

Pickling Line Capabilities



Approved by: General Manager
 Authorized by: Q.A. Manager
 Date: 6/28/2019

400 Glover Road, Stoney Creek Ontario L8E 5X1

Pickling	<input checked="" type="checkbox"/> Yes <input type="checkbox"/> No	Gauge Trace	<input checked="" type="checkbox"/> Yes <input type="checkbox"/> No
Multi Slitting	<input checked="" type="checkbox"/> Yes <input type="checkbox"/> No	Gauge Trace Type	Single Point Center Line
Leveling	<input checked="" type="checkbox"/> Yes <input type="checkbox"/> No	Surface Inspection	<input checked="" type="checkbox"/> Yes <input type="checkbox"/> No
Re-pickling	<input checked="" type="checkbox"/> Yes <input type="checkbox"/> No	Entry Mandrel	Cones - Overwind Only
Edge Trim	<input checked="" type="checkbox"/> Yes <input type="checkbox"/> No	Exit Mandrel	Latch - Overwind Only

Machine Limitations			
Thickness	Gauge	Width	Yield
	.050"-.375"	18-74"	67 ksi max
	.376"-.500"	50" max	50 ksi max
70 carbon - .300" max.			Charged ID
			18" - 30"
			Finished ID
			20" (.050"-.375" ga.) or 24" (.050"-.500" ga.)
Charged Width	See above		Charged OD
			32" min. / 96" max.
Finished Slit Width	7" min / 72.5" max		Finished OD
			80" max
Charged Weight	80,000 lbs. Max		Finished Weight
			20" ID (50,000 lbs.) or 24" ID (80,000 lbs.)

Oiling Capability	
Types	Application
Any oil or prelude, no tallow.	Oil is applied to the top, bottom, or both surfaces using spray nozzles. Coverage is controlled by a timer that can be adjusted to achieve a light, normal, or heavy application. Others are applied directly to the strip surface and excess oil is removed by the oiler roll.
Dry Lubes (Coatings): N/A	
Minimum Coil Length	
380 feet	

Max # of Cuts		
Based on 50 ksi material. Refer to bottom of page for other.		
Thickness	Width	# of mults
.150"-.250"	67" max	7
.251"-.313"	60" max	6
.314"-.375"	60" max	5
.376"-.438"	48" max	3
.439"-.500"	48" max	1
** For 2 Cut - Please Inquire **		

Edge Trim Capability per Side		
Thickness	Min	Max
.060"-.300"	.375" or 2X thickness whichever is greater	2.5" per side
** Over .300 gauge please inquire**		
Please include finished slit width tolerances when calculating edge trim allowance.		

Slit Width Capability	
Thickness	Tolerance
.150"-.200"	+ .020 / - 0
.201"-.500"	+ .030 / - 0
Capability based on slit width equal to or less then 24", Please inquire for others.	

Incoming Telescope
Up to 8" per side, with a max width of 84 inches

Pickling Capability	
Product (Material Type)	Comments
Cold Rolled	Must specify Grade and Yield Strength.
Hot Rolled Plain Dry	Must specify Grade and Yield Strength.

Grade/Yield Strength Specific Slitting Capability .150" Gauge Minimum			
Product	Sidetrिम	Slit	Comments
Grade upto 1070	Yes	Inquire	.300 gauge max.
Grade 4130	Yes	Inquire	.300 gauge max.
Grade 4140	Yes	Inquire	.300 gauge max.
60 ksi	Yes	Yes	4 mults @ .375", 6 mults @ .250" max.
70 ksi	Yes	Yes	3 mults @ .375", 5 mults @ .250", 7 mults @ .187" max.
80 ksi	Yes	Yes	5 mults @ .250", 5 mults @ .187" max.
90 ksi	Yes	Yes	3 mults @ .275", 4 mults @ .185" max.
** If outside of above please inquire **			

Pickling Line Capabilities

In Line Levelling Capability (.060 min to .260 max at 68" Wide)			
Product	Sidetrिम	Slit	Yield Strength
Hot Rolled Pickle (Dry & PO)	Inquire	Inquire	.060 to .145 gauge 80,000PSI max
Hot Rolled Pickle (Dry & PO)	Inquire	Inquire	.060 to .185 gauge 70,000PSI max
Hot Rolled Pickle (Dry & PO)	Inquire	Inquire	.060 to .235 gauge 60,000PSI max
Hot Rolled Pickle (Dry & PO)	Inquire	Inquire	.060 to .260 gauge 50,000PSI max

Note: For any pickling, sidetrिमing, slitting, packaging or oiling requirements that do not conform to the above specifications, please inquire.

Effective Date: June 28, 2019