

HR STRETCHER LEVELING CTL

	LINE #1	LINE #2
Gauge Range	.135" - .565"	.053" - .165"
Width Range	30" - 96"	24" - 72"
OD Inbound	40" - 80"	40" - 80"
ID Inbound	20" - 32"	20" - 32"
Weight	80,000 lbs.	60,000 lbs.
Length	60" - 720"	30" - 288"
Pack Height	up to 18" incl. skid	up to 18" incl. skid
Pack Weight	40,000 lbs. max	40,000 lbs. max
Elongation	GA 1 2	GA 1 2
Unit Weight	GA 1 2 • 1 max	GA 1 2 • 1 2

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

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

HR SLITTING

	LINE #1		LINE #2	
	Inbound	Outbound	Inbound	Outbound
Gauge	.125" - .625"	.125" - .625"	.053" - .250"	.053" - .250"
Width	15" - 76"	4" - 72"	15" - 60"	2" - 60"
OD	36" - 80"	36" - 76"	36" - 80"	36" - 76"
ID	20" - 32"	24" or 30"	20" - 32"	20" or 24"
Weight	80,000 lbs.	80,000 lbs.	80,000 lbs.	60,000 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