

**Nelson Steel**  
 Processing Capability  
 Information Sheet

Approved By: General Manager  
 Authorized By: Q.A. Manager  
 Date: 1/9/13  
 Page: 1 of 2

Pickling Line				Nelson Steel - Glover Rd.	
Pickling	Yes	Inspection	100 ft. lead, middle, and trail each coil, coil, top and bottom.  Note: Please inquire for other inspection requirements.		
Multi Slitting	Yes				
Leveling	Yes				
Edge Trim	Yes				
Re-pickling	Yes				
Gauge Trace	Yes	Gauge Trace Type	Single Point or Full Width Scan		
Entry Mandrel: Cones - Overwind Only			Exit Mandrel: Latch - Overwind Only		
Machine Limitations					
Thickness	Gauge	Width	Yield	Charged ID	18" - 30"
	.060-.375"	18-74"	70 ksi max	Finished ID	20" (.060"-.375" ga.) or 24" (.060"-.500" ga.)
	.375-.500"	50" max	50 ksi max	Charged OD	32" min. / 96" max.
	70 carbon - .300" max.			Finished OD	80" max
Charged Width	See above				
Finished Slit Width	7" min / 72.5" max				
Charged Weight	80,000 lbs. Max				
Oiling Capability					
Types			Application		
Any oil or prelube, 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
.250"-.313"	60" max	6
.313"-.375"	60" max	5
.375"-.438"	48" max	3
.438"-.500"	48" max	2
** 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
.060"-.200"	+ .020 / - 0
.200"-.500"	+ .030 / - 0
Capability based on slit width equal to or less than 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			
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", 6 mults @ .187" max.
90 ksi	Yes	Yes	4 mults @ .187", 8 mults @ .134" max.

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**Pickling Line Nelson Steel - Glover Rd.**

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.