

Specifications for Incoming Coil

Incoming Coil Protection

Steelscape recommends that all incoming customer-owned feed coils be protected from corrosion prior to arriving at Steelscape. Steelscape is not responsible for corrosion that occurs to coils prior to being processed through Steelscape's production, nor is Steelscape responsible for damage to coils that have been in Steelscape's inventory for longer than sixty (60) days.

Dimension, Shape and Surface

Steelscape can only inspect to those physical requirements specified by the customer as required for the intended end use. However, the following general guidelines are appropriate for most end uses.

The decimal thickness and width of the received metal must be in tolerance with the painting order. Unless otherwise stated, all ordered thickness and widths are considered minimum, with all tolerances over.

All metal shall be free of center buckle and pinch marks. Any edge wave must fall within commonly recognized ASTM limits and must be generally suitable for processing on a continuous coating line. All metal edges must be substantially free of edge stain, edge strain, minute cross-breaks, cracks, saw-tooth, slivers, excessive burr, laps, slugs or folds and tears. Camber must not exceed 7/8" in a 20 foot section.

Inspection will be to standard ASTM tolerances unless otherwise stated on the painting order.

Substrate surfaces must be free of storage stain, oxidation, grease, silicones and wax. Painting of chemically-treated Galvanized material is subject to inquiry and must be identified as such on all incoming paperwork and coil tags.

Substrate surfaces must be free from excessive surface irregularities such as, but not limited to, dents, dings, pits, scale, pipe, hearth roll pickup, stringers and dross. Galvanized, Galvalume and Aluminum shall be reasonably free of dross, steam blisters, voids, craters, bands, stripes and curtains.

Galvanized or Galvalume coating should have a suppressed spangle relief, which is free of cob webbing or curtains. All substrates must be free of oxidation.

The substrate should be free of brands and stencils. (These will normally bleed through the paint coating).

If the substrate must be oiled, it should be lightly coated with an oil that is free of paraffin, lanolin and sulfonate. (The surface must have the ability to be readily cleaned with a typical paint line cleaning solution.)

The metals supplied must have adequate adherence to take pre-paint coating and fabricate without loss of adhesion or severe crazing of the zinc coating. (Normally zinc coating that can withstand a reverse impact of 120 inch pounds without loss of adhesion will meet this requirement.) The surface of the metal must be capable of accepting metal treatments at the appropriate coating weights without voids in the metal treatment coating when the product is processed within the temperature and concentration ranges as specified by the manufacturer.

Steelscape cannot process coils with interleaf.

Steelscape does not guarantee flatness as we do not have in-line leveling equipment; therefore coils must be free of coil set.

Coils must be wound flush. Stagger winding results in edge damage during handling and transporting. Coils must be wound tight and suitable for stacking.

Steelscape will not assume financial responsibility for rejects by the final customer which are due to steel related defects that are within standard tolerances unless tighter than standard tolerances were specified at the time of the pricing of the order.