

MANUFACTURING RANGE

CRFH

Thickness Range	Width	Coil Weight	Coil ID
0.12 - 0.60mm	700-1060mm	10 to 20 Kg/mm	508
0.25 - 2.50mm	900-1650mm	15 to 20 Kg/mm	508 / 610

CRCA

Thickness Range	Width	Coil Wt	Coil ID
0.25mm to 0.35mm	1250mm max	15 to 20 kg/mm	508 / 610*
0.36mm to 1.60mm	1650mm max	15 to 20 kg/mm	
1.61mm to 2.50mm	1650mm max	15 to 20 kg/mm	

* 406 mm ID can be supplied on request for width < 500 mm

TOLERANCES FOR COLD ROLLED PRODUCTS

Thickness Tolerance	mm
Thickness range mm	
0.12 to 0.40	+/- 0.02
0.41 to 0.60	+/- 0.03
0.61 to 0.80	+/- 0.03
0.81 to 1.00	+/- 0.04
1.01 to 1.25	+/- 0.04
1.26 to 1.60	+/- 0.05
1.61 to 2.00	+/- 0.05
2.01 to 2.50	+ /- 0.07

Length Tolerance	mm
Upto 600mm	+ 1.5 / 0
> 600mm	+ 3 / 0

Roughness	
Bright	0.5 micron max
Matt	0.8 to 1.6 micron max

Camber	
Upto 5000 mm Length (coils)	5 mm max
Cut Length Sheets	0.1 % x Length

Width Tolerance	mm
> 600	
Mill Edge	+ 5 / 0
Slit Edge	+ 3 / 0
100 upto 600mm	+/- 0.5

* Width lesser than 100mm on request

Diagonal Difference	
1.5mm max	

Flatness	mm
BOW (width 600 mm and below)	2
BOW (width > 600mm)	5
Edge wavy	3
Centre Buckling	3

COLD ROLLED PRODUCTS

Applications	International Specifications			Dimension Range (mm)	Indian Specification Standards
	Euro Norm	American Standards	JIS Standards		
General fabrication	-	ASTM A 1008 CS - A/B/C	JIS G 3141 SPCC	Thickness : 0.25 to 2.5 Width : 50 to 1650	IS 513 Gr 0
Drawing	EN 10130 DC 01	ASTM A 1008 FS - A/B	JIS G 3141 SPCD	Thickness : 0.25 to 2.5 Width : 50 to 1650	IS 513 Gr D
Deep Drawing	EN 10130 DC 03	ASTM A 1008 DDS	JIS G 3141 SPCE	Thickness : 0.25 to 2.5 Width : 50 to 1650	IS 513 Gr DD
Extra Deep Drawing	EN 10130 DC 04 / 05	ASTM A 1008 EDDS	JIS G 3141 SPCEN	Thickness : 0.6 to 2.0 Width : 50 to 1650	IS 513 Gr EDD
Super Extra Deep Drawing	EN 10130 DC 06	-	-	Thickness : 0.6 to 1.2 Width : 50 to 1650	IFS
Medium Carbon for automotive chains	-	SAE 1040 SAE 1050	-	Thickness : 0.3 to 2.0 Width : 50 to 1650	MC 11 MC 12
Semi Processed Electrical Steel	EN 10126 EN 10165	ASTM A 726	-	Thickness : 0.5 to 0.65 Width : 50 to 1650	USP - E1 E2 E3 E4 E5
Atmospheric Corrosion Resistant Steel	-	-	JIS G 3125 SPA - C	Thickness : 0.5 to 1.5 Width : 50 to 1650	IRS - M41 (Corten 'A')
Steel for Enameling	EN 10209 EK2/EK4	ASTM-A424	JIS G 3133	Thickness : 0.3 to 1.5 Width : 800 to 1650	-
Structural Grade		ASTM A 1008 SS Gr 80	JIS G 3141 SPCC1B	Thickness : 0.12 to 2.5 Width : 700 to 1650	IS 513

Length	Max - 5000 mm	Min - 660mm	Width > 600 mm
	Max - 4000 mm	Min - 340mm	Width < 600 mm