



232 J STREET • AMPOINT INDUSTRIAL PARK • PERRYSBURG, OHIO 43551
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Sheet and Die Cut Tolerances

Width	Material Size	Tolerance
Extruder (Offline Sheet)	2 mm - 6 mm	+/- 1/8"
	8 mm - 10 mm	-1/8", +1/4"
Slitter (Square Cut Sheet)	2 mm - 6 mm	+/- 1/8"
	8 mm - 10 mm	-1/8", +1/4"
Rotary Die Cut Parts	2 mm - 6 mm	+/- 1/8"
	8 mm - 10 mm	-1/8", +1/4"
Flat Bed Die Cut Parts	All	+/- 1/8"

Length	Material Size	Tolerance
Extruder (Offline Sheet)	< 36"	-0", +1/2"
	36" - 66"	-0", + 3/4"
	66" - 96"	-0", + 1"
	> 96"	-0", + 1-1/2"
Slitter (Square Cut Sheet)	All	-0", +1/8"
Rotary Die Cut Parts	All	+/- 1/4"

Squareness*	Material Size	Tolerance
* The difference in length between the corner to corner diagonal measurement		
Extruder (Offline)	< 60"	3/8"
	> 60"	5/8"
Slitter (Cut Square)	< 60"	1/8"
	60" - 72"	1/4"
	> 72"	5/16"
Die Cutter	< 72"	1/4"
	> 72"	5/16"

Warp/Bow*	Material Size	Tolerance
* Material Height above a flat surface of any portion of a sheet		
	< 96"	1/4"
	> 96"	1"
	70" x 70" or Larger	2"

Straightness*	Material Size	Tolerance
* Maximum distance measured between the edge of a sheet of Pcorr and a straight edge when the two corners of the sheet touch the straight edge		
	< 98"	1/8"
	> 98"	3/16"

Extruded Sheet Thickness

GAUGE (mm)	DENSITY (g)	TOLERANCE (+/- 0.15 mm)	
		Min	Max
+/- 5%			
2 mm	350 g	1.85 mm	2.15 mm
2 mm	450 g	1.85 mm	2.15 mm
3 mm	600 g	2.85 mm	3.15 mm
3.2 mm	450 g	3.05 mm	3.35 mm
4 mm	700 g	3.85 mm	4.15 mm
4 mm	1469 g	3.85 mm	4.15 mm
5 mm	1000 g	4.85 mm	5.15 mm
6 mm	1200 g	5.85 mm	6.15 mm
6 mm	1800 - 2000 g	5.85 mm	6.15 mm
7 mm	1700 g	6.85 mm	7.15 mm
8 mm	1800 g	7.85 mm	8.15 mm
10mm	2000 g	9.85 mm	10.15 mm

Extruded Sheet Skins and flutes.

GAUGE (mm)	SKIN (in)	FLUTE (in)	TOLERANCE (in)
2 mm 350 g	0.0040 in	0.0030 in	± 0.0015 in
2 mm	0.0065 in	0.0065 in	± 0.0015 in
3 mm	0.0080 in	0.0080 in	± 0.0020 in
3.2 mm	0.0050 in	0.0040 in	± 0.0015 in
4 mm	0.0090 in	0.0090 in	± 0.0020 in
4 mm, 1469 g	0.0200 in	0.0200 in	± 0.0040 in
5 mm	0.0130 in	0.0130 in	± 0.0030 in
6 mm	0.0180 in	0.0180 in	± 0.0025 in
6 mm 1800 - 2000 g	0.0260 in	0.0260 in	± 0.0075 in
7 mm	0.0240 in	0.0230 in	± 0.0070 in
8 mm	0.0300 in	0.0300 in	± 0.0080 in
10mm	0.0340 in	0.0250 in	± 0.0080 in

