

Amendment 3 to IS 5522

Hindi title will be added later

बर्तनों के लिए स्टेनलेस इस्पात प्लेट, चद्रे और पत्तियाँ — विशिष्टि

(*First cover page and Page 1, English title*) — Substitute ‘Stainless Steel Plate, Sheet and Strip for Utensils and Kitchen ware — Specification’ for ‘Stainless Steel Sheets and Strips for Utensils — Specification’

(*Page 1, clause 1*) — Substitute the clause with following:

‘1.2 This standard covers the requirements for stainless steel in the form of plates, sheets and strips for manufacture of utensils, kitchen ware and portable stainless steel flasks/bottles.’

(*Page 1, clause 4*) — Insert the following new clauses and re number the subsequent clauses:

‘4.1 General requirements related to the supply of material shall conform to IS 8910.

4.2 Steels covered by the standard shall be ordered and delivered on the basis of the following:

- a) Chemical composition only (Hot-rolled steels)
- b) Chemical composition and Mechanical Properties in the annealed condition.
- c) Chemical composition and Mechanical properties in any other condition as agreed to between the purchaser and the supplier.

4.3 Information to be given by the purchaser

4.3.1 Basis for Order

While placing an order for the purchase of material covered by this standard, the purchaser should specify the following:

- a) Grade designation
- b) Form (plate, sheet or strip);
- c) Nominal dimensions — Thickness, width and length (for cut length)
- d) Condition (hot rolled, cold rolled, annealed or any other treatment)
- e) Surface Finish(see 11)
- f) Edge condition(see 10.2)
- g) Method of manufacture, if any specified.

4.4 Unless otherwise agreed to between the purchaser and the supplier, the material shall be supplied in annealed condition.’

(*Page 1, Clause 7.3*) — Insert the following new clauses:

‘7.3 Limits of lead and cadmium shall be mentioned and shall be tested.

7.4 Isotopes of Cobalt and other radioactive elements shall not be present. Testing shall be as agreed to between the manufacturer and purchaser.’

(*Page 2, Table 3*) — Insert the foot note as ‘for conditions other than those mentioned in Table-3, the mechanical properties shall be mutually agreed to between the purchaser and the seller’.

(*Page 3, clause 9*) — Substitute the following for the existing:

‘9 DIMENSIONS

Unless otherwise agreed to between the manufacturer and the purchase, dimensions of plate, sheet and strip shall be as follows:

Thickness : 0.20 mm - 50 mm

Width : upto 2000 mm

Length : As per mutual agreement between the purchaser and the manufacturer at the time of enquiry and order.’

(Page 3, clause 10.1) — Substitute the following for the existing:

‘Permissible variation in thickness for Hot rolled product shall be as per Table 5a and Cold rolled product shall be as per Table 5b.’

(Page 3, Table 5) — Substitute the following for the existing Table 5a:

**‘Table 5(a) Permissible Variations in Thickness for Hot Rolled Product
(Clause10.1)**

All dimensions in millimeters

| SI No. | Thickness | Tolerance on Thickness for Width | | | |
|--------|-----------------|----------------------------------|----------------|----------------|----------------|
| | | < 1000 | 1000 to < 1250 | 1250 to < 1600 | 1600 to ≤ 2000 |
| (1) | (2) | (3) | (4) | (5) | (6) |
| i) | 1.00 to <1.50 | ±0.15 | ±0.15 | ±0.20 | ±0.25 |
| ii) | 1.50 to <2.00 | ±0.20 | ±0.20 | ±0.25 | ±0.30 |
| iii) | 2.00 to <2.50 | ±0.20 | ±0.25 | ±0.30 | ±0.35 |
| iv) | 2.50 to <3.00 | ±0.25 | ±0.30 | ±0.30 | ±0.40 |
| v) | 3.00 to <4.00 | ±0.30 | ±0.30 | ±0.35 | ±0.45 |
| vi) | 4.00 to <5.00 | ±0.40 | ±0.40 | ±0.45 | ±0.60 |
| vii) | 5.00 to <6.00 | ±0.50 | ±0.50 | ±0.55 | ±0.70 |
| viii) | 6.00 to <8.00 | ±0.60 | ±0.60 | ±0.60 | ±0.75 |
| ix) | 8.00 to <10.00 | ±0.65 | ±0.65 | ±0.65 | ±0.80 |
| x) | 10.00 to <16.00 | ±0.70 | ±0.70 | ±0.70 | ±0.85 |
| xi) | 16.00 to <25.00 | ±0.80 | ±0.80 | ±0.80 | ±0.95 |
| xii) | 25.00 to <40.00 | ±0.90 | ±0.90 | ±0.90 | ±1.10 |
| xiii) | 40.00 to <50.00 | ±1.00 | ±1.00 | ±1.00 | ±1.20 |

NOTES

1 Thickness measurements are taken at least 15 mm from the edge of the product in case of trimmed edges atleast 25 mm from the edge of the product in case of mill edge.

2 For Width > 2000mm, tolerances on thickness shall be agreed to between the purchaser and the manufacturer/the seller.

3 For thickness \geq 50 mm, tolerances on thickness shall be agreed to between the purchaser and the manufacturer/the seller.

4 In case of wide strip of hot rolled coils, the specified values for tolerances shall not apply to mill edge of the coil for total length (l). Which is calculated using the formula $l(m) = 90/\text{nominal thickness}$ in mm, with maximum total length (both ends) of 20 m per coil.'

(Page 3, clause 10.1) — Insert the new table 5b for permissible variations in thickness for Cold rolled product

**‘Table 5(b) Permissible Variations in Thickness for Cold Rolled Product
(Clause 10.1)**

All dimensions in millimeters

| SI No. | Thickness | Tolerance on Thickness for Width | | | |
|--------|---------------|----------------------------------|----------------|----------------|---------------------|
| | | < 1000 | 1000 to < 1250 | 1250 to < 1600 | 1600 to \leq 2000 |
| (1) | (2) | (3) | (4) | (5) | (6) |
| i) | 0.20 to <0.30 | ± 0.04 | ± 0.04 | — | — |
| ii) | 0.30 to <0.40 | ± 0.05 | ± 0.05 | ± 0.05 | — |
| iii) | 0.40 to <0.60 | ± 0.08 | ± 0.08 | ± 0.08 | — |
| iv) | 0.60 to <0.80 | ± 0.10 | ± 0.10 | ± 0.10 | — |
| v) | 0.80 to <1.25 | ± 0.12 | ± 0.15 | ± 0.15 | ± 0.15 |
| vi) | 1.25 to <1.50 | ± 0.13 | ± 0.15 | ± 0.20 | ± 0.20 |
| vii) | 1.50 to <2.00 | ± 0.20 | ± 0.20 | ± 0.25 | ± 0.30 |
| viii) | 2.00 to <2.50 | ± 0.20 | ± 0.25 | ± 0.30 | ± 0.35 |
| ix) | 2.50 to <3.00 | ± 0.25 | ± 0.30 | ± 0.30 | ± 0.40 |
| x) | 3.00 to <4.00 | ± 0.30 | ± 0.30 | ± 0.35 | ± 0.45 |
| xi) | 4.00 to <5.00 | ± 0.40 | ± 0.40 | ± 0.45 | ± 0.60 |
| xii) | 5.00 to <6.00 | ± 0.50 | ± 0.50 | ± 0.55 | ± 0.70 |
| xiii) | 6.00 | ± 0.60 | ± 0.60 | ± 0.60 | ± 0.75 |

Notes

1 Thickness measurements are taken at least 15 mm from the edge of the product for trimmed edges and at least 25 mm from the edge for mill edges.

2 For Width>2000mm, tolerances on thickness shall be agreed to between the purchaser and the manufacturer/the seller

3 For thickness of above 6mm, tolerances shall be agreed upon between the purchaser and the manufacturer/seller.’

(Page 3, clause 10.2.2) — Substitute the following for the existing:

‘10.2.2 Cold rolled and hot rolled product in trimmer edge shall have width tolerance as given in Table 7a and Table 7b.’

(Page 4, Table 7a) — Substitute the following for the existing Table 7:

Table 7a Permissible Variations in Width for Trimmed Edge Cold Rolled Product for Cold Rolled Strip in Coils and Cut Lengths

(Clause 10.2.2)

All dimensions in millimeters

| Sr. No. | Thickness | Tolerance on Width | | | | |
|---------|---------------------|--------------------|-------------|--------------|---------------|----------------|
| | | <250 | 250 to <500 | 500 to <1000 | 1000 to <1250 | 1250 to ≤ 2000 |
| (1) | (2) | (3) | (4) | (5) | (6) | (7) |
| 1 | <0.6 | ±0.20 | ±0.30 | ±0.50 | ±1.00 | ±1.00 |
| 2 | From 0.6 to < 1.00 | ±0.25 | ±0.30 | ±0.50 | ±1.00 | ±1.00 |
| 3 | From 1.00 to < 1.50 | ±0.30 | ±0.40 | ±0.60 | ±1.20 | ±1.20 |
| 4 | From 1.50 to < 2.50 | ±0.40 | ±0.50 | ±0.70 | ±1.40 | ±1.40 |
| 5 | From 2.50 to < 4.00 | ±0.40 | ±0.50 | ±0.80 | ±1.60 | ±1.60 |
| 6 | From 4.00 to < 5.00 | ±0.50 | ±0.70 | ±1.00 | ±2.00 | ±2.00 |

NOTES

1 For thicknesses of 5m and above, tolerances shall be agreed to between the purchaser and the manufacturer/the seller.

2 For Width>2000mm, tolerances on width shall be agreed to between the purchaser and the manufacturer/the seller.’

(Page 3, clause 10.2) — Insert the new table 7b for permissible variations in width for trimmed edge hot rolled product

Table 7b Permissible Variations in Width for Trimmed Edge Hot Rolled Product

(Clause 10.2.2)

All dimensions in millimeters

| SI No. | Width | Tolerance on Width | |
|--------|-------|--------------------|-------|
| | | Plus | Minus |

| (1) | (2) | (3) | (4) |
|-----|--------|-----|-----|
| 1 | ≤ 2000 | 5 | 0 |

Note: For Width > 2000mm, tolerances on width shall be agreed to between the purchaser and the manufacturer/the seller'

(Page 4, Table 8) — Substitute the following for the existing Table 8:

Table 8 Permissible Variations in Length of Hot Rolled or Cold Rolled specified Lengths

(Clause 10.3)

| Length (mm) (1) | Tolerance (mm) (2) |
|-----------------------------|--------------------------|
| For all thickness and width | +10 -0' |