



Engineering Specification

Technical Specification For Peeling-Off The Steel
Bars

No : PSE 010.07
Yayın Tarihi : 08.11.2007
Bir Önceki Yayın Tarihi : 15.03.2006
Sayfa : 1 / 3

1.0 PURPOSE

This Technical Specification is prepared for determining the purchasing conditions and the delivery/packaging conditions of The Steel Bars which are peeled-off by SUB-CONTRACTING WORKS in the market.

2.0 THE DEFINITIONS

- 2.1 Peeling-Off :** This is a turning operation by chip removal for cleaning/removing off THE SURFACE DEFECTS developed during hot rolling operation of The Hot-Rolled Steel Bars.
- 2.2 Surface Quality :** This is surface roughness grade measured in microns on THE TURNED (Peeled-Off) SURFACE of peeled-off steel bars.
- 2.3 Total Stock Removal Depth :** This is the total depth of the material to be removed from the surface. This is expressed in millimeters (mm) as the depth of material removal on the radius.
- 2.4 Straightening :** This is the operation carried out on the peeled-off steel bars; for the purpose of eliminating bending/curvature of the peeled-off steel bars.
- 2.5 Surface Defects :** These are THE DEFECTS observed on the turned (peeled-off) surface of the peeled-off steel bars; such as notch, scratch, impact-indentation, crack, fissure, cutting (turning) TOOL-MARKS, unmachined surface etc.

3.0 THE TECHNICAL REQUIREMENTS

- 3.1 Surface Quality :** The Surface Quality on the peeled-off (turned) surface shall not exceed $R_a = 6,3$ micron.
- 3.1.1** The surface quality on the reeled/ straightened surface after peeling-off operation, shall not exceed $R_a=3.2$ micron
- 3.2 Total Stock Removal Depth :** The minimum Stock Removal Depths to be removed from the surface; are given in the below outlined chart, depending on the diameters of The Hot-Rolled Steel Bars :

Dağıtım : KLT, MUH, DVM, IHR, YST, LAB, UPL

Hazırlayan : F. ŞAHİN

Onay : Ö. ALPARTUN

Yetkili imzalar orijinal dosyada muhafaza edilmektedir. Elektronik ortamda imzasız geçerlidir.



Engineering Specification

Technical Specification For Peeling-Off The Steel
Bars

No : PSE 010.07
Yayın Tarihi : 08.11.2007
Bir Önceki Yayın Tarihi : 15.03.2006
Sayfa : 2 / 3

Konu :

Diameter of Hot-Rolled Steel Bar (mm)	Minimum Stock Removal Depth (mm)
Up to 12,70	0,40
12,70-25,40	0,60
25,40-50,80	0,90
50,80-63,50	1,10
63,50-88,90	1,50

3.3 Surface Defects : The Surface Defects mentioned in clause 2.5 are not allowed.

3.4 Run out : The Sample taken from the peeled-off steel bars, having 1000 mm sample length is checked for RUN OUT over 2 V- Blocks of the same height.
The Run out shall not exceed 0,6 mm.

3.5 Dimensions and Tolerances : The Dimensions and their tolerances to be obtained after peeling-off of the steel bars are given, in each order.

4 PACKAGING and DELIVERY

The Peeled-Off Steel Bars will be delivered in BUNDLES not exceeding 3000 kg weight, unless otherwise specified.

These Bundles will be tied firmly with 4 mm dia-Iron wires or steel strips (packaging strip) for assuring no loosening or no break-up of the bundle during handling storing and transportation.

In the bundle at least at 3 places THE REINFORCEMENTS OF THE WOODEN BILLETS of 100 x 100 mm cross section shall be placed to avoid bending / sagging of the peeled-off steel bars. (to maintain THE STRAIGHTNESS OF THE PEELED-OFF BARS).
THE STEEL TAGS of The Steel Maker shall be hanged on the bundling steel stripes.

Additionally The Company who carried our THE PEELING-OFF-WORKS, shall hang her own TAG. On these tags the following information shall be given :



Engineering Specification

No : PSE 010.07

Yayın Tarihi : 08.11.2007

Bir Önceki Yayın Tarihi : 15.03.2006

Konu : Technical Specification For Peeling-Off The Steel
Bars

Sayfa : 3 / 3

On The Steel Supplier's Tag	On The Tag of The PEELING-OFF Company
Name of The Company	Name of The Company
The Date	The Date
Steel Grade Nr.	Steel Grade Nr.
Heat Nr. Of that Steel Batch	Heat Nr. Of that Steel Batch
Bar Diameter	Bar Diameter
Bar Length	Bar Length
The Quantity	The Quantity