

Table 10 — Tolerances for diameter and out-of-roundness

Specified outside diameter <i>D</i> mm (in)	Diameter tolerances ^d				Out-of-roundness tolerances	
	mm (in)		mm (in)		mm (in)	
	Pipe except the end ^a		Pipe end ^{a,b,c}		Pipe except the end ^a	Pipe end ^{a,b,c}
	SMLS pipe	Welded pipe	SMLS pipe	Welded pipe		
< 60,3 (2.375)	- 0,8 (0.031) to + 0,4 (0.016)		- 0,8 (0.031) to + 0,4 (0.016)		1,2 (0.048)	0,9 (0.036)
≥ 60,3 (2.375) to 168,3 (6.625)	± 0,007 5 <i>D</i>		- 0,4 (0.016) to + 1,6 (0.063)		0,020 <i>D</i> for $\frac{D}{t} \leq 75$; by agreement for $\frac{D}{t} > 75$	0,015 <i>D</i> for $\frac{D}{t} \leq 75$; by agreement for $\frac{D}{t} > 75$
> 168,3 (6.625) to 610 (24.000)	± 0,007 5 <i>D</i>	± 0,007 5 <i>D</i> , but maximum of ± 3,2 (0.125)	± 0,005 <i>D</i> , but maximum of ± 1,6 (0.063)		0,020 <i>D</i>	0,015 <i>D</i>
> 610 (24.000) to 1 422 (56.000)	± 0,01 <i>D</i>	± 0,005 <i>D</i> , but maximum of ± 4,0 (0.160)	± 2,0 (0.079)	± 1,6 (0.063)	0,015 <i>D</i> , but maximum of 15 (0.6) for $\frac{D}{t} \leq 75$; by agreement for $\frac{D}{t} > 75$	0,01 <i>D</i> , but maximum of 13 (0.5) for $\frac{D}{t} \leq 75$; by agreement for $\frac{D}{t} > 75$
> 1 422 (56.000)	as agreed					

^a The pipe end includes a length of 100 mm (4.0 in) at each of the pipe extremities.

^b For SMLS pipe, the tolerances apply for $t \leq 25,0$ mm (0.984 in), and the tolerances for thicker pipe shall be as agreed.

^c For expanded pipe with $D \geq 219,1$ mm (8.625 in) and for non-expanded pipe, the diameter tolerance and the out-of-roundness tolerance may be determined using the calculated inside diameter (the specified outside diameter minus two times the specified wall thickness) or measured inside diameter rather than the specified outside diameter (see 10.2.8.3).

^d For determining compliance to diameter tolerances, the pipe diameter is defined as the circumference of the pipe in any circumferential plane divided by Pi.

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1. Understanding the eBook Api 5l 45th Edition
 - The Rise of Digital Reading Api 5l 45th Edition
 - Advantages of eBooks Over Traditional Books
2. Identifying Api 5l 45th Edition
 - Exploring Different Genres
 - Considering Fiction vs. Non-Fiction
 - Determining Your Reading Goals
3. Choosing the Right eBook Platform
 - Popular eBook Platforms
 - Features to Look for in an Api 5l 45th Edition
 - User-Friendly Interface
4. Exploring eBook Recommendations from Api 5l 45th Edition
 - Personalized Recommendations
 - Api 5l 45th Edition User Reviews and Ratings
 - Api 5l 45th Edition and Bestseller Lists
5. Accessing Api 5l 45th Edition Free and Paid eBooks
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- Api 5l 45th Edition Budget-Friendly Options
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 - Api 5l 45th Edition Enhanced eBook Features
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 - Adjustable Fonts and Text Sizes of Api 5l 45th Edition
 - Highlighting and Note-Taking Api 5l 45th Edition
 - Interactive Elements Api 5l 45th Edition
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 - Joining Online Reading Communities
 - Participating in Virtual Book Clubs
 - Following Authors and Publishers Api 5l 45th Edition
- 9. Balancing eBooks and Physical Books Api 5l 45th Edition
 - Benefits of a Digital Library
 - Creating a Diverse Reading Collection Api 5l 45th Edition
- 10. Overcoming Reading Challenges
 - Dealing with Digital Eye Strain
 - Minimizing Distractions
 - Managing Screen Time
- 11. Cultivating a Reading Routine Api 5l 45th Edition
 - Setting Reading Goals Api 5l 45th Edition
 - Carving Out Dedicated Reading Time
- 12. Sourcing Reliable Information of Api 5l 45th Edition
 - Fact-Checking eBook Content of Api 5l 45th Edition
 - Distinguishing Credible Sources
- 13. Promoting Lifelong Learning
 - Utilizing eBooks for Skill Development
 - Exploring Educational eBooks

14. Embracing eBook Trends

- Integration of Multimedia Elements
- Interactive and Gamified eBooks

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