

Data sheet: B1.1

Cold Rolled Sheet

Cold rolled product tolerances

General description

Cold rolled sheet is produced in thicknesses from 0,4mm to 2,0mm and widths 800mm to 1 600mm. The following tables describe the standard tolerances on thickness, width and camber. When cold rolled steel sheet is ordered to an international specification, dimensional tolerances will conform to the requirements of that specification.

Tolerances

1. Thickness

The thickness tolerance is the permissible deviation from the **nominal** ordered thickness.

Table 1. Thickness tolerances.

Nominal thickness t (mm)	Thickness tolerance (mm)
$0,40 \leq t \leq 0,50$	-0,04 +0,04
$0,50 < t \leq 0,60$	-0,05 +0,05
$0,60 < t \leq 0,70$	-0,06 +0,06
$0,70 < t \leq 0,80$	-0,07 +0,07
$0,80 < t \leq 1,20$	-0,08 +0,08
$1,20 < t \leq 1,60$	-0,09 +0,09
$1,60 < t \leq 2,00$	-0,10 +0,10

Notes:

1. Thickness is measured at any point more than 40mm from an edge.
2. Stricter tolerances of up to 50 % of the specified ranges may be available on enquiry.

For further information, contact:

ArcelorMittal South Africa Limited, PO Box 2, Vanderbijlpark 1900. T +27 (0) 16 889 9111

<https://www.arcelormittalsa.com/Products.aspx>

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2. Width

The width tolerance is the permissible deviation from the ordered width.

Table 2. Width tolerances.

Width w (mm)	Width tolerance (mm)
$800 \leq w \leq 1200$	-0 +4,0
$1201 \leq w \leq 1500$	-0 +5,0
$1501 \leq w \leq 1600$	-0 +6,0

3. Camber

Camber is the maximum deviation of a side edge from a straight line, measured on the concave side of the sheet with a straight edge.

Table 3. Camber tolerances.

	Width w (mm)	Tolerance
Coils	$800 \leq w \leq 1\ 600$	25 mm over 6 000 mm

4. Flatness (cut lengths)

Flatness tolerance is defined as the maximum permissible deviation from a horizontal flat surface in any 1000mm length.

Table 4. Flatness tolerances.

Width w (mm)	Levelling	Flatness tolerance for thickness t (mm)		
		$0,40 \leq t < 0,65$	$0,65 \leq t < 1,15$	$1,15 \leq t \leq 2,00$
$800 \leq w < 1200$	Not specified	12	10	8
	Specified	5	4	3
$1200 \leq w < 1500$	Not specified	15	12	10
	Specified	6	5	4
$1500 \leq w \leq 1600$	Not specified	19	17	15
	Specified	8	7	6

Notes:

1. Application of this table to product in coil form is not appropriate unless the coil has been rolled out and adequately flattened by powerful levellers, with all coil set removed.
2. This table does not apply to ASTM A606M Type 4 CR and products that are ordered hard un-annealed.
3. When cold rolled sheet is ordered to an international specification, flatness tolerances will conform to the requirements of that specification.

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Tolerance on coil and bundle mass

Refer to Price Lists 130 and 131 and 148 for Electro-galvanised material.

Supply conditions

Cold rolled sheet is supplied in terms of Price Lists 130 and 131 and ArcelorMittal Steel South Africa's General Conditions of Sale.

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