

VARIATIONS FOR DIMENSIONS AND WORKMANSHIP

DEPTH A	WEB WIDTH		WIDTH (OVERALL)		WEIGHT	OFF-SQUARENESS		FLANGE TO WEB		
	LONG FLANGE D	SHORT FLANGE E	LONG FLANGE H	SHORT FLANGE J		LONG FLANGE	SHORT FLANGE	UP ONLY	OVER	UNDER
OVER 1/8"	UNDER 1/8"	OVER 0"	UNDER 1/8"	OVER 5/32"	UNDER 1/4"	OVER 1/2"	UNDER 1/2"	UP ONLY 3/8"	OVER 1"	UNDER 1"

I- Depression in web - Maximum 1/16" at junction of web and flange, tapering to 0" about 1/4" down on web.

F- Inside depression - Maximum 1/32" deep

CAMBER

LENGTHS	MAXIMUM	PREFERENCE
Up to 41 feet Incl.	1/4"	1/2" to 7/8"
Over 41 feet to 51 feet Incl.	1/2"	3/4" to 1 1/8"
Over 51 feet to 66 feet Incl.	2"	1 1/8" to 1 5/8"
Over 66 feet to 82 feet Incl.	3"	2" to 2 5/8"

CAMBER: Camber denotes the curvature from the plane of either flange in the length of the section. Section may vary from straight to cambered. If section is cambered the corner of the long flange must be high at the center of length.

SWEEP: Sweep denotes the curvature from the plane of the web in the length of the section.
 Maximum Sweep in either direction:
 $\frac{1}{8} \times \frac{\text{Number of feet of total length}}{5}$ Short kinks not acceptable

LENGTH

LENGTHS	VARIATIONS FROM SPECIFIED LENGTH *	
	PLUS	MINUS
Up to 30 feet Incl.	3/4"	0"
Over 30 feet to 40 feet Incl.	1"	0"
Over 40 feet	1 1/4"	0"

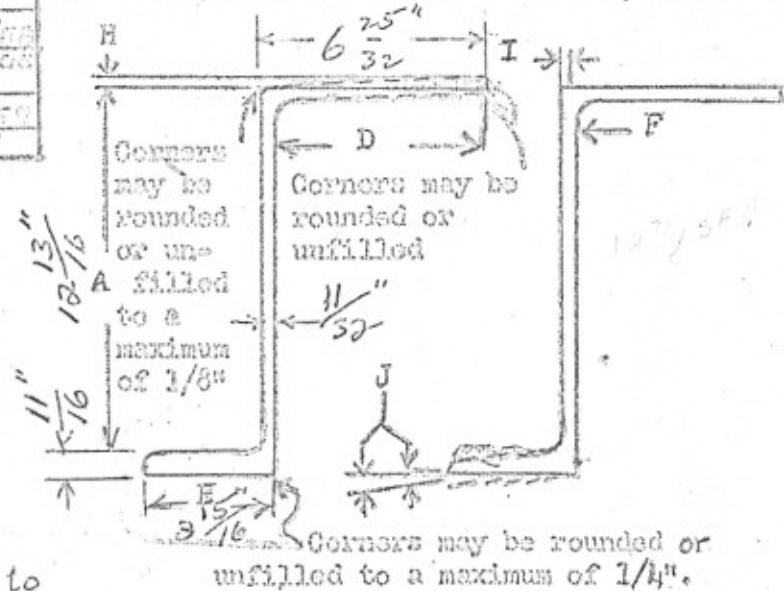
* Prefer plus minus 0".

Surface conditioning same as applicable for structural shapes.

Maximum off squareness of ends, 3/28" per inch of section depth.

Revised A. I. S. I. Sheets #1 and #2 dated 6-4-51

OFF-SQUARENESS OF FLANGES, ETC.



Excessive saw burrs to be removed.

ZEE CENTER SILL SECTIONS	
Standard Practice Tables	
Bethlehem Steel Co., Bethlehem, Pa.	
DATE	REV
	ER - 7330 - D