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**Dimension, shape, weight and tolerance for twin-roll casting
thin gauge hot-rolled steel strip and sheet**

双辊铸轧热轧薄钢板及钢带的尺寸、外形、重量及允许偏差

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Foreword

This document was drafted in accordance with the rules given in GB/T 1.1-2020, *Directives for standardization - Part 1: Rules for the structure and drafting of standardizing documents*.

Please note that some of the contents of this document may involve patents. The issuing organization of this document is not responsible for identifying patents.

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Dimension, shape, weight and tolerance for twin-roll casting thin gauge hot-rolled steel strip and sheet

1 Scope

This document specifies the classification and code, dimension, dimension tolerance, shape, measurement of dimension and shape, weight and rounding off for numerical values for twin-roll casting thin gauge hot-rolled steel strip and sheet (hereinafter referred to as “steel strip and sheet”).

This document applies to hot-rolled thin steel strips, slitting steel strips, as well as steel strip cross-cut steel plates – with a thickness of 0.6 mm ~ 2.0 mm and a width of 900 mm ~ 1800 mm – which are produced by twin-roll casting and rolling process.

2 Normative references

The following documents are normatively referenced in this document and are indispensable for its application. For dated references, only the version corresponding to that date is applicable to this document; for undated references, the latest version (including all amendments) is applicable to this document.

GB/T 8170, Rules of rounding off for numerical values & expression and judgment of limiting values

3 Terms and definitions

The following terms and definitions are applicable to this document.

3.1 Twin-roll cast steel strip and sheet

Steel strip and sheet which is made by using the twin-roll casting and rolling process, to directly cast the molten steel into a cast strip of a thickness close to the final thickness, and subsequently hot-rolled with a small reduction.

4 Classification and code

4.1 The classification and code, by edge state, are as follows:

- a) cut edge, EC;
- b) mill edge, EM.

4.2 The classification and code, by dimension precision, are as follows:

- a) ordinary thickness precision, PT. A;
- b) higher thickness precision, PT. B;
- c) ordinary width precision, PW. A;
- d) higher width precision, PW. B;
- e) ordinary length precision, PL. A;
- f) higher length precision, PL. B.

4.3 By surface treatment method, it is divided into:

- a) hot rolled state;
- b) pickling state.

5 Dimensions

5.1 Nominal dimension range

The nominal dimension range of steel strip and sheet shall comply with the provisions in Table 1.

5.2 Recommended nominal dimensions

5.2.1 The nominal thickness of the steel strip and sheet shall be any size in multiples of 0.05 mm, and within the range specified in 5.1.

5.2.2 The nominal width of the hot-rolled thin steel plate and hot-rolled thin steel strip shall be within the range specified in 5.1, and any dimension in multiples of 5 mm. The nominal width of the slitting steel strip shall be within the range specified in 5.1, and any dimension in multiples of 1 mm.

5.2.3 The nominal length of the hot-rolled steel plate shall be within the range specified in 5.1, and any dimension in multiples of 50 mm.

8 Measurement of dimension and shape

8.1 Thickness

8.1.1 The mill-edged steel strip and sheet shall be measured at a distance not less than 40 mm from the rolling edge; the cut-edged steel strip and sheet shall be measured at a distance not less than 25 mm from the cutting edge.

8.1.2 When the width of the slitting steel strip is less than 50 mm, measure along the center of the width direction.

8.2 Width

Width shall be measured perpendicular to the centerline of the steel strip or sheet.

8.3 Unevenness

8.3.1 Place the hot rolled thin steel plate freely on the plane, without applying any pressure except the weight of the steel plate itself; use a measuring tool of the corresponding precision level to measure the maximum distance between the lower surface of the hot rolled thin steel plate and the platform (as shown in the Figure 1).

8.3.2 For the hot rolled thin steel plate with a length not greater than 2 000 mm, its length is the measuring length of unevenness; for the hot rolled thin steel plate with a length greater than 2 000 mm, any length of 2 000 mm can be cut arbitrarily for the measurement of unevenness.

8.4 Rocker

The maximum distance between the concave side of the hot rolled thin steel strip or hot rolled thin steel plate and the straight line connecting the two ends of the measuring part (as shown in Figure 2) shall be measured on the concave side of the product. The measuring position of the rocker of the hot rolled thin steel strip is not less than 5 000 mm from the head or tail.

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