

TIANZHIWANG Coil
Coating Line
(CCL) Operations
CCL/ Tension leveler

Quality contract / Transfer Specification.

Original Date: 12/11/2018
Revision Date:

PAGES REVISED
12/11/2018

TZW CCL Quality System



Issued by: -Quality Manager CCL

Approved by: -Production Manager CCL

Staff Signatures

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IDENTIFICATION

Coils should be identified with the following information in the core of the coil.

1. Coil Number
2. Gauge / Width
3. Alloy / Hardness
4. Net Weight

DIMENSIONS

Minimum Wall Size 1100mm

Maximum Wall OD: - 2000mm (Based 12M Tonnes on entry Spec as per GLOBUS)

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Any coil not meeting minimum customer coil size requirements must be placed on HOLD for planning disposition.

Width Tolerance: - Width is to be maintained to $\pm 1.00\text{mm}$ (BS EN 485-4 1993) on all products (MEASURED COLD) If outside of tolerance put on hold for planning disposition.
No Weave

THICKNESS DIMENSIONS

For Thickness: - $0.46-1.20\text{mm} = + 0.015\text{mm}$

$0.30-0.45\text{mm} = + 0.010\text{mm}$

$0.20-0.29\text{mm} = + 0.005\text{mm}$

BURR

Minimum Possible

Maximum:-20 micron

BEND SPECIFICATION

OT For Gauge 0.20-0.49mm

IT For Gauge 0.50-0.80 mm

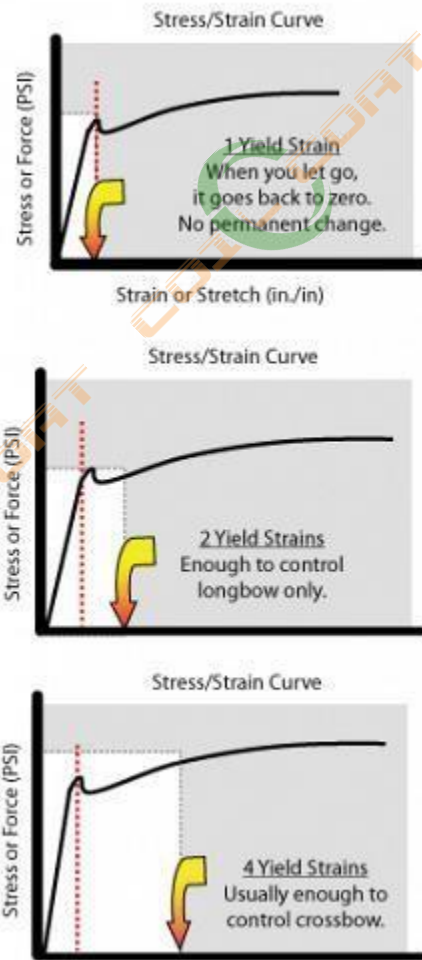
1.5T For gauge 0.80-1.20

FLATNESS

Not exceed 5 I units (Vialco to be advised by supplier tolerances)

Lateral Bow: - Max 1.2mm / 2000mm (Technical Spec) (BS EN 485-4 1993)

A simplified formula is:



$$I\text{-units} = 2.467(H/L)^2 (10)^5$$

Where: H = wave height and L = wave length

The percent elongation (strain) required for leveling is directly proportional to the measured number of I-units. One percent length differential is equal to 1,000 I-units. Thus, one I-unit equals 0.01 percent length differential. The difference between the incoming shape and the desired outgoing shape can be shown as a percent length differential in the material. To achieve the desired flatness requires that much permanent elongation of the shorter parts of the product.

SURFACE QUALITY

Coil shall be smooth surface very lightly oiled (<250mg/m²) to prevent inter lap chafing during transit.

1. Sheet to be free of scratches or damage.
2. Sheet to be free of scratches or damage from Flatness or Shape Issues within coil body.
3. Coil should have no known oxide patches or rolled in foreign material.
4. No Orange peeled surface allowable.
5. Finish to be free of broken surface, chatter & stains.

(BS EN 485-1:2008+A1:2009)

Coil should be free from edge waves, buckling, dents, pin holes, laminations. Scratches, ID to OD thickness variation, width variation, white rust, excessive oil and grease, uneven coil winding, (UMC)

OR Prior agreement with Vialco Quality Department

SIDE WALL BUILD UP

Target:- Straight wall

Max Deviation +/- 50mm

INSIDE DIAMETER

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Minimum 508mm

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COIL COAT

Maximum 610mm

PROPERTIES

Chemical & Mechanical properties as per BS EN 485-2.

PACKAGING

Presentation: - Eye to wall, V Saddle, Bore protector & Packaging.

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