

Product Information Sheet
Galvanized Strip Steel # MMD-060-100-003

1.0 Scope:

- 1.1 This document is for the procurement and control of commercial quality galvanized steel for the specific use as flat steel armoring tape.

2.0 Reference Documents:

- 2.1 ASTM A459 Standard Specification for Zinc-Coated Flat Steel Armoring Tape.
- ASTM A653 Standard Specification for Steel Sheet, Zinc-Coated (galvanized) or Zinc-Iron Alloy-Coated (galvannealed) by the Hot-dipped process.
- UL-1 Flexible Metal Conduit
- UL-4 Armored Cable
- UL-360 Liquid tight flexible metal conduit
- UL-1072 Medium voltage power cables
- UL-1569 Metal clad cable

3.0 Manufacture:

- 3.1 The steel shall be made by basic-oxygen, or electric arc furnace process.
- 3.2 The galvanize process shall conform to ASTM A-653.
- 3.3 The edge of tape shall conform to ASTM A-109, #3 and UL-4.
- 3.4 Tape will be furnished in continuous coils and shall contain welds. Gauge shall not vary outside of standard gauge range per ASTM A-459. The weld will be able to withstand the forming operation without breaking.
- 3.5 Surface of the tape shall be free from injurious scale, flaws, seams, splits, and other imperfections not consistent with good commercial practices. The zinc coating shall be bright, smooth, and continuous.

4.0 Chemical Composition:

- 4.1 SAE - AISI 1008

5.0 Galvanize Coating:

- 5.1 Zinc coating weight shall meet the minimum required by the customer.
- 5.2 Zinc coating shall not flake when the strip is bent 180° over a 1/8" diameter mandrel.
- 5.3 Zinc coating shall pass the Preece (Copper Sulfate) test per UL-4.

6.0 Product Marking:

- 6.1 The marking and identification will be in accordance with customer requirements.
 - 6.1.1 Supplier's Name
 - 6.1.2 Material Width
 - 6.1.3 Material Thickness
 - 6.1.4 Gross and Net Weights
 - 6.1.5 Date of Manufacture
 - 6.1.6 Time of Manufacture (lot number)

7.0 Dimensional Tolerances:

- 7.1 Thickness Tolerance: +/- 0.002" for gauge < 0.0251" and - 0.002", +0.003" for gauge > 0.025"
- 7.2 Width Tolerance: + 0.008", - 0.008"
- 7.3 Camber Tolerance: 1/2" maximum in 8' sheet.

8.0 Mechanical Property Requirements:

- 8.1 Tensile Strength: 40,000 - 70,000 psi.
- 8.2 Elongation: 10 % minimum in 10"
- 8.3 Hardness: 40 – 65 Rockwell B Scale.
- 8.4 Bend Test: Material shall be able to be bent upon itself in any direction without cracking.

9.0 Packaging:

- 9.1 The galvanized coils will be furnished in compact coils reasonably symmetrical in shape and in good condition. Coils will be securely strapped to the pallet and separated by spacer blocks. Each individual coil will be banded to prevent shifting during shipment and unloading.
 - 9.1.1 Coil Inside Diameter: 14" +/- 3/8" (16" special run)
 - 9.1.2 Coil Outside Diameter: 26" to 34", normal aim 32" +/- 1"
 - 9.1.3 Coil Face Width: 6" to 6 7/8", normal aim 6 3/8" (8 7/8" Special Run)

10.0 Documentation:

- 10.1 No documentation is provided unless specified and agreed to in advance.

11.0 Approvals:

- 11.1 Revision Level: 4 5/3/03
- 11.2 Procedure revised by: Melissa Moore
- 11.3 Approvals:
 - Department Approval: Michael A. Miller
Plant Manager

 - Quality Systems Approval: Raymond A. Clausius
Quality Systems Manager