

TATA STEEL
Technical Processing requirement (SPC-PTG)

TPR NO.: TPR West_ACGL Jejuri Internal		Customer ACGL Jejuri	REV. NO.: 00	DATE: 08-12-2021																				
Segment: AUTO – Internal		Product: Full/Slit Coil / Plate & Cut-to-length sheets (HRPO & HRSPO)	Grade: Any																					
Issued to EPA: TSPDL-Pune, SKM Taloja																								
Sr. No.	Parameter	Acceptance Norms																						
1	Dimension & Shape tolerance (a) <u>Thickness</u>	Conversion agents to ensure for discarding the portion which is beyond tolerance as mentioned below																						
		<table border="1" style="width: 100%; border-collapse: collapse;"> <thead> <tr> <th style="text-align: center;">Thickness Range (mm)</th> <th style="text-align: center;">Thickness Tolerance (mm)</th> </tr> </thead> <tbody> <tr><td style="text-align: center;">1.60 - 2.80</td><td style="text-align: center;">-0.14/+0.06</td></tr> <tr><td style="text-align: center;">2.81 - 3.10</td><td style="text-align: center;">-0.16/+0.08</td></tr> <tr><td style="text-align: center;">3.11 - 4.99</td><td style="text-align: center;">-0.17/+0.08</td></tr> <tr><td style="text-align: center;">5.00 - 5.99</td><td style="text-align: center;">-0.19/+0.08</td></tr> <tr><td style="text-align: center;">6.00 - 8.99</td><td style="text-align: center;">-0.21/+0.10</td></tr> <tr><td style="text-align: center;">9.00 - 12.00</td><td style="text-align: center;">-0.23/+0.10</td></tr> <tr><td style="text-align: center;">12.01-15.00</td><td style="text-align: center;">-0.26/+0.13</td></tr> <tr><td style="text-align: center;">15.01-20.00</td><td style="text-align: center;">-0.30/+0.15</td></tr> <tr><td style="text-align: center;">20.01-25.00</td><td style="text-align: center;">-0.36/+0.18</td></tr> </tbody> </table>			Thickness Range (mm)	Thickness Tolerance (mm)	1.60 - 2.80	-0.14/+0.06	2.81 - 3.10	-0.16/+0.08	3.11 - 4.99	-0.17/+0.08	5.00 - 5.99	-0.19/+0.08	6.00 - 8.99	-0.21/+0.10	9.00 - 12.00	-0.23/+0.10	12.01-15.00	-0.26/+0.13	15.01-20.00	-0.30/+0.15	20.01-25.00	-0.36/+0.18
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(b) <u>Width</u>																								
<ul style="list-style-type: none"> Untrimmed HR Coil Width Trimmed / Slit Coil Width 	-0, + 20 mm (max) -0, +1mm (max.)																							
<u>For Cut-to-length sheets</u>																								
c) Camber	1.0mm per meter (at the trim edge) in cut to length sheet.																							
d) Flatness	10mm (max) over 1meter of length. 2-3 waves per meter																							
e) Length	+4mm (max)/-0.0mm for CTL>1m																							
	+2mm (max)/-0.0mm for <1m																							
f) Diagonal Difference	+4mm (max) for CTL >1m and 2mm (max) for <1m CTL																							
2	Fish tail / Tongue	Should be discarded.																						
3	Telescopicity	25 mm (max)																						
4	Slit coil ID	± 15 mm (max) of nominal coil ID as per order.																						
5	Surface	<ul style="list-style-type: none"> A clearance norm with the “Limit sample photographs” of the surface defects is prescribed in Annexure#1. For all continuous defects, the severity will be considered up by 1 (e.g., the 2 Severity defect if present in full coil, the severity will be read as 3). Three defects (i.e Rust – Spot / Patch & Hole / Surface Discontinuity) is “NOT-ALLOWED” even if the severity is low. 																						
6	Inspection	Both top and bottom surfaces as per Inspection plan.																						
7	Slit Coil weight	As per order																						
8	Slit Edge quality	Edge should be free from slitting induced defects.																						
9	(a) Burr height	5% of thickness																						
9	Bundling	As per order																						
10	Product identification	Parent Coil no., Cast no., Grade, slit position number (on each slit coil starting from drive side along with parent coil number) with slit size & date of slitting should be written on the coil.																						
11	Document requirements	Tata Steel test certificate																						
12	Supply condition	As per order																						
13	Special instruction	<ul style="list-style-type: none"> Oiling should be done uniformly on both surfaces. Edge oiling to done to prevent rusting Packaging – LPDE-HDPE 																						
PREPARED BY:		APPROVED BY	APPROVED BY																					
SIGNATURE:		SIGNATURE :	SIGNATURE :																					
NAME: Nitin M Patil		NAME : Saurabh Hadas	NAME :																					
DESIGNATION: Sr. Mgr SPC QA West TSL		DESIGNATION: Head SPC QA TSL	DESIGNATION:																					

NORMS AGREED BY EPA:
SIGNATURE:
NAME : Vikram Parte
DESIGNATION: SPC QA SKM Taloja

Annexure L: Surface Clearance norms*

Sr.no	Defect	Severity allowed max
1	High Temperature Scale (HTS)	3
2	Salt & Pepper scale	3
3	Banded Scale	3
4	Sticky Scale	3
5	Boat scale	3
6	Gouge Mark	3
7	Scratch	Non feelable by nail
8	Sticker/Roll mark	3
9	Slivers/Lamination/Al Stringers	2
10	Pitting Marks	3
11	Black/Yellow / Brown Patches	Not allowed
12	Coil Break Mark (CBM)	3
13	Saddle patches	Not allowed
14	Fold/Bump marks/gripper mark	Not allowed
15	Rubbing mark	Not allowed
16	Rust – Spots or Patches	Not allowed
17	Black/Brown Pickling patches	Not allowed
18	Coolant patches	Not allowed
19	Loose scale	Not allowed
20	Surface & edge should be free from Powdery scale / loose scale. Same needs to be cleaned before sending.	Edge powder not allowed. To be cleaned.
21	Fish Tail end mark	Not allowed

***Check for the Defect Library for defect and Severity.**