

CMF-C

DIMENSIONAL TOLERANCES FOR STANDARD
TANK HEADS (ASME AND NON CODE)

05-09-07

DIE FORMED

<u>Head size (OD)</u>	<u>Diameter</u>	<u>Outside Circumference</u>	<u>Ovality</u>	<u>Overall Height As Formed</u>	<u>Overall Height Trimmed</u>
14" & Under	+/-1/32		1/16"Max.	+/-1/8"	+1/8
18" & Under	+1/16" -1/32		1/16"Max.	+/-1/8"	+1/8"
22" & Under	+3/32" -1/32"		3/32"Max.	+/-1/8"	+1/8"
30"& Under	+1/8" -1/16"		1/8"Max	+/-1/8"	+1/8"
48"& Under	+1/8" -1/16"		3/13"Max	+/-3/16"	+3/16"

BUMPED & SPUN

<u>Head size (OD)</u>	<u>Diameter</u>	<u>Outside Circumference</u>	<u>Ovality</u>	<u>Overall Height As Formed</u>	<u>Overall Height Trimmed</u>
18" to 22"	+3/32" -1/32		3/32"Max.	+/-1/8"	+1/8"
Over 22" to 30"	+1/8" -1/16"		1/8"Max.	+/-1/8"	+1/8"
Over 30"to 42"	+1/8" -1/16"		1/8"Max	+/-1/8"	+1/8"
Over 42"to 72"		+/- 1/4	1/4"Max	+1/2"-1/4"	+1/4"
72"-108"		+/-1/4"	3/8"Max	+3/4"-1/4"	+1/4"
+108"-144"		+/-1/4"	1/2"Max	+1"-1/4"	+3/8" -1/4"
+144"-192"		+/-1/4"	5/8"Max	+1 1/4" -1/2"	+1/2" -1/4"
194"-240"		+/-1/4	1 1/4"Max	+1 1/2" -3/4"	+3/4" -1/4"
241"-276"		+3/8" - 3/8"	1 1/2" Max	+1 3/4" - 1"	+1" - 3/8"