



LEVELING

	HEAVY GAUGE	LIGHT GAUGE	NARROW WIDTH
Gauge Range	.135" - .565"	.053" - .165"	.125" - .565"
Width Range	30" - 96"	24" - 72"	6" - 24"
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
	.053" - .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	.053" - .250"	.053" - .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	.053	.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
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