

MANUFACTURING RANGE

CONTINUOUS GALVANIZING CAPACITIES

Thickness Range	0.12mm - 0.6mm	0.21mm - 0.6mm	0.25mm - 1.00mm	0.40mm - 3.00mm
Width	700mm - 1320mm	700mm - 1040mm	900mm - 1250mm	900mm - 1650mm
Coil Weight	5 - 18MT	5 - 20MT	5 - 20MT	10 - 35MT
Coating Weight	80 - 275GSM	80 - 275GSM	80 - 275GSM	80 - 350GSM
Surface Finish	Regular/Minimised Spangles		Regular/Minimised Spangles/Skin Passed	
Type	Roofing	Roofing, Commercial Light Drawing and Structural		
Surface Treatment	Chromating and Electrostatic Oiling			
Passivation	CR 6	CR 6	CR 6/CR 3	CR 6/CR 3
Coil ID	508	508	508	508/610

TOLERANCES FOR GALVANIZED PRODUCTS

Thickness Tolerance	mm	Width Tolerance	mm
Thickness range mm		>600	
<0.025	+/- 0.020	Mill Edge	+ 5/0
>0.025 to 0.40	+/- 0.025	Slit Edge	+3/0
>0.40 to 0.60	+/- 0.030	150 upto 600mm*	+/-0.5
>0.60 to 0.80	+/- 0.035		
>0.80 to 1.00	+/- 0.040	Diagonal Difference	
>1.00 +	+/- 0.045	1.5mm max	
Length Tolerance	mm	Flatness	
Upto 600mm	+1.5/0	BOW (width 600 mm & below)	2
>600mm	+3/0	BOW (width > 600mm)	5
Camber		Edge wavy in sheet	3
Upto 2000 mm length (coils)	2mm max	Edge wavy in coil	4
Cut Length Sheets	0.1 % x Length	Buckling	5

* Lower widths on request

GALVANIZED PRODUCTS

Applications	International Specifications			Zn Coating GSM	Surface	Dimension Range		Indian Specification Standards
	Euro Norm	American Standards	JIS Standards			(mm)	(Inches)	
General fabrication and light drawing (Soft Commercial Quality)	EN 10142/10292 FE P02GZ (DX51D)	ASTM A 653/653M CS A CS B CS C	JIS G 3302 SGCC	80-350	Spangles : Regular / Minimised / Skin passed. Treatment : Chromated Dry / Non Chromated & oiled. Oiling : Electrostatically oiled 200mg to 1500mg on each side Stretch levelled.	Thickness : 0.21 to 3.00 Widths : Upto 0.28: 700-1045 0.29 to 0.50: 900-1250 0.50 to 2.00: 900-1650 2.00 to 2.50: 900-1250	Thk.: 0.0082 TO 0.118 Upto 0.0110: 27.55- 41.14 0.0114 to 0.0196: 35.43 - 49.21 0.0196 to 0.0787: 35.43 - 64.96 0.0787 to 0.0984: 35.43 - 49.21	IS 277-0 (GP)
Drawing	EN 10142/10292 FE P03GZ (DX52D)	ASTM A 653 653M FS A & B	JIS G 3302 SG CD 1	80-275	Spangles : Normal / Minimised / Skin passed. Treatment : Chromated Dry / Non Chromated & oiled. Oiling : Electrostatically oiled 200mg to 1500mg on each side Stretch levelled.	Thickness : 0.21 to 3.00 Width : Upto 0.28: 700-1045 0.29 to 0.50: 900-1250 0.50 to 2.00: 900-1650 2.00 to 2.50: 900-1250	Thk.: 0.0082 TO 0.118 Upto 0.0110: 27.55 - 41.14 0.0114 to 0.0196 : 35.43 - 49.21 0.0196 to 0.0787 : 35.43 - 64.96 0.0787 to 0.0984 : 35.43 - 49.21	IS 277 GPL-D
Structural	EN 10147/10327 S 220 GD S 250 GD S 280 GD S 320 GD S 350 GD S 550 GD	ASTM A 653 653M SS 230 (Gr 33) SS 255 (Gr 37) SS 275 (Gr 40) SS 340 (Gr 50) Class 1,2,3 & 4 SS 550 (Gr 80)	JIS G 3302 SGC 340 SGC 400 SGC 440 SGC 490 SGC 570	80-350	Spangles : Normal / Minimised / Skin passed. Treatment : Chromated Dry / Non Chromated & oiled. Oiling : Electrostatically oiled 200mg to 1500mg on each side Stretch levelled.	Thickness : 0.21 to 3.00 Width : Upto 0.28: 700-1045 0.29 to 0.50: 900-1250 0.50 to 2.00: 900-1650 2.00 to 2.50: 900-1250	Thk.: 0.0082 to 0.118 Upto 0.0110 : 27.55 - 41.14 0.0114 to 0.0196 : 35.43 - 49.21 0.0196 to 0.0787 : 35.43 - 64.96 0.0787 to 0.0984 : 35.43 - 49.21	
Roofing			JIS G 3302 SGCH	80-275	Spangles : Normal Treatment : Chromated Dry	Thickness : 0.12 to 0.70 Corrugated width : 665 - 1050 Length : 1500 - 4800	Thk :0.0047 to 0.02755 Corrugated width : 26.11 - 41.338 Length: 59.0551 - 188.976	GC-0 GCH-0 Hard