

	Technical Delivery Condition For Cold rolled carbon sheets coils	Doc Ref:	TDC:RTA:408
		Rev.No.	0 2
		Date:	10 05 2002
		Page No	1 of 3

1.0 Scope

- 1.1 This TDC specifies the requirements for cold rolled sheets of deep drawing quality to specification IS 513 GR- DD/ JIS G 3141 SPCD – SD

2.0 Chemical & Mechanical Properties

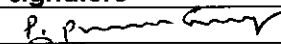
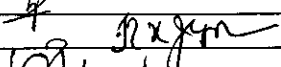
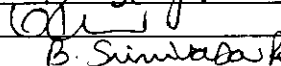
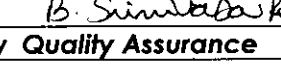
- 2.1 **IS 513**
- | | |
|----------------|---------------------------------|
| 1. Chemistry | } Shall be as per specification |
| 2. Hardness | |
| 3. Bend test . | |
4. Erich son cupping value shall be as per fig.1 of IS 513.

JIS G3141

1. Chemistry shall be as per Table 1 under informative reference of JIS 3141.
2. Hardness shall be 57 HRB MAX
3. Bendability shall be as per table 6 of JIS G 3141.
4. Erichson cupping test shall be conducted and the value shall be as per fig.1 of IS 513.

3.0 Supply condition

- 3.1 The coils shall be free from slit edges, visual scales & rust.
- 3.2 The tolerance on thickness and width shall be as follows :
On width : plus 0.00 to minus 1.5mm
On thickness : Plus 0.00 mm to Plus 0.07 mm
- 3.3 The camber, out of flatness, bend shall be permitted only to the extent specified in the applicable standard.
- 3.4 The ID of the coil shall be 500mm $\pm$ 20 mm, OD of the coil shall be 1500 mm Max and coil wt. 5 to10 MT

Prepared by 	Reviewed by	signature	Approved by  (Head/QA)
	Engg(APH)		
	Purchase		
	MPL		
	QC/proc.		
	QA		
Issued by Quality Assurance			

	Technical Delivery Condition For Cold rolled carbon sheets coils	Doc Ref:	TDC:RTA:408
		Rev.No.	0 2
		Date:	10 05 2002
		Page No	2 of 3

3.5 Surface condition

- 3.5.1 Cold rolled with matt finish with an oil coat to protect rusting and When ordered as per the Japanese standard, it shall be SPCD-SD, that is, skin rolled – dull finished by roll whose surface is made rough mechanically or chemically

4.0 PACKING

- 4.1 Before packing the coils, shall be given a sufficient coat of rust preventive fluid on the outer part to prevent rusting.
- 4.2 Three binding strips through eye of the coil at equal spacing shall tightly be secured.
- 4.3 Polythene sheet(thickness more than 20 microns) shall be wrapped over the coil.
- 4.4 Subsequently coil shall be wrapped with Hessian cloth.
- 4.5 ID rings shall be provided at both the sides of the coil to protect the coil edges.
- 4.6 Entire circumference of the coil shall be covered with GI sheet/painted sheet. Subsequently, both the faces shall be protected with metal sheets. (ie) full coil is to be covered.
- 4.7 Three cross strapping shall be tightly secured through the ID of the coil at equal spacing.
- 4.8 Two more strappings along the periphery shall be provided ensuring tight strapping. The outer label containing details as in 5.1 shall be pasted on the packed OD of the coil.
- 4.9 A metal label containing the detail as in 5.1 shall be secured at one of the outer cross strapping.

5.0 IDENTIFICATION

- 5.1 The following details shall be ensured in outer label pasted on the ID of the coil.
- | | |
|---------------|-----------------------|
| Vendor's Name | Specification & Grade |
| P.O. No | Net weight |
| Coil No. | |
- 5.2 Two more labels containing all the details as in 5.1 shall be pasted, one on the eye and another on the outer surface of the packed coil.

 Ranipet	Technical Delivery Condition For Cold rolled carbon sheets coils	Doc Ref:	TDC:RTA:408
		Rev.No.	0 2
		Date:	10 05 2002
		Page No	3 of 3

6.0 TEST CERTIFICATE

6.1 TC S hall be in English and it shall contain

P.O.NO

Specification and Grade

Coil No

Nominal thickness and

width

Chemical composition-melt wise

Bend test results

Max. camber

Gross and Net weight

Hardness and Erichson,

cupping values

7.0 BHEL reserves the right to carry out tests and reject the item where ever non conforming to the requirement of P.O and TDC.

Rev.No	Date	Changes made
00	26 02 96	TDC RTA 008 REV 04 Revised and Re numbered as TDC RTA 408/REV 00
01	29 11 02	CL 4.0 and CL 4.1 Revised to change tolerance on thickness plus 0.00 to plus 0.015 mm
02	10 05 02	TDC totally reviewed and revised

QUALITY ASSURANCE
QWI NO: TDC:RTA:408 Rev.02 Dtd.10.05.2002
<i>Amendment to Quality Work Instruction (QWI)</i>
Amendment No: A1 Date: 09.05.2017
Title: TDC FOR Cold rolled carbon sheets coils.8

Details of Amendment		
Clause No	Amended As	Basis for Amendment
Refer Clause no 3.4	OD of the Coil shall be 1300mm max and Coil wt. 5 to 9 MT max.	Shop feedback. Refer Email Dated:06.05.2017

Prepared By (QA)		Reviewed & Approved By
