

STEELRODE (Pty) Ltd

STANDARD TOLERANCES

HOT ROLLED PRODUCTS

Work Instruction: WI 2/1

1 Coil inside diameter

Mill edge	760 mm
Pickled & oiled	610 mm
Slit strip	508 mm

2 Full slab coil mass

1200mm	23 Tons
1225mm	23 Tons
1500mm	25 Tons

3 Thickness (measured 20 mm from the edge)

Tolerance over or under thickness (mm)

	1,6 to 1,9	2,0 to 2,4	2,5 to 4,4	4,5 to 5,9	6,0 to 7,9	8,0 to 9,9
1200mm	0,18	0,18	0,20	0,23	0,30	0,32
1225mm	0,18	0,18	0,20	0,23	0,30	0,32
1500mm	0,18	0,20	0,20	0,28	0,36	0,38

4 Width

Mill edge	-0,0 mm to +20,0 mm
Slit strip	+ - 0,25

5 Flatness (cut lengths)

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

	1,6 to 4,0		4,5 to 5,0		6,0 to 9,0	
	Standard	Specified	Standard	Specified	Standard	Specified
1200mm	15	10	15	10	20	15
1225mm	15	10	15	10	20	15
1500mm	20	15	20	15	25	20
1800mm	25	20	30	20	35	30
Special	to customer specification					

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
Permissible camber	4	5	6	8	10	13
Special	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	1500
Standard deviation	4	5	6

Special to customer specification