

STEELRODE (Pty) Ltd

STANDARD TOLERANCES

GALVANISED PRODUCTS

Work Instruction: WI 2/3

1 Coil inside diameter

Slit coils 508 mm

Slit strip 508 mm

2 Full slab coil mass

925mm 18 Tons

1225mm 22 Tons

1500mm 24 Tons

3 Thickness (measured 40 mm from the edge)

Tolerance over or under thickness (mm)

	0,58	0,8	1,0	1,2	1,6	2,0
1200mm	0,03	0,04	0,05	0,06	0,08	0,10

4 Width (permissible deviation from ordered width)

925 coil -0,0 mm to +5,0 mm

1225 coil -0,0 mm to +6,0 mm

Slit strip + - 0,25 (or specified)

5 Flatness (cut lengths)

Deviation from a flat surface in 1000mm length (mm)

	0,5 to 0,6		0,7 to 1,1		1,2 to 2,0	
	Standard	Specified	Standard	Specified	Standard	Specified
925mm	12	5	10	4	8	3
1225mm	15	6	12	5	10	4

6 Camber (cut lengths)

Deviation of the side edge of the sheet from a straight line (mm)

Cut length	1000	1500	2000	2500	3000	4000
Camber from coils	4	6	8	10	10	16
CTS blanks	to customer specification					

7 Length (cut lengths)

Permissible deviation from ordered length (over mm)

Sheet length	1000	1500	2000	2500	3000	4000
Standard deviation	2.0	2,5	3.0	3,5	4,0	5,0
Special	to customer specification					

8 Diagonals (cut lengths out of square)

Permissible out of square deviation (mm)

Sheet width	1200	1225	3000
Standard deviation	3	4	5
Special	to customer specification		