

ISO 11951:2016-03 (E)

Cold-reduced tinmill products - Blackplate

Contents		Page
Foreword		v
Introduction		vi
1	Scope	1
2	Normative references	1
3	Terms and definitions	1
4	General technical delivery condition	3
5	Classification	3
6	Information to be supplied by the purchaser	3
6.1	Designation	3
6.2	Mandatory information	4
6.3	Options	5
7	Manufacturing features	5
7.1	Manufacture	5
7.2	Annealing	5
7.3	Finish	5
7.4	Oiling	6
7.5	Imperfections	6
8	Mechanical properties	6
8.1	General	6
8.2	Hardness requirement	6
8.3	Tensile property requirement	6
9	Tolerances on dimensions and shape	7
9.1	General	7
9.2	Thickness and feather edge	7
9.2.1	Coil thickness	7
9.2.2	Feather edge	7
9.3	Coil width	7
9.4	Coil length	7
9.5	Edge camber of trimmed coils	7
9.6	Flatness	8
9.6.1	Edge wave	8
9.6.2	Longitudinal and transverse bow	8
9.6.3	Centre fullness	8
10	Joint within a coil	8
10.1	General	8
10.2	Number of joint	8
10.3	Location of joint	9
10.4	Dimension of joint	9
10.4.1	Thickness	9
10.4.2	Overlap	9

11	Sampling	9
12	Test method	10
12.1	Hardness test	10
12.1.1	Test piece	10
12.1.2	Test method	10
12.2	Tensile test	11
12.2.1	Test piece	11
12.2.2	Test method	11
12.3	Flatness test	11
12.3.1	General	11
12.3.2	Edge wave	11
12.3.3	Longitudinal or transverse bow	11
12.3.4	Centre fullness	12
13	Retests	13
14	Inspection document	14
15	Dispatch and packaging	14
15.1	Coil orientation	14
15.2	Labelling	14
	Annex A (normative) Hardness requirements for blackplate	15
	Annex B (normative) Tensile property requirements for blackplate	16
	Annex C (informative) Steel types	18
	Annex D (informative) Springback test for routine determination of proof strength for blackplate	19
	Annex E (normative) Rockwell HR15Tm values and their HR30Tm equivalents	20
	Bibliography	21