

5.4 COLD ROLLED CARBON STRIP STEEL

Product Description—Cold rolled carbon strip steel is a product wherein the maximum of the specified carbon range does not exceed 0.25 percent. It is produced in the following dimensional ranges:

Width, in	Thickness, in
Over 1/2 to 23 15/16 incl.	0.300 and under

TYPES OF EDGES

Many types of edges can be produced in cold rolled carbon strip steel. Over the years, the following types of edges have become recognized as those in most common use for the wide variety of applications for which cold rolled carbon strip steel is used.

No. 1 Edge is a prepared edge of a specified contour (round or square), which is produced when a very accurate width is required, or when an edge condition suitable for electroplating is required, or both. Applicable width tolerances are shown in Table 20.

No. 2 Edge is a natural mill edge carried through the cold rolling from the hot rolled strip without additional processing of the edge. Applicable width tolerances are shown in Table 21.

No. 3 Edge is an approximately square edge produced by slitting on which the burr is not eliminated. Applicable width tolerances are shown in Table 22. Normal coiling

Cold rolled carbon strip steel is customarily described by designating a specific edge, finish and temper. These designations and the additional requirements sometimes specified are described in the following paragraphs. The manufacturing methods used are described in Section 3.

Cold rolled carbon strip steel may be specified to ASTM A109/A109M, "Steel, Strip, Carbon, Cold-Rolled."

or piling does not necessarily provide a definite positioning of the slitting burr.

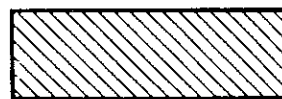
No. 4 Edge is a rounded edge produced by edge rolling either the natural edge of hot rolled strip or slit edge strip. This edge is produced when the width tolerance and edge condition are not as exacting as for No. 1 edge. Applicable width tolerances are shown in Table 20.

No. 5 Edge is an approximately square edge produced from slit edge material on which the burr is eliminated usually by rolling or filing. Applicable width tolerances are shown in Table 20.

No. 6 Edge is a square edge produced by edge rolling the natural edge of hot rolled strip or slit edge strip. This edge is produced when the width tolerance and edge condition are not as exacting as for No. 1 edge. Applicable width tolerances are shown in Table 20.

Schematic drawings are included to illustrate the typical edge descriptions. Actual edge profiles may vary from the illustrations.

**NO. 1 EDGE
(SQUARE)**
Broken Radial Corners



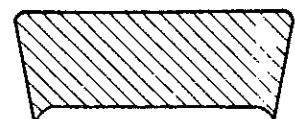
**NO. 1 EDGE
(ROUND)**
Radius approximately equal to 1/2 thickness



NO. 2 EDGE
Natural mill edge



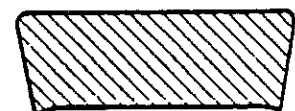
**NO. 3 EDGE
(SLIT)**
Approximately square



**NO. 4 EDGE
(ROUND)**
Rounded corners – may be flat with slitting fracture visible across the edge



NO. 5 EDGE
Approximately square
(No. 3 edge de-burred)



**NO. 6 EDGE
(SQUARE)**
Radial corners – may have slitting fracture visible across the edge

