

HOT - ROLLED SHEET

GOST 19003-74

STEEL.

SUPERSEDES

GOST 8597-57 **

DIMENSIONMENT.

PART 1 OF 20

21

03. Code

1. This standard pertains to hot-rolled sheet steel having width 500mm and above, produced in the form of sheets of thickness from 0.5 to 160mm and rolls of thickness from 1.2 to 12mm.

The requirements of SEV recommendations as per standards RS 919-71, RS 1682-69 and RS 1684-69 have been taken into account in this standard.

2. Sizes of sheets should correspond to the values given in table 1 and in case of rolls - in table 2.

3. Sheet steel is classified:

a) as regards accuracy of rolling:

increased accuracy - A, Δ

normal accuracy - B; ∇

b) as regards planeness:

extra-high planeness - PO, ∇

high planeness - PV, ∇

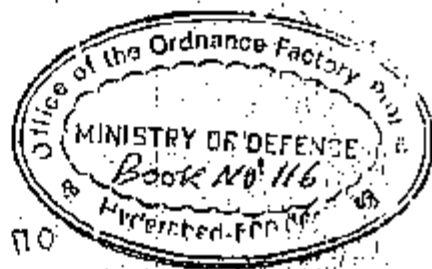
improved planeness - PU; ∇

normal planeness - PN; ∇

c) as regards edge:

with untrimmed edge - NO, ∇

with trimmed edge - O; ∇



FOR REVISION ONLY

** as regards sheets having width 500mm and above, GOST 3780-57, as regards hot-rolled sheets and GOST 5681-57,

APPROVED	<i>M. K. K.</i>	<i>g</i>	MATL/SPECN.			
ENGINEER / GP. IN CHARGE	<i>M. K. K.</i>		HEAT TREAT			
CHECKED	<i>M. K. K.</i>	<i>21.11.74</i>	FINISH			
DRAWN				ISS. NO.	ISSD. BY	APPRD.

d) as regards sizes:

with indication of sizes as regards thickness, width and length in accordance with the sizes given in the appendix - form I;

with indication of sizes as regards thickness within the limits as given in table 1, but without indication of sizes as regards width and length - form II;

with indication of sizes which are multiple (as regards width and length) to sizes given in the order within the limits given in table 1 - form III;

with indication of standard sizes within the limits given in table 1, at intervals of 10mm as regards width and 50mm as regards length - form IV. On mutual agreement of customer and manufacturer the intervals as regards width and length may be less than those indicated.

On customer's request, the sheet steel can be supplied in standard sizes other than the sizes given in the appendix.

Sheet thickness

Minimum and maximum length of sheets when width is :

Sheet thickness	1900	2000	2100	2200	2300	2400	2500	2600	2700	2800	2900	3000	3200	3400	3600	3800
0.50; 0.55; 0.60	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
0.65; 0.70; 0.75	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
0.80; 0.90	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
1.0	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
1.2; 1.3; 1.4	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
1.5; 1.6; 1.8	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
2.0; 2.2	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
2.5; 2.8	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
3.0; 3.2; 3.5; 3.8	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
3.9	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
4.0; 4.5; 5.0	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
6.0; 7.0	2000	2000	-	-	-	-	-	-	-	-	-	-	-	-	-	-
5000	5000	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
2.0; 2.0; 10.0	3000	3000	3000	3000	3000	4000	4000	-	-	-	-	-	-	-	-	-
12000	12000	12000	12000	12000	12000	12000	12000	-	-	-	-	-	-	-	-	-
1; 12	3000	3000	3000	3000	3000	4000	4000	-	-	-	-	-	-	-	-	-
12000	12000	12000	12000	12000	12000	12000	12000	-	-	-	-	-	-	-	-	-
13; 14; 15; 16; 17;	4000	4000	4500	4500	4500	4500	4000	-	-	-	-	-	-	-	-	-
18; 19; 20; 21; 22;	10000	10000	10000	10000	10000	10000	10000	3500	3500	3500	3500	3000	3200	3400	3500	-
25	10000	10000	10000	10000	10000	10000	10000	8200	8200	8200	8200	8200	8200	8500	8000	7000
26.0; 28.0; 30.0;	4000	4000	4000	4000	4500	4000	4000	-	-	-	-	-	-	-	-	-
32.0; 35.0; 38.0;	4000	4000	4000	4000	4500	4000	4000	3500	3500	3500	3500	3000	3200	3400	3500	-
40.0	12000	12000	12000	12000	12000	11000	11000	10000	10000	10000	10000	9500	9500	9500	9500	-
42.0; 45.0; 48.0; 50;	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
52; 55; 60; 63; 70;	3500	3500	3500	3500	3500	3500	3500	3000	3000	3000	3000	3000	3200	3400	3600	3600
73; 80; 85; 90; 95;	3500	3500	3500	3500	3500	3500	3500	3000	3000	3000	3000	3000	3200	3400	3600	3600
100; 105; 110; 120;	9000	9000	9000	9000	9000	9000	9000	9000	9000	9000	9000	9000	9000	8500	8000	7000
125; 130; 140; 150;	9000	9000	9000	9000	9000	9000	9000	9000	9000	9000	9000	9000	9000	8500	8000	7000

Notes: With the approval of the manufacturer, sheets of other sizes may be supplied.

Width of Steel Sheet	Thickness of steel to be supplied in rolls																					
	1.5	2.0	2.5	3.0	3.5	4.0	4.5	5.0	5.5	6.0	6.5	7.0	7.5	8.0	8.5	9.0	9.5	10.0	10.5	11.0	11.5	12.0
500	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5
530	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5
550	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5
600	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5
630	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5
650	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5
670	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5
700	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5
(710)	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5
750	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5
800	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5
850	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5
900	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5
950	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5
1000	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5
1100	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5
1200	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5
1300	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5
(1400)	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5
1500	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5
1600	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5
1700	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5
1800	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5
1900	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5
2000	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5
2100	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5
2200	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5

Note: With the approval of customer and manufacturer, steel sheet may be supplied in rolls having other sizes as regards thickness and width as compared to the values given in Table 2.

4. Limit deviations on thickness of steel, to be supplied in sheets and coils, at any point of measurement should not exceed the norms given in Table 3 and 4.

Limit deviations on thickness of steel when width is

Steel thickness (sheets and rolls)	From 500 to 750	above 750 to 1000	above 1000 to 1500	above 1500 to 2000	above 2000 to 2500	above 2500 to 2730	above 2730 to 3000	Increased		Normal		Increased		Normal		Increased		Normal	
								rolling accuracy	rolling accuracy	rolling accuracy	rolling accuracy	rolling accuracy	rolling accuracy	rolling accuracy	rolling accuracy	rolling accuracy	rolling accuracy	rolling accuracy	rolling accuracy
0.50	±0.05	±0.07	±0.08	±0.09	±0.10	±0.11	±0.12	±0.13	±0.14	±0.15	±0.16	±0.17	±0.18	±0.19	±0.20	±0.21	±0.22	±0.23	±0.24
Above 0.50	to 0.60	±0.06	±0.08	±0.09	±0.10	±0.11	±0.12	±0.13	±0.14	±0.15	±0.16	±0.17	±0.18	±0.19	±0.20	±0.21	±0.22	±0.23	±0.24
"	"	0.75	±0.07	±0.09	±0.10	±0.11	±0.12	±0.13	±0.14	±0.15	±0.16	±0.17	±0.18	±0.19	±0.20	±0.21	±0.22	±0.23	±0.24
"	"	0.90	±0.08	±0.11	±0.09	±0.12	±0.13	±0.14	±0.15	±0.16	±0.17	±0.18	±0.19	±0.20	±0.21	±0.22	±0.23	±0.24	±0.25
"	"	1.10	±0.10	±0.12	±0.11	±0.13	±0.14	±0.15	±0.16	±0.17	±0.18	±0.19	±0.20	±0.21	±0.22	±0.23	±0.24	±0.25	±0.26
"	"	1.30	±0.11	±0.13	±0.12	±0.14	±0.15	±0.16	±0.17	±0.18	±0.19	±0.20	±0.21	±0.22	±0.23	±0.24	±0.25	±0.26	±0.27
"	"	1.40	±0.11	±0.14	±0.12	±0.15	±0.16	±0.17	±0.18	±0.19	±0.20	±0.21	±0.22	±0.23	±0.24	±0.25	±0.26	±0.27	±0.28
"	"	1.60	±0.12	±0.15	±0.13	±0.16	±0.17	±0.18	±0.19	±0.20	±0.21	±0.22	±0.23	±0.24	±0.25	±0.26	±0.27	±0.28	±0.29
"	"	1.80	±0.13	±0.16	±0.14	±0.17	±0.18	±0.19	±0.20	±0.21	±0.22	±0.23	±0.24	±0.25	±0.26	±0.27	±0.28	±0.29	±0.30
"	"	2.00	±0.14	±0.17	±0.15	±0.18	±0.19	±0.20	±0.21	±0.22	±0.23	±0.24	±0.25	±0.26	±0.27	±0.28	±0.29	±0.30	±0.31
"	"	2.30	±0.15	±0.18	±0.16	±0.19	±0.20	±0.21	±0.22	±0.23	±0.24	±0.25	±0.26	±0.27	±0.28	±0.29	±0.30	±0.31	±0.32
"	"	2.50	±0.16	±0.19	±0.17	±0.20	±0.21	±0.22	±0.23	±0.24	±0.25	±0.26	±0.27	±0.28	±0.29	±0.30	±0.31	±0.32	±0.33
"	"	2.70	±0.17	±0.20	±0.18	±0.21	±0.22	±0.23	±0.24	±0.25	±0.26	±0.27	±0.28	±0.29	±0.30	±0.31	±0.32	±0.33	±0.34
"	"	3.00	±0.18	±0.21	±0.19	±0.22	±0.23	±0.24	±0.25	±0.26	±0.27	±0.28	±0.29	±0.30	±0.31	±0.32	±0.33	±0.34	±0.35
"	"	3.50	±0.20	±0.23	±0.21	±0.24	±0.25	±0.26	±0.27	±0.28	±0.29	±0.30	±0.31	±0.32	±0.33	±0.34	±0.35	±0.36	±0.37
"	"	5.5	±0.40	±0.50	±0.45	±0.55	±0.60	±0.65	±0.70	±0.75	±0.80	±0.85	±0.90	±0.95	±1.00	±1.05	±1.10	±1.15	±1.20
"	"	7.5	±0.50	±0.60	±0.55	±0.65	±0.70	±0.75	±0.80	±0.85	±0.90	±0.95	±1.00	±1.05	±1.10	±1.15	±1.20	±1.25	±1.30
"	"	10.0	±0.80	±1.00	±0.90	±1.10	±1.20	±1.30	±1.40	±1.50	±1.60	±1.70	±1.80	±1.90	±2.00	±2.10	±2.20	±2.30	±2.40
"	"	18.0	±1.20	±1.50	±1.40	±1.70	±1.80	±1.90	±2.00	±2.10	±2.20	±2.30	±2.40	±2.50	±2.60	±2.70	±2.80	±2.90	±3.00

Note: Supply of sheet steel with negative tolerances, equal (in value) to sum of limit deviations is allowed, if it is required by firms of Ministry of Aviation Industry.

Limit Deviations on steel thickness (mm) as is

Steel thickness	1000 to 1200	Above 1200 to 1500	Above 1500 to 1700	Above 1700 to 1800	Above 1800 to 2000	Above 2000 to 2200	Above 2200 to 2300	Above 2300 to 2500	Above 2500 to 2600	Above 2600 to 2800	Above 2800 to 3000	Above 3000 to 3200	Above 3200 to 3400	Above 3400 to 3600	Above 3600 to 3800
12.0	+0.2	+0.2	+0.3	+0.4	+0.6	+0.8	+0.8	+0.8	+1.0	+1.1	+1.2	-	-	-	-
15.0	+0.8	+0.8	+0.8	+0.8	+0.8	+0.8	+0.8	+0.8	+0.8	+0.8	+0.8	+0.8	+0.8	+0.8	+0.8
20.0	+0.4	+0.5	+0.6	+0.7	+0.8	+1.0	+1.0	+1.1	+1.2	+1.4	+1.5	-	-	-	-
25.0	+0.3	+0.3	+0.3	+0.3	+0.3	+0.3	+0.3	+0.3	+0.3	+0.3	+0.3	+0.3	+0.3	+0.3	+0.3
30.0	+0.2	+0.3	+0.3	+0.4	+0.5	+0.6	+0.6	+0.6	+0.6	+0.6	+0.6	+0.6	+0.6	+0.6	+0.6
34.0	+0.3	+0.4	+0.5	+0.6	+0.7	+0.8	+0.8	+0.8	+0.8	+0.8	+0.8	+0.8	+0.8	+0.8	+0.8
40.0	+0.3	+0.4	+0.5	+0.6	+0.7	+0.8	+0.8	+0.8	+0.8	+0.8	+0.8	+0.8	+0.8	+0.8	+0.8
50.0	+0.5	+0.7	+0.8	+0.9	+1.0	+1.1	+1.1	+1.1	+1.1	+1.1	+1.1	+1.1	+1.1	+1.1	+1.1
60.0	+0.5	+0.7	+0.8	+0.9	+1.0	+1.1	+1.1	+1.1	+1.1	+1.1	+1.1	+1.1	+1.1	+1.1	+1.1
70.0	+0.5	+0.7	+0.8	+0.9	+1.0	+1.1	+1.1	+1.1	+1.1	+1.1	+1.1	+1.1	+1.1	+1.1	+1.1
80.0	+0.5	+0.7	+0.8	+0.9	+1.0	+1.1	+1.1	+1.1	+1.1	+1.1	+1.1	+1.1	+1.1	+1.1	+1.1
90.0	+0.5	+0.7	+0.8	+0.9	+1.0	+1.1	+1.1	+1.1	+1.1	+1.1	+1.1	+1.1	+1.1	+1.1	+1.1
100.0	+0.5	+0.7	+0.8	+0.9	+1.0	+1.1	+1.1	+1.1	+1.1	+1.1	+1.1	+1.1	+1.1	+1.1	+1.1
115.0	+0.5	+0.7	+0.8	+0.9	+1.0	+1.1	+1.1	+1.1	+1.1	+1.1	+1.1	+1.1	+1.1	+1.1	+1.1
125.0	+0.5	+0.7	+0.8	+0.9	+1.0	+1.1	+1.1	+1.1	+1.1	+1.1	+1.1	+1.1	+1.1	+1.1	+1.1
140.0	+0.5	+0.7	+0.8	+0.9	+1.0	+1.1	+1.1	+1.1	+1.1	+1.1	+1.1	+1.1	+1.1	+1.1	+1.1

NOTE: Supply of sheet steel with negative tolerances equal (in value) to the sum of limit deviations is allowed if it is required by the terms of Ministry of Aviation Industry.

6. On customer's request the difference in thickness of steel to be supplied in rolls, at a single cross-section should not exceed half the sum of limit-deviations on thickness.

6. Limit deviations on width of steel rolls having trimmed edges should not exceed:

- a) upto 1000 mm - if width is 500 to 1000 mm incl.;
- b) above 1000 mm - if width is more than 1000mm.

7. Limit deviations on width of steel sheets having trimmed edges should not exceed the norms given in table 5.

TABLE - 5

Steel width	Limit deviations on steel width when thickness is				
	upto 3.0	above 3.0 to 12	above 12 to 60	above 60 to 100	above 100 to 160
Upto 800	+6	+5	-	-	-
Above 800	+10	-	-	-	-
Upto 1500	-	+10	-	-	-
Above 1500	-	+5	-	-	-
All widths	-	-	+25	+50	+75

8. Limit deviations on width of sheet steel, rolled sheet-wise and supplied with untrimmed edge, should not exceed the limit deviations on width given in table 5 by more than 50mm.

9. Limit deviations on width of steel, rolled on continuous mills and supplied with untrimmed edge, should not exceed:

- a) 20 mm - if width is upto 1000 mm;
- b) 30 mm - if width is more than 1000 mm.

10. Limit deviations on length of steel, rolled sheet-wise, should not exceed the norms given in table 6.

TABLE - 6

mm

Steel length	Limit deviations on length of steel when thickness is				
	upto 3.9	above 3.9 to 16	above 16 to 60	above 60 to 100	above 100 to 160
Upto 1500	+10	-	-	-	-
Above 1500	+15	-	-	-	-
Upto 2000	-	+10	-	-	-
Above 2000 to 6000	-	+25	-	-	-
Above 6000	-	+35	-	-	-
Upto 3000	-	-	+15	-	-
Above 3000 to 6000	-	-	+25	-	-
Above 6000	-	-	+40	-	-
All lengths	-	-	-	+50	-
All lengths	-	-	-	-	+75

11. Limit deviations on length of steel, rolled on continuous mills and cut into sheets, should not exceed the norms given in table 7.

TABLE - 7

mm

Steel length	Limit deviations on length of steel when thickness is	
	Upto 3.9	above 3.9
Upto 1500	+15	-
Above 1500	+30	-
Upto 3000	-	+20
Above 3000	-	+25

12. Deviations from planeness for 1 metre length of steel to be supplied in sheets, should not exceed the norms given in table 8.

TABLE - 8.

Type of planeness	Deviations from planeness when steel thickness is as follows, mm, max.		
	0.6-1.4	1.5-3.9	4.0 and above
Extra-high	8	8	5
High	10	10	8
Improved	15	12	10
Nominal	20	15	12

Note: 1. Deviations from planeness, given in table 8, pertain to sheets from steel having $\sigma_u \leq 70 \text{ kg/mm}^2$; for sheets from steel having $\sigma_u > 70 \text{ kg/mm}^2$ the norms are given in the standards on general technical requirements or in specifications.

2. Sheet steel with extra high planeness is supplied by mutual agreement between customer and manufacturer.

3. Crescent shape of the steel, to be supplied in rolls, should not exceed 10mm over a length of 3m.

Other limit value of crescent shape may be set by mutual agreement between both parties.

4. Steel, to be supplied in sheets having trimmed edge, should be cut at right angles. Obliquity of cut and crescent shape should not lead the sheets beyond the nominal dimension.

5. In case steel is supplied in sheets and rolls with untrimmed edge, tears and other defects (if they are on the edges) should not exceed half the limit deviations on width and should not lead the sheets beyond the nominal dimension on width given in the order.

16. Steel, to be supplied in rolls, should not have twisted and crumpled ends. Bent edges (at an angle not exceeding 90°) are allowed in individual places.

17. Telescopicity (extensibility) of steel, to be supplied in rolls, should not exceed the norms given in table 9.

TABLE 9

Steel thickness	Steel width.	Telescopicity (extensibility) of rolls.
Up to 2.5	Up to 800	60
	Above 800	100
Above 2.5	Up to 800	35
	Above 800	70

Increase of one internal or one external turn over the surface of end of a roll is not considered as telescopicity (extensibility). Looseness of 2 outer turns of a roll is not a cause for rejection.

18. Measurement of steel thickness is done :

Imp

a) on sheets - at a distance of not less than 100mm from the ends and 40mm from the edges;

b) on rolls - at a distance of not less than 40mm from the edges and 2m from the end of roll.

19. Width of steel, to be supplied in rolls, is measured at a distance of not less than 2 m from the end of roll.

Eds of incomplete width along length should not exceed the roll width.

On customer's request, the ends of incomplete width should be trimmed.

20. Deviation from planeness of steel, to be supplied in sheets, is determined by the maximum deflection between surface of sheet (laid on plane surface) and by using a metric scale applied to it in any direction.

21. Steel, to be supplied in rolls, may consist of not more than 2 pieces (separate or welded together).

Ratio of lengths of pieces in one roll should not be less than 1 : 5. Rolls with more number of pieces or welded joints may be supplied by mutual agreement between customer and manufacturer.

22. Internal diameter of steel, to be supplied in rolls, should not be less than 650mm and should not be more than 1000mm.

23. Maximum weight of steel, to be supplied in rolls should not exceed 20 T.

Supply of steel in rolls having other values of weight is allowed by mutual agreement between customer and manufacturer.

HOT-ROLLED SHEET STEEL

ASSORTMENT

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Cont'd. Table

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Steel thickness

Length of sheet steel, when width is

Steel thickness	600	650	700	750	800	850	900	950	1000	1100	1250	1400	1420	1500	1600	1700	1800
3.0	2300	2400	2500	2600	2700	2800	2900	3000	3100	3200	3300	3400	3500	3600	3700	3800	3900
3.2	2200	2300	2400	2500	2600	2700	2800	2900	3000	3100	3200	3300	3400	3500	3600	3700	3800
3.5	2100	2200	2300	2400	2500	2600	2700	2800	2900	3000	3100	3200	3300	3400	3500	3600	3700
3.8	2000	2100	2200	2300	2400	2500	2600	2700	2800	2900	3000	3100	3200	3300	3400	3500	3600
4.0	1900	2000	2100	2200	2300	2400	2500	2600	2700	2800	2900	3000	3100	3200	3300	3400	3500
4.5	1800	1900	2000	2100	2200	2300	2400	2500	2600	2700	2800	2900	3000	3100	3200	3300	3400
5.0	1700	1800	1900	2000	2100	2200	2300	2400	2500	2600	2700	2800	2900	3000	3100	3200	3300
5.5	1600	1700	1800	1900	2000	2100	2200	2300	2400	2500	2600	2700	2800	2900	3000	3100	3200
6.0	1500	1600	1700	1800	1900	2000	2100	2200	2300	2400	2500	2600	2700	2800	2900	3000	3100

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Cont'd Table

Length of sheet steel, when width is.

Steel thickness:	2800	2900	3000	3100	3200	3300	3400	3500	3600	3700	3800	3900	4000	4100	4200	4300	4400	4500	4600	4700	4800	4900	5000	5100	5200	5300	5400	5500	5600	5700	5800	5900	6000	6100	6200	6300	6400	6500	6600	6700	6800	6900	7000	7100	7200	7300	7400	7500	7600	7700	7800	7900	8000	8100	8200	8300	8400	8500	8600	8700	8800	8900	9000
13; 14; 15; 16; 17; 18;	4500	4600	4700	4800	4900	5000	5100	5200	5300	5400	5500	5600	5700	5800	5900	6000	6100	6200	6300	6400	6500	6600	6700	6800	6900	7000	7100	7200	7300	7400	7500	7600	7700	7800	7900	8000	8100	8200	8300	8400	8500	8600	8700	8800	8900	9000	9100	9200	9300	9400	9500	9600	9700	9800	9900	10000							
19; 20; 21; 22; 23;	4500	4600	4700	4800	4900	5000	5100	5200	5300	5400	5500	5600	5700	5800	5900	6000	6100	6200	6300	6400	6500	6600	6700	6800	6900	7000	7100	7200	7300	7400	7500	7600	7700	7800	7900	8000	8100	8200	8300	8400	8500	8600	8700	8800	8900	9000	9100	9200	9300	9400	9500	9600	9700	9800	9900	10000							
25; 28; 30; 32; 34; 36;	4500	4600	4700	4800	4900	5000	5100	5200	5300	5400	5500	5600	5700	5800	5900	6000	6100	6200	6300	6400	6500	6600	6700	6800	6900	7000	7100	7200	7300	7400	7500	7600	7700	7800	7900	8000	8100	8200	8300	8400	8500	8600	8700	8800	8900	9000	9100	9200	9300	9400	9500	9600	9700	9800	9900	10000							
38; 40	4500	4600	4700	4800	4900	5000	5100	5200	5300	5400	5500	5600	5700	5800	5900	6000	6100	6200	6300	6400	6500	6600	6700	6800	6900	7000	7100	7200	7300	7400	7500	7600	7700	7800	7900	8000	8100	8200	8300	8400	8500	8600	8700	8800	8900	9000	9100	9200	9300	9400	9500	9600	9700	9800	9900	10000							

Steel thickness	Length of sheet steel, when width is,											
	2800	3200	3600	4000	4500	5000	5500	6000	6500	7000	7500	8000
25; 24; 30; 32; 3/4; 3/8;	6500	6300	6500	6500	6500	6500	6500	6500	6500	6500	6500	6500
28; 30	7000	7000	7000	7000	7000	7000	7000	7000	7000	7000	7000	7000
	7500	7500	7500	7500	7500	7500	7500	7500	7500	7500	7500	7500
	8000	8000	8000	8000	8000	8000	8000	8000	8000	8000	8000	8000
	9000	9000	9000	9000	9000	9000	9000	9000	9000	9000	9000	9000
	10000	10000	10000	10000	10000	10000	10000	10000	10000	10000	10000	10000
	11000	11000	11000	11000	11000	11000	11000	11000	11000	11000	11000	11000
	12000	12000	12000	12000	12000	12000	12000	12000	12000	12000	12000	12000

Notes:—In case of quality of sheets as per Form I provision of not more than 2 other sizes, taken from this table. In case of not more than 2 other sizes, taken from this table.

Other standards referred to in this standard: Nil

