



DILLIMAX TL

HIGH YIELD STRENGTH FINE GRAINED STRUCTURAL STEELS WITH CLOSE TOLERANCES ON DIMENSION AND SHAPE

Specification DH-E48-C Edition September 2010

DILLIMAX TL steel plates are delivered with very close tolerances on dimension and shape. These close tolerances are for example necessary for telescopic booms.

Product description

This specification can be specified for the following steel grades in addition to the DILLIMAX data sheets of DILLINGER HÜTTE GTS or EN 10025-6:

- DILLIMAX 690 B/T/E (S 690Q/QL/QL1 according to EN 10025-6)
- DILLIMAX 890 B/T/E (S 890Q/QL/QL1 according to EN 10025-6)
- DILLIMAX 965 B/T (S 960Q/QL according to EN 10025-6)
- DILLIMAX 965 E
- DILLIMAX 1100

The steel is designated as e.g. DILLIMAX 965 T TL or S 960 QL TL.

Other specifications may be possible on request.

DILLIMAX TL plates can be delivered in the following dimensions:

Plate thickness t [mm]	Width B [mm]	Length L [mm]
6 ≤ t < 8 ^{a)} (0.25 in. ≤ t < 0.30 in. ^{e)})	1000 ≤ B ≤ 2500 (39 in. ≤ B ≤ 98 in. ^{e)})	
8 ≤ t < 9,5 (0.30 in. ≤ t < 0.37 in. ^{e)})	1000 ≤ B ≤ 3200 ^{b)} (39 in. ≤ B ≤ 126 in. ^{e)})	2000 ≤ L ≤ 18000
9,5 ≤ t < 15 (0.37 in. ≤ t < 0.60 in. ^{e)})	1000 ≤ B ≤ 3300 ^{c)} (39 in. ≤ B ≤ 130 in. ^{e)})	(79 in. ≤ L ≤ 708 in.)
15 ≤ t ≤ 25 (0.60 in. ≤ t < 1.00 in. ^{e)})	1000 ≤ B ≤ 3300 ^{d)} (39 in. ≤ B ≤ 130 in. ^{e)})	

^{a)} DILLIMAX 1100 for t ≥ 8 mm (0.31 in.^{e)})

^{b)} 3050 (120 in.^{e)}) for DILLIMAX 890/965 and 2500 (98 in.^{e)}) for DILLIMAX 1100

^{c)} 2500 (98 in.^{e)}) for DILLIMAX 1100

^{d)} 3050 (120 in.^{e)}) for DILLIMAX 1100

^{e)} The values in US units are for information only.

General technical delivery requirements

Unless otherwise agreed, the general technical delivery requirements in accordance with EN 10021 apply.



Tolerances

Tolerances on nominal plate thickness

For TL plates, the very close thickness range Δ (upper value – lower value) is distributed as given in the following table. Other distributions of Δ e.g. as in EN 10029 can be agreed.

DILLIMAX TL		
Nominal thickness t [mm]	Lower limit of thickness [mm]	Upper limit of thickness [mm]
$6 \leq t < 16$ (0.25 in. $\leq t < 0.63$ in. ^{a)})	- 0,2 (0.008 in. ^{a)})	+ 0,4 (0.016 in. ^{a)})
$16 < t \leq 20$ (0.63 in. $\leq t < 0.80$ in. ^{a)})	- 0,3 (0.012 in. ^{a)})	+ 0,5 (0.020 in. ^{a)})
$20 < t \leq 25$ (0.80 in. $\leq t < 1.00$ in. ^{a)})	- 0,3 (0.012 in. ^{a)})	+ 0,8 (0.031 in. ^{a)})

a) The values in US units are for information only

The difference in thickness along the bending line (axis in rolling direction from tip to toe of a plate) does not exceed 0,3 mm (0.012 in.¹⁾).

Tolerances on width and length

Unless otherwise agreed, the tolerances will be in accordance with EN 10029.

Tolerances on flatness

The following tolerances on flatness apply:

- 3 mm / 1m (0.12 in. / 3.3 ft¹⁾) for a corrugation ≤ 1 m (≤ 3.3 ft¹⁾)
- 4 mm / 1m (0.16 in. / 3.3 ft¹⁾) for a corrugation $> 1 \leq 2$ m (> 3.3 ft ≤ 6.6 ft¹⁾)
- 5 mm / 2m (0.20 in. / 6.6 ft¹⁾) for a corrugation > 2 m (> 6.6 ft¹⁾)

A maximum of 2 ripples or corrugations per m (3.3 ft¹⁾) of plate length is allowed. A ripple or corrugation is defined as a flatness deviation > 1 mm (> 0.04 in.¹⁾). The flatness control is carried out on a flat support according to EN 10029 using a 1 m (3.3 ft¹⁾) - or 2 m (6.6 ft¹⁾) - levelling staff.

Surface quality

Unless otherwise agreed, the specification will be in accordance with EN 10163-2, class B2. Steel grid blasting and shop primer can be agreed.

Identification of plates

Unless otherwise agreed the marking is carried out via steel stamps with at least the following information:

- steel grade (e.g. DILLIMAX 965 T TL)
- heat number
- number of mother plate and individual plate
- the manufacturer's symbol
- inspector's sign

1) The values in US units are for information only.



General Note

If particular requirements are demanded and not covered in this data sheet, please contact us with the specifications for our review and agreement prior to ordering. The information in this data sheet is a product description. This data sheet is updated at occasion demands. The latest version is available from the mill or as download at www.dillinger.de.

Distribution

For your local representative
please contact our coordination office in Dillingen:

Telephone: +49 6831 47 22 23

Fax: +49 6831 47 33 50

or the internet:

<http://www.dillinger.de/dh/kontakt/weltweit/index.shtml.en>



DILLINGER HÜTTE GTS

AG der Dillinger Hüttenwerke
Postfach 1580
D-66748 Dillingen/Saar

e-mail: info@dillinger.biz
<http://www.dillinger.de>

Telephone: +49 6831 47-21 46
Fax: +49 6831 47-30 89