

## LEVELING

	HEAVY GAUGE	LIGHT GAUGE	NARROW WIDTH
Gauge Range	.135" - .565"	.054" - .165"	.125" - .565"
Width Range	30" - 96"	24" - 72"	4" - 29"
OD Inbound	40" - 80"	40" - 80"	30" - 72"
ID Inbound	20" - 32"	20" - 32"	18" - 30"
Weight	80,000 lbs.	60,000 lbs.	20,000 lbs.
Length	60" - 720"	30" - 288"	60" - 480"
Pack Height	up to 18" incl. skid	up to 18" incl. skid	12"
Pack Weight	40,000 lbs. max	40,000 lbs. max	20,000 lbs. max

Length tolerance: 1/2 ASTM-A-568 commercial tolerance

## STRETCHER LEVELING

	GAUGE	WIDTH	LENGTH	ELONGATION	STRETCHING FORCE
	.135" - .565"	30" - 96"	60" - 720"	2% max	2,200 tons max
	.054" - .165"	24" - 72"	30" - 288"	2% max	1,000 tons max

### TYPICAL MEMORY FREE FLATNESS

YIELD STRENGTH	INCOMING SHAPE	OUTGOING SHAPE
≤ 70,000 psi	≤ 100 I-Units	≤ 5 I-Units
≤ 70,000 psi	> 100 I-Units	x 20 improvement
> 70,000 psi	≤ 100 I-Units	≤ 8 I-Units
> 70,000 psi	> 100 I-Units	x 10 improvement

## SLITTING

	LIGHT GAUGE		HEAVY GAUGE	
	Inbound	Outbound	Inbound	Outbound
Gauge	.054" - .250"	.054" - .250"	.125" - .625"	.125" - .625"
Width	15" - 60"	2" - 60"	15" - 76"	4" - 72"
OD	36" - 80"	36" - 76"	36" - 80"	36" - 76"
ID	20" - 32"	20" or 24"	20" - 32"	24" or 30"
Weight	80,000 lbs.	60,000 lbs.	80,000 lbs.	80,000 lbs.

### MULTS BY GAUGE

Gauge	.054	.125	.250	.375	.500	.565	.625
50 ksi	16	14	12	8	5	4	2
80 ksi	16	14	12	8	4	3	2

Slit width tolerance: 1/2 of commercial tolerance per ASTM-A-568 or better

Edge trim required: 4x thickness or 1" min— whichever is greater

Cannot slit coils with mill edge on one side, ie drop cut must have cut edge on both sides with min required edge trim