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**NATIONAL STANDARD OF THE
PEOPLE'S REPUBLIC OF CHINA**

GB/T 15391-2010

Replacing GB/T 15391-1994

**Dimensions, shape and tolerances of cold-rolled steel strip less
than 600 mm wide**

宽度小于600mm冷轧钢带的尺寸、外形及允许偏差

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Quarantine;
Standardization Administration of the PRC**

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Foreword

The standard instead of GB/T 15391-1994 "width less than 600mm cold rolled steel strip size, shape and allowable deviation." This standard is compared with the original standard, the main amendments are as follows: - redefine the classification and codename;

--- to cancel the original standard supply thickness negative deviation agreement terms;

--- the width of the allowable deviation, roughness re-provided;

--- the weight of the provisions. This standard is proposed by China Iron and Steel Industry Association. This standard by the National Steel Standardization Technical Committee. The drafting of this standard unit. Metallurgical Industry Information Standards Institute, Jiangsu Province, stainless steel products Quality Supervision and Inspection Center. The main drafters of this standard. Wang Xiaohu, Dong Li, Chen Anyuan. This standard has been replaced by the previous version of the release.

--- GB/T 15391-1994. Width less than 600mm cold rolled steel strip Size, shape and allowable deviation

1 Scope

China's national standard for the dimensions, shape and tolerances of narrow cold-rolled steel strip - the material less than 600 millimetres wide from which pressed and formed parts, tube, profiles, springs, saw blades, packaging and countless components are made. It specifies the dimensions, the shape and the permissible deviations for cold-rolled steel strip of width less than 600 mm. The six hundred millimetre boundary is not arbitrary: it is the international division between wide flat products, which are rolled on a plate or strip mill and toleranced as sheet, and narrow strip, which is either rolled narrow or slit from wide material and which carries a different set of achievable tolerances and a different set of defects. Narrow strip is defined by properties that do not arise on wide product. The edge condition matters, because the strip is either slit - leaving a cut edge with a burr and a work-hardened zone - or rolled with a natural edge, and the two behave completely differently in a forming press and in a welded tube mill. The camber, the deviation from

straightness along the length in the plane of the strip, is a narrow-strip defect specifically: it makes the material wander in a roll-forming line and produces a tube that will not track. And the flatness, the crossbow and the coil set determine whether the strip lies down after it leaves the coil at all. This standard sets the tolerances on the thickness and its variation along and across the strip, the width, the edge camber, the flatness, the burr and the coil dimensions - and the tolerance grades, so that a purchaser buys the precision the application needs rather than the best available. Issued on 2 September 2010 and in force since 1 June 2011, it replaces GB/T 15391-1994.

This standard specifies the width, less than 600mm cold-rolled strip (hereinafter referred to as steel) size, shape and allowable deviation. This standard applies to the rolling width of less than 600mm, the thickness of not more than 3mm cold rolled steel.

2.1 Divided by edge state Trimming EC Not trimming em

2.2 by size accuracy is divided into Ordinary thickness accuracy Higher thickness accuracy General width accuracy Higher width accuracy PW.B

3.1 The thickness of the steel strip is not more than 3.00mm.

3.2 The width of the steel strip is 6mm ~ < 600mm.

4 size tolerance

4.1 Allowable deviation of thickness

4.1.1 The allowable deviation of the thickness of the strip shall be in accordance with Table 1. Table 1 units are in millimeters Nominal thickness Thickness tolerance Normal accuracy, PT.A higher accuracy, PT.B Nominal width Nominal width < 250 250 ~ < 600 < 250 250 ~ < 600 $\leq 0.10 \pm 0.010 \pm 0.015 \pm 0.005 \pm 0.010 >$

$0.10 \text{ to } 0.15 \pm 0.010 \pm 0.020 \pm 0.005 \pm 0.015 > 0.15 \sim 0.25 \pm 0.015 \pm 0.030 \pm 0.010 \pm 0.020 >$

$0.25 \text{ to } 0.40 \pm 0.020 \pm 0.035 \pm 0.015 \pm 0.025 >$

$0.40 \text{ to } 0.70 \pm 0.025 \pm 0.040 \pm 0.020 \pm 0.030 >$

$0.70 \text{ to } 1.00 \pm 0.035 \pm 0.050 \pm 0.025 \pm 0.035 > 1.00 \sim 1.50 \pm 0.045 \pm 0.060 \pm 0.035 \pm 0.045 >$

$1.50 \text{ to } 2.50 \pm 0.060 \pm 0.080 \pm 0.045 \pm 0.060 >$

$2.50 \text{ to } 3.00 \pm 0.075 \pm 0.090 \pm 0.060 \pm 0.070$