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GB/T 708-2006

Replacing GB/T 708-1988

Dimension, shape, weight and tolerance for cold-rolled plates and sheets

(ISO 16162:2000, Continuously cold-rolled steel sheet products –
Dimensional and shape tolerances, NEQ)

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Foreword

This Standard is not equivalent to ISO 16162:2000 *Continuously cold-rolled steel sheet products – Dimensional and shape tolerances* (English version).

This Standard replaces GB/T 708-1988 *Dimensions shape weight and tolerances for cold-rolled plates and sheets*.

Compare with previous standard, the main changes of this Standard are as follows:

- Application scope mainly includes cold-rolled steel sheets and its shear products; the single cold-rolled sheet can also reference to this Standard for implementation;
- Re-adjust the provisions of classification and code;
- Cancel the stipulations on dimension of steel sheets in Table 1 of previous standard; add the recommended nominal thickness of steel sheets and strips;
- Add the minimum yield strength grading in permissible tolerance of thickness and flatness;
- Re-regulate the permissible tolerance of thickness, permissible tolerance of width, permissible tolerance of length, flatness, out-of-square and camber;
- Change the representation methods of edge state, dimensional precision and flatness;
- Add the method of theoretical weight-calculation of steel sheets.

This Standard was proposed by China Iron & Steel Association.

This Standard shall be under the jurisdiction of National Steel Standardization Technical Committee.

Main draft organizations of this Standard: China Metallurgical Information and Standardization Research Institute, Angang New Steel Co., Ltd., and Hunan Valin Lianyuan Iron and Steel CO., Ltd.

Main drafters of this Standard: Wang Xiaohu, Tang Yifan, Piao Zhimin, Zhou Jian and Zhou Yu.

The previous versions replaced by this Standard are as follows:

- GB 708-1965, GB 708-1988.

Dimension, shape, weight and tolerance for cold-rolled plates and sheets

1 Scope

This Standard specifies the dimensions, shapes, weights and permissible tolerances of cold-rolled steel sheets and strips [Translator note: to align with ISO 16162-2000 and Clause 3 of this Standard, hereafter “plate” is indicated as “sheet”; “sheet” is indicated as “strip”].

This Standard is applicable to cold-rolled wide strip of which the width is not less than 600 mm, its shear sheets (hereafter referred to as “steel sheet”) and slit wide strip. The single cold-rolled sheets can also reference to this Standard for implementation.

2 Normative References

The following provisions contain the provisions which, through reference in this text, constitute the provisions of this Standard. For dated reference, the subsequent amendments or revisions (excluding corrigendum contents) do not apply to this Standard. However, it is encouraged that all parties who reach an agreement according to this Standard study if the latest editions of these documents are applicable. For undated references, the latest edition of the normative document referred to applies.

GB/T 8170 Rules for rounding off of numerical values

3 Terms and Definitions

The following terms and definitions apply to this Standard.

3.1 Wide strip

It refers to the wide strip, delivered in coil-form, of which the rolling width is not less than 600 mm.

3.2 Sheet

It refers to the sheet that is horizontally cut from wide steel strip.

3.3 Slit wide strip

It refers to the strip that is longitudinally cut from wide steel strip, delivered in coil-form.

	>1500	19	17	15	8	7	6
280~<360	≤1200	15	13	10	8	6	5
	>1200~1500	18	15	13	9	8	6
	>1500	22	20	19	12	10	9

7.1.2 The flatness of steel sheets with specified minimum yield strength ≥ 360 MPa shall be determined by agreement between supplier and buyer.

7.1.3 For steel sheets with specified minimum yield strength < 280 MPa, when it is delivered as per high flatness, under the arbitration condition, it needs to additionally inspect the waviness; the waviness shall comply with the specification as follows:

- If the wave length is not less than 200 mm, the wave height shall be less than 1% of wave length (applied to the steel sheets of which the nominal width is less than 1500 mm), or 1.5% of wave length (applied to the steel sheets of which the nominal width is less than 1500 mm).
- If the wave length is less than 200 mm, the wave height shall be less than 2 mm.

7.1.4 If there is special requirement for flatness of steel strips, after the steel strips are unbent and flattened by buyer, the specified values in Table 6 are also applicable to the steel sheets that are cut from strips by users.

7.2 Camber

7.2.1 The camber of sheets and strips shall not be greater than 6 mm at any lengths of 2000 mm; when the length of steel sheets is not greater than 2000 mm, the camber shall not be greater than 0.3% of actual length of steel sheets. The camber of slit strips shall not be greater than 2 mm at any lengths of 2000 mm.

7.3 Out-of-square

The steel sheets shall be cut into right angle; the out-of-square shall not greater than 1% of width of steel sheets.

7.4 Tower

The steel strips shall be firmly coiled; one side of tower height of strip coil shall not exceed the specification in Table 7.

Table 7

Dimension in mm

Nominal thickness	Nominal width	Tower height
≤2.5	≤1000	40
	>1000	60
>2.5	≤1000	30
	>1000	50

weight-calculation shall use nominal dimension; the density of carbon steel is 7.85g/cm³; other steel shall be in accordance with relevant standards.

9.2 The calculating methods of theoretical weight-calculation for steel sheets shall be in accordance with specification in Table 8.

Table 8

Calculation sequence	Calculation method	Rounding off for results
Basic weight/[kg/(mm·m ²)]	7.85 (weight with thickness of 1mm and area of 1m ²)	—
Unit weight/(kg/m ²)	Basic weight/[kg/(mm·m ²)]x thickness (mm)	Rounding off to 4 significant figures
Area of steel sheet/m ²	Width (m)x length (m)	Rounding off to 4 significant figures
Weight of a piece of steel sheet/kg	Unit weight/(kg/m ²) x area (m ²)	Rounding off to 3 significant figures
Total weight/kg	Sum of weight of various steel sheets	Kg integral value

9.3 Value rounding off method shall be in accordance with provisions of GB/T 8170.

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