

PLASMA CUTTING		FLAME CUTTING		LASER CUTTING		BEVELING	ROLLING	MACHINING	FORMING	
Max Plate Size 144" W X 900" L		Max Plate Size 148" W X 720" L		Max Plate Size 168" W X 600" L		Max Plate Size Application Specific	Max Plate Size Application Specific	Max Part Size Application Specific	Max Part Size Application Specific	
Hypertherm HPR260XD		10 Torch - Oxy-Fuel		4000-7000W		Mechanical Bevel	Plate Rolling	VMC	75 Ton – 1500 Ton	
TOLERANCE	THICKNESS	TOLERANCE	THICKNESS	TOLERANCE	THICKNESS	Max Bevel Depth	Max 10' width	Max Part Size 18" X 37"	Bend Length up to 30'	
+/- 0.040	11GA-1-1/8"	+/- 1/16"	<1-1/2"	+/- 0.005	< 1/2"	5/8" @ 25° to 45°	Max 1-1/8" thick	Max Lift 1000 lbs	DIMENSIONAL TOLERANCE	
ID HOLES 1 X THICKNESS		+/- 3/32"	1-5/8" < 2-1/2"	+/- 0.010	5/8" – 1"	Min Bevel Depth	Max ID 120" - Min ID 14"	Max Height 7"	+/- 1/16" per bend	
HPR400XD		+/- 1/8"	2-5/8" < 4"			1/8" @ 25° to 55°	TOLERANCE	TOLERANCE	ANGULAR TOLERANCE +/- 1°	
TOLERANCE	THICKNESS	+/- 3/16"	4-1/4" < 7"			ANGULAR TOLERANCE +/- 1°	+/- 1/8" on diameter	Bores +/- 0.0005 Position +/- 0.001		
+/- 0.040"	11GA" – 2"	+/-1/4"	7-1/4" < 12"			Flame Bevel	Structural Rolling			
Kerf Angle +/- 1° to 3° as plate thickness increases		Kerf Angle +/- 2°		SAW CUTTING		Max Bevel Depth Application Specific	Max Angle 5" X 5" X 1/2" Min Angle 1" X 1" X 1/8"	Manual Mill		
True Hole Technology 3/16" -3/4"		ID Holes 1 X Thickness		SQUARE CUT		Bevel Angles 10° to 60°	Min Diameter (ID) 20"	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°	TOLERANCE	Max Lift 50 lbs		
ID Holes 1.5 X Thickness > 3/4"				DIMENSIONAL TOLERANCE +/- 1/32"		MITRE CUTS		+/- 3/16" on diameter	TOLERANCE +/- 0.0005	
BEVEL HEAD 360 DEG. TILT / TILT ROTATION 45 DEGREE TORCH ANGLE				Max Part Size @ 60° 20"W X 20"H X 40'L		DIMENSIONAL TOLERANCE +/- 2°			Heavy Duty Lathe	
								Max Diameter 16"		
								Max Length 60"		
								3" Spindle Bore		
								Max Rectangle 10" W X 8" L		
								TOLERANCE +/- 0.005		
								Radial Arm Drill		
								Max Part Width 60"		
								Max Hole Diameter 2-1/32"		
								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 impact the general published tolerances.

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