Mill</b>	
3/16" -3/4"		ID Holes 1 X Thickness		<b>SQUARE CUT</b>		Bevel Angles 10° to 60°		Maximum Part Size X=36", Y=14", Z=15"	
ID Holes 1 X Thickness ≤ 3/4"				Max Part Size 20"W X 20"H X 40'L		ANGULAR TOLERANCE +/- 2°	<b>Structural Rolling</b>	Max Lift 50 lbs	
ID Holes 1.5 X Thickness > 3/4"				DIMENSIONAL TOLERANCE +/- 1/32"			Max Angle 5" X 5" X 1/2"	TOLERANCE +/- 0.0005	
<b>BEVEL HEAD</b>				<b>MITRE CUTS</b>			Min Angle 1" X 1" X 1/8" Min Diameter (ID) 20"	<b>Radial Arm Drill</b>	
360° TILT ROTATION 45° TORCH ANGLE				Max Part Size @ 60° 20"W X 20"H X 40'L			TOLERANCE +/- 3/16" on diameter	Max Part Width 70"	
				DIMENSIONAL TOLERANCE +/- 2°				Max Hole Diameter 2-1/4"	
								Max Lift 1250 lbs	
								TOLERANCE +/- 1/32" on diameter +/- 1/16" on position	

These tolerances are general and for reference only. Material composition, part geometry, lead-in/lead-out locations and thermal effect are variables that may impact product realization. Tighter tolerances are held on the overall part profile, but stop/start marks and 90° corners may impact the general published tolerances.

**BRANNON STEEL** will always endeavor to meet customer specified tolerances unless otherwise noted at time of quotation.

Visit us online at [www.brannonsteel.com](http://www.brannonsteel.com)

12 TILBURY COURT, BRAMPTON, ONTARIO L6T 3T4 TELEPHONE: (905) 453-4730 FAX: (905) 453-4483