

CSP Production Guideline: Dimension

Table 1: Slab dimensions possible to be produced

Thickness (mm)	Width (mm) (2)		Length (mm)	
	Minimum	Maximum	Minimum	Maximum
220	1100	2300	6500	12500
250				
300				

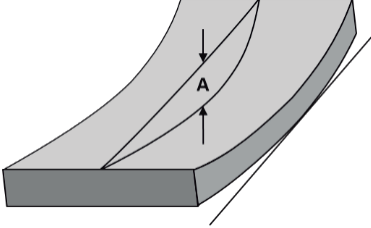
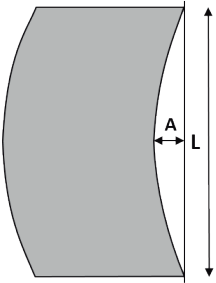
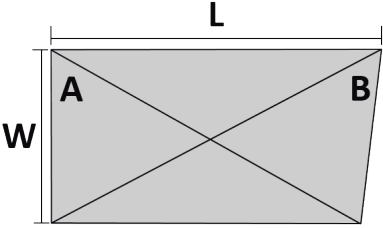
Notes:

- 1) Maximum weight must be 38 t.
- 2) The CSP capacity for width less than 1250 mm is 30% of the production.

Table 2: Dimensional tolerance	Minimum (mm)	Maximum (mm)
Thickness	-5	+5
Width	-20	+20
Length	-100	+100

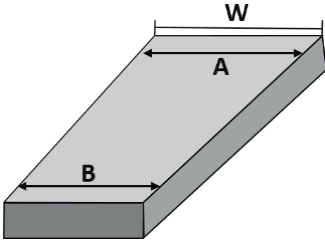
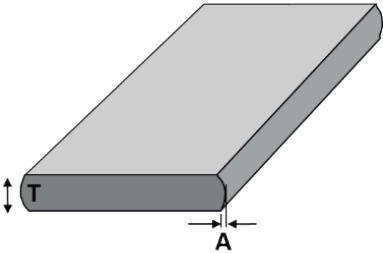
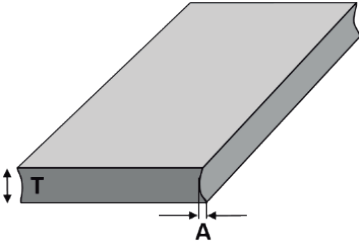
CSP Production Guideline: Shape and Surface

Table 3 (1/7): Shape and surface tolerance

Items	Legend	Tolerance
<p>Flatness</p> 	<p>A = Flatness</p>	<p>$A \leq 5 \text{ mm/m}$</p>
<p>Camber</p> 	<p>A = Camber L = Length</p>	<p>$A \leq 5 \text{ mm/m}$</p>
<p>Out of Square (diagonal difference)</p> 	<p>A = Largest diagonal B = Shortest diagonal W = Width L = Length DE = A – B DE = Out of square</p>	<p>$DE \leq (1\% \times L) \text{ mm}$</p>

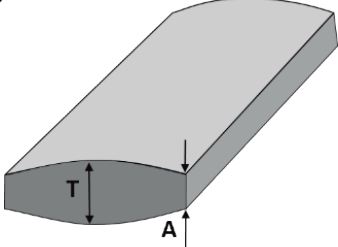
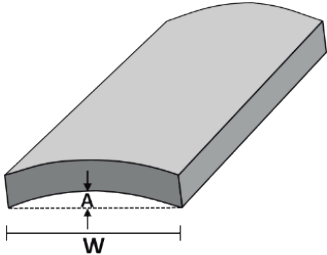
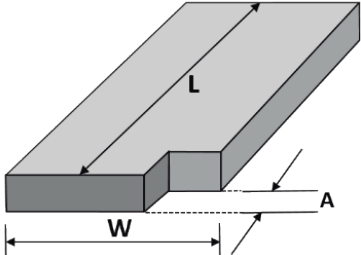
CSP Production Guideline: Shape and Surface

Table 3 (2/7): Shape and surface tolerance

Items	Legend	Tolerance
<p>Taper</p> 	<p>A = Largest width B = Shortest width W = Width Taper = A – B</p>	<p>$A - B \leq 25 \text{ mm}$</p>
<p>Convexity</p> 	<p>T=Thickness A= Convexity</p>	<p>$A \leq 10 \text{ mm}$</p>
<p>Concavity</p> 	<p>T = Thickness A = Concavity</p>	<p>$A \leq 10 \text{ mm}$</p>

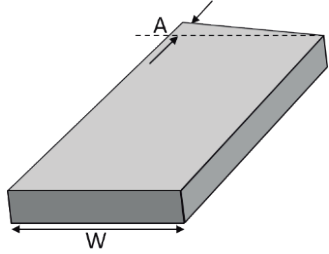
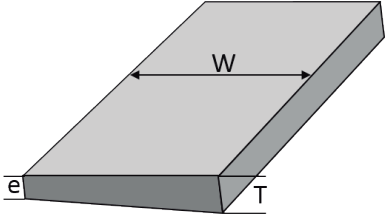
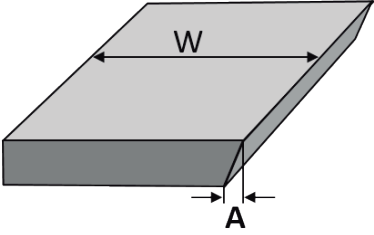
CSP Production Guideline: Shape and Surface

Table 3 (3/7): Shape and surface tolerance

Items	Legend	Tolerance
<p>Bulging on wide faces</p> 	<p>T = Bigger thickness A = Smaller thickness</p>	<p>$T - A < 5\text{mm}$</p>
<p>Concavity on wide faces</p> 	<p>A = Concavity W = Width</p>	<p>$A \leq 5\text{ mm}$</p>
<p>Cut Deviation</p> 	<p>L = Length W = Width A = Cut deviation</p>	<p>$A \leq 12,7\text{ mm}$</p>

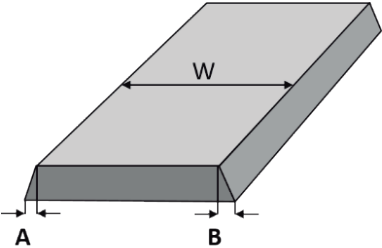
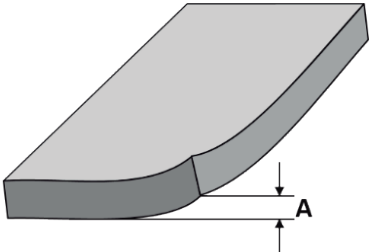
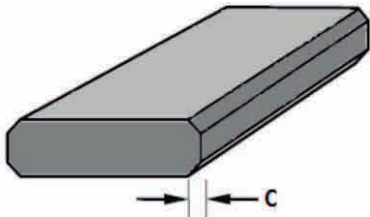
CSP Production Guideline: Shape and Surface

Table 3 (4/7): Shape and surface tolerance

Items	Legend	Tolerance
<p>Out of square</p> 	<p>A = Out of square W = Width</p>	<p>$A \leq (1,5\% \times L)$</p>
<p>Wedge</p> 	<p>T = Thicker thickness e = Thinner thickness W = Width Wedge = T - e</p>	<p>$T - e \leq 4 \text{ mm}$</p>
<p>Vertical cut out of square</p> 	<p>A = Vertical cut out of square W = Width</p>	<p>$A \leq 10 \text{ mm}$</p>

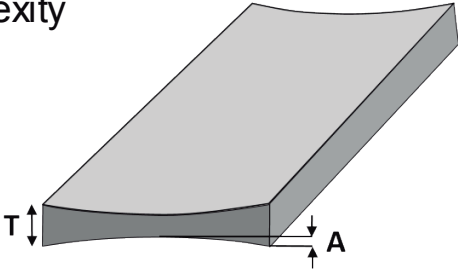
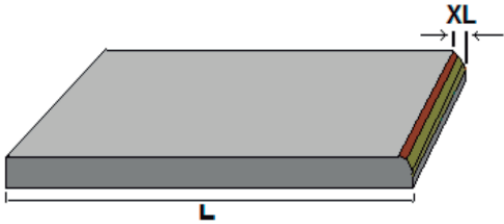
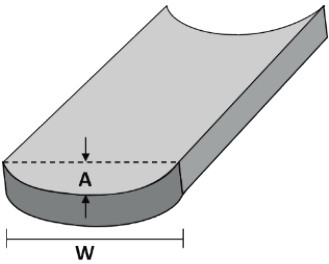
CSP Production Guideline: Shape and Surface

Table 3 (5/7): Shape and surface tolerance

Items	Legend	Tolerance
<p>Trapezoid</p>  <p>The diagram shows a 3D perspective of a trapezoidal slab. A horizontal double-headed arrow across the top surface is labeled 'W'. At the front-left and front-right corners, there are small horizontal double-headed arrows pointing inward, labeled 'A' and 'B' respectively, indicating the width of the chamfered corners.</p>	<p>A and B = Trapezoid W = Width</p>	<p>$A \text{ and } B \leq 10 \text{ mm}$ (each side)</p>
<p>Torsion (twist)</p>  <p>The diagram shows a 3D perspective of a slab that is twisted. A vertical double-headed arrow at the right end is labeled 'A', indicating the vertical displacement between the top and bottom surfaces, representing the longitudinal rotation.</p>	<p>A = Longitude rotation</p>	<p>$A \leq 5 \text{ mm}$</p>
<p>Corner</p>  <p>The diagram shows a 3D perspective of a rectangular slab with chamfered corners. A horizontal double-headed arrow at the bottom front corner is labeled 'C', indicating the width of the chamfered corner.</p>	<p>C = Corner width</p>	<p>$C \leq 10 \text{ mm}$ (for not scarfed slabs)</p>

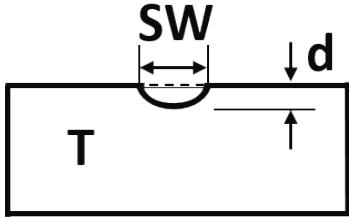
CSP Production Guideline: Shape and Surface

Table 3 (6/7): Shape and surface tolerance

Items	Legend	Tolerance
<p>Face Convexity</p> 	<p>T = Thickness A = Face concavity</p>	<p>$A \leq 5 \text{ mm}$</p>
<p>Irregularity of the extremity</p> 	<p>XL= Irregularity of the extremity L = Length</p>	<p>$XL \leq 10 \text{ mm}$</p>
<p>Convexity on wide faces</p> 	<p>W = Width A = Convexity</p>	<p>$\leq 5 \text{ mm}$</p>

CSP Production Guideline: Shape and Surface

Table 3 (6/7): Shape and surface tolerance

Items	Legend	Tolerance
<p>Scarfing Width and Pass Deep</p>  <p>The diagram shows a rectangular plate of thickness 'T'. A semi-circular scarfing pass is shown on the top surface. The width of the pass is labeled 'SW' with a double-headed arrow. The depth of the pass is labeled 'd' with a downward arrow. The thickness of the plate is labeled 'T' with an upward arrow.</p>	<p>Sw = Width scarfing pass</p> <p>d = Depth scarfing</p> <p>T = Thickness</p>	<p>$d \leq (0,06 \times E)$</p> <p>$Sw \geq 6 \times PP$</p>

CSP Production Guideline: Weight

Table 5: Slab weight acceptance for 220 mm of thickness

Length (mm)	Width (mm)	1100 - 1750	1800	1850	1900	1950	2000	2050	2100	2150	2200	2250	2300
		6500 - 9600	<div style="text-align: center;"> <p>Dimensions accepted (weight ≤ 38 t)</p> <p>Dimensions not accepted (weight > 38 t)</p> </div>										
9601 - 9800													
9801 - 10000													
10001 - 10200													
10201 - 10500													
10501 - 10700													
10701 - 11000													
11101 - 11300													
11301 - 11600													
11601 - 11900													
11901 - 12000													
12001 - 12500													

CSP Production Guideline: Weight

Table 6: Slab weight acceptance for 250 mm of thickness

Length (mm) \ Width (mm)	Width (mm)																
	1100 - 1550	1600	1650	1700	1750	1800	1850	1900	1950	2000	2050	2100	2150	2200	2250	2300	
6500 - 8400	<div style="text-align: center;"> <p>Dimensions accepted (weight ≤ 38 t)</p> <p>Dimensions not accepted (weight > 38 t)</p> </div>																
8401 - 8500																	
8601 - 8800																	
8801 - 9000																	
9001 - 9200																	
9201 - 9500																	
9501 - 9700																	
9701 - 9900																	
9901 - 10200																	
10201 - 10500																	
10501 - 10800																	
10801 - 11100																	
11101 - 11400																	
11401 - 11800																	
11801 - 12000																	
12001 - 12500																	

CSP Production Guideline: Weight

Table 7: Slab weight acceptance for 300 mm of thickness

Length (mm) \ Width (mm)	Width (mm)																							
	1100-1250	1300	1350	1400	1450	1500	1550	1600	1650	1700	1750	1800	1850	1900	1950	2000	2050	2100	2150	2200	2250	2300		
6500 - 7000	<div style="text-align: center;"> <p>Dimensions accepted (weight ≤ 38 t)</p> <p>Dimensions not accepted (weight > 38 t)</p> </div>																							
7001 - 7200																								
7201 - 7300																								
7301 - 7500																								
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