

SINGLE-BILL SERVICE OFFER MANUAL



This issue supersedes all previous issues

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INTRODUCTION TO STEELSCAPE

Welcome to Steelscape. To make doing business with us easy and hassle-free, we developed this manual as a resource. It will explain our product and service offers, highlighting all available options. You can reference how to most effectively place an order with Steelscape, selecting the appropriate packaging, shipping and storage options. You can also reference our billing and claims policies, as necessary. We have documented product capabilities and ASTM specifications.

This manual is not all-encompassing and is subject to amendment. However, your basic questions should be answered fully and accurately. Any information not addressed can be quickly answered by contacting the appropriate Steelscape Customer Service Representative by calling 1-888-285-7717.

Please distribute the information presented within this manual to appropriate departments and people within your company. For example, section 7 should be forwarded to your accounting or payables area and so on.

Steelscape's Single-Bill Service Offer Manual will be updated as the information found within is refined and developed. The updated manual will be reviewed annually. To ensure your version of this manual is as current as possible please reference the footer information at the bottom of the page. The footer will display the version number and release date of the Service Offer Manual in your possession. Should your version be outdated, please contact your Steelscape Sales Representative or our Marketing Department for the most up-to-date version.

We hope this information proves useful in answering your questions. We welcome any feedback you may have on the layout or content.

We know you have many options when selecting your suppliers and we appreciate your business. All of us at Steelscape look forward to working with you to fulfill your coated steel needs.

[CLICK HERE FOR THE STEELSCAPE TERMS & CONDITIONS](#)

STEELSCAPE'S VISION, MISSION & VALUES

Our Shared Vision...

Inspire, strengthen and beautify our communities through color and imagery on metal.

Our Shared Mission...

Deliver unique value via innovative and robust product solutions, superior customer experience, and the best team in the industry.

Our Shared Values...

Integrity: Doing what we say we'll do.

High Performance: Achieving superior results and stretching our capabilities.

Courage to Lead Change: Inspiring and delivering change even in the face of adversity.

Respect for Each Other: Valuing diversity and recognizing our interdependencies.

Safety and the Environment: Commitment to safety, health & environmental responsibilities.

OUR BOND

We and our customers proudly bring inspiration, strength and color to communities with Steelscape steel.

Our customers are our partners.

Our success depends on our customers and suppliers choosing us. Our strength lies in working closely with them to create value and trust, together with superior products, service and ideas.

Our people are our strength.

Our success comes from our people. We work in a safe and satisfying environment. We choose to treat each other with trust and respect and maintain a healthy balance between work and family life. Our experience, teamwork and ability to deliver steel inspired solutions are our most valued and rewarded strengths.

Our shareholders are our foundations.

Our success is made possible by the shareholders and lenders who choose to invest in us. In return, we commit to continuing profitability and growth in value, which together, make us all stronger.

Our communities are our homes.

Our success relies on communities supporting our business and products. In turn, we care for the environment, create wealth, respect local values and encourage involvement. Our strength is in choosing to do what is right.

STEELSCAPE CONTACTS

To ensure you have the best possible access to our staff, please visit our website at www.steelscape.com. Most departments and contacts associated with your account will be listed under the [Contacts and Locations](#) page.

For product inquiries or project assistance call (888) 553-5521.

For account management support and customer service call (888) 285-7717.

If you need assistance identifying product partners in your area, use the [WHERE TO BUY](#) contact form on our website to contact us. Alternatively, inquire with your local metal product manufacturer, roofing contractor, or building product distributor if they use genuine Steelscape steel.

STEELSCAPE LOCATIONS

Steelscape operates two facilities in Kalama, Washington and Rancho Cucamonga, California. Strategically located near major transportation hubs for both truck and rail, this assures that our customers get fast, reliable deliveries throughout the United States and Canada.

Kalama, Washington

222 West Kalama River Road, Kalama, WA
98625-9420, USA

Rancho Cucamonga, California

11200 Arrow Route, Rancho Cucamonga, CA
91730-4805, USA

ORDER PROCESSING

Purchase Order Requirements*

To process your order more efficiently, we require the following information when receiving your order:

Criteria	Options (If Applicable)
Ship-to Address	NA if customer will call
Mode of Transportation	(Truck or Rail)
Customer Purchase Order No.	
Total Quantity Ordered	(Pounds and/or Lineal Feet)
Metallic-Coating Type	(ZINCALUME® or TruZinc® Steel)**
Resin Coating	(Yes/No)
Metal Grade	(33, 37, 40, 50CL1, 50CL2, 50CL4, 57, 80CL1, CSA, CSB)
Coating Weight	(G30, G40, G60, G90, G100, AZ35, AZ50, AZ55)
Thickness	(Base Metal Thickness or Total Coated Thickness)
Thickness Tolerance	(Full Thickness Tolerance - See Section 4.5)
Width Tolerance	(Standard or Slit Tolerance)
Output Width	(Min)
Skin Passed	(Yes/No)
End Use	
Chem. Treat	(Yes/No)
RoHS Compliant	(Yes/No)
Oil	(None/Light/Medium) (Heavy upon request & approval)
Branding	(Yes/No)
Coil Inside Diameter (ID)	(20")
Coil Weight Minimum	(Min must be no greater than 50% of max for painted and 75% for bare)
Coil Weight Maximum	
Skid Weight Maximum	
Packaging Preference	
Steelscape to Paint	(Yes/No)
Steelscape to Slit	(Yes/No)
Steelscape to Emboss	(Yes/No)
Emboss Type & Depth	(Non-directional Stucco 0.007" to 0.010")
Steelscape to CTL	(Yes/No)
Flat Sheet Length	36"-144"
Flat Sheet Plastic Film Required	(Yes/No)
Customer to Paint	(Yes/No)
Requested Ship Date	
Paint Details-Top & Bottom Primer/Backer	(Topcoat Mills, Top/Bottom Primer Mills, Backer Mills)
Paint Details-Top & Bottom Paint Color	(Paint Code with Color Description and Paint System)
Unit Pricing	(Per CWT or Pounds and TWM or Actual) (Note: Freight always calculated on actual weight)
Quote Number Used for Pricing	

* If your order needs to comply with any special building requirements, you will need to include that information on your purchase order provided to Steelscape. This includes requirements to meet the Buy American Act (BAA), Surface Transportation Assistance Act (STAA), American Recovery and Reinvestment Act (ARRA), various Buy America requirements, domestic and/or melted and poured requirements, or recycled-content requirements.

** If you are ordering any of Steelscape's custom branded products, you will need to include that information on your purchase order as well. This includes Vintage®, ReziBond®, TruzGuard®, Spectrascape®, and Steelscape Prints®.

Lead Times & Releases

Steelscape will make every attempt to satisfy the customer order request date. Availability of materials - substrate and paint - in addition to line time availability will determine Steelscape's ability to meet the request date. Every order will reflect the customer order requested ship date as well as the Steelscape Acknowledged Date.

To help our customers better understand Steelscape's order entry process as it relates to lead times we offer the following order practices:

1. Steelscape requires 48 hours to arrange trucking. Orders requiring shipment should be released a minimum of 48 hours prior to the required shipping date.
2. Our delivery time is measured by the Acknowledged Production Date of the order and does not include the transportation time or mode used to deliver the product from our facility to the customer's final destination. Providing a release date when placing an order will help ensure the added time for transportation is minimal.

Order Acknowledgments

Upon receipt and entry of an order into the Steelscape production system, the customer will be provided an Order Acknowledgment. The acknowledgment will contain all specifications related to the order and should be reviewed to ensure accuracy. Any discrepancies must be brought to your Customer Service Representative's attention immediately. Order Acknowledgments will be sent for all orders unless requested otherwise in writing from the customer to the appropriate Steelscape Customer Service Representative.

Change Requests

We realize sometimes an initial order will need to be altered. Recognizing that potential need, we have established the following guidelines to help customers understand our change policy for existing orders.

1. Any changes to an existing order must be submitted in writing to the Customer Service Representative (CSR).
2. The CSR will initiate the change in Steelscape's system by obtaining approval from all appropriate departments, as determined by the type of change requested. Each request will be reviewed within twenty-four (24) hours. However, it may take up to one (1) business day to determine acceptance or refusal of the requested change.
3. Approval of changes will depend on the type of change requested and the status of order (i.e. where the order is in-process, lead time guarantee, etc.)
4. Orders approved for change will be revised per the customer request.

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5. Customers will be notified of the outcomes for all changes requested.

Allowable changes include:

- Substrate
- Coating Weight
- Width
- Quantity*
- Lead Time
- Price
- Cut To Length (CTL)
- Purchase Order No.
- Customer Part No.(s)
- Min/Max Coil Weights
- Packaging Instructions
- Paint Color*
- Paint Thickness*
- Grade*
- Decimal Thickness*
- End-Use
- Ship-To
- Ship Mode
- Slitting/Embossing Instructions

* Some restrictions apply to amending these items. Consult Steelscape Customer Service with any questions or concerns.

Amending an order may result in resetting of the Acknowledged Date. Upon amendment approval, a revised order acknowledgment will be reprinted and be sent to the customer.

Any further questions regarding Steelscape's order change policy can be directed to the Customer Service Department.

Thickness Tolerances

Full Restricted Tolerances - 1" Minimum Edge Distance

	Thickness (Inches)	
Width (Inches)	.010 - .023	>.023 - .045
MINIMUM	Minimum Tolerances - All Plus	
> 0 - 32	0.003	0.004
> 32 - 40	0.003	0.004
> 40 - 54	0.003	0.004
NOMINAL	Nominal Tolerances - Plus and Minus	
> 0 - 32	0.002	0.002
> 32 - 40	0.002	0.002
> 40 - 54	0.002	0.002

Thickness is measured on the coated sheet and includes the metallic-coating thickness. Thickness is measured at any point on the sheet not less than 1 inch from a side edge, per ASTM 924-22a, Table 2.

Customers should inquire about any application requiring improved (tighter) tolerances for performance reasons.

PRICING

All pricing is per current (most recent) quote and is price in effect at the time of acknowledgment*, including all add-ons and deductions. All applicable price changes will be communicated to the customer by the Account Manager and/or Customer Service Representative.

Any pricing disputes or discrepancies should be reported to the Steelscape Account Manager or Customer Service Representative for resolution upon receipt of Order Acknowledgment. Shipments are F.O.B. the Steelscape facility. Steelscape is not liable for any transportation costs unless mutually agreed to in writing prior to the material shipment.

Actual weight pricing will be applied on the finished material weight and will include applied coating weight. TMW pricing is available upon approval.

Price quotations are subject to change and will be communicated to the customer by their Steelscape Account Manager.

- * Pricing may be based on shipment date if agreed upon and noted on final quote for the order.

CREDIT & PAYMENT TERMS

Steelscape is happy to accept payments on a net 30 day basis. However, Steelscape also offers a 0.5% discount for early payment of invoices. The discount is applicable to materials value only and does not include freight. Your invoice will clearly indicate the correct amount to discount on each page and as a total for the entire invoice. This offer is consistent with industry payment terms.

Customer invoices may be discounted 0.5% if paid within 10 days of the invoice date. Steelscape will permit discount if payment is postmarked on or before the 10th day, as appropriate. In the event that the discount dates fall on a weekend or national holiday the next working day will be allowed. Full payment of invoices is expected within 30 days of the invoice date.

Steelscape is prepared to receive payments by ACH or wire transfer. The Steelscape Credit/AR Department can provide details and bank routing information.

Steelscape charges for late payments on invoices not paid within terms. The late payment charge is described on the credit application and on the Steelscape Terms and Conditions of Sale. Allowing a grace period of 30 days, Steelscape will assess a 1.5% charge each month to all unpaid invoices 60 days from invoice date and beyond.

The customer will not delay payment or withhold (short-pay) for claims or related problems until the issue is resolved to the satisfaction of both parties.

All shipments are subject to prior approval by the Steelscape Credit Department.

DOWNLOADS

Steelscape Terms & Conditions of Sale [PDF](#)

Credit Application & Agreement [PDF](#)

ZINCALUME® STEEL

ZINCALUME is Steelscape's trade name for Galvalume® Steel and is manufactured in our Rancho Cucamonga, CA facility. This 55%/45% aluminum-zinc metallic coating offers two to four times the corrosion resistance of regular galvanized steel and carries a limited corrosion warranty. [Click to view warranty](#).

ZINCALUME Grade Data Sheets can be found in Appendix A. They describe in detail each of our products' performance and composition characteristics. Typical dimensions, mechanical properties and supply conditions are described for each product by steel grade and metal type.

An SDS for both the bare and resin-coated versions of our ZINCALUME Steel can be found in the [Document Library at www.Steelscape.com](#).

The ZINCALUME Technical Bulletins provide helpful information regarding proper use, installation and maintenance of ZINCALUME Steel. There are currently fourteen bulletins covering a wide range of topics that serve as an invaluable tool to both the veteran user and/or first time buyer of ZINCALUME. [These bulletins can be found by clicking here.](#)

ZINCALUME® Steel Processing Capabilities

The matrix below was designed to help you determine the ZINCALUME® Steel products Steelscape is capable of producing on a consistent basis. These capabilities grow and change with each new successful trial order we process to completion. As we become more proficient in producing product outside the stated capacity limits we will expand this matrix accordingly.

	Rancho
Max Input Coil Wt	55,000 #
Max Output Coil Wt	38,000 #*
Thickness	0.0120" - 0.0356"***
Width	28" - 50"***
Coatings	ZINCALUME®/Resin/Oil/ Passivant (Standard or RoHS Compliant)
Entry OD/ID	79" max/20" +/- 0.25"
Delivery OD/ID	76" max/20" +/- 0.25"
Cores	Not Available
Coatings	AZ35, AZ50, AZ55, AZ60****

* ZINCALUME Plus max output weight 20,000 lbs horizontal and 15,000 lbs vertical.

** Width restrictions may apply on less than 0.0157" total coated thickness. 0.0300" thickness and greater is considered non-surface critical for some product grades and end-uses, both bare and painted. Inquire with a Steelscape Sales Representative for additional information.

*** For widths outside of this range. Inquire with a Steelscape Sales Representative.

****For heavier coating weights, inquire with a Steelscape Sales Representative.

Steelscape is happy to evaluate requests for ZINCALUME® Steel products not shown on the capability matrix above. Equipment capabilities and hot band supply may impact our production capabilities. Questions regarding ZINCALUME Steel processing capabilities should be directed to a Steelscape Sales Representative.

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TRUZINC® STEEL

TruZinc is Steelscape's hot dipped galvanized steel product and manufactured in our Kalama, WA facility.

TruZinc Grade Data Sheets can be found in Appendix B. These sheets describe, in detail, each of our products' performance and composition characteristics. Typical dimensions, mechanical properties and supply conditions are described for each product.

An SDS for both the bare and resin-coated versions of our TruZinc Steel product, [which can be found on www.Steelscape.com](http://www.Steelscape.com) by clicking [here](#).

A Technical Bulletin providing helpful information regarding proper use, installation and maintenance of TruZinc Plus Steel is [located on www.Steelscape.com](#) or by clicking [here](#).

Important application and handling information is described in this bulletin. The fit-for-purpose tips are also an excellent technical reference.

This section will serve as an invaluable tool to both veteran users and first time buyers of TruZinc Steel.

TruZinc® Steel Processing Capabilities

The matrix below was designed to help you determine the TruZinc® Steel products Steelscape is capable of producing on a consistent basis. These capabilities grow and change with each new successful trial order we process to completion. As we become more proficient in producing product outside the stated capacity limits we will expand this matrix accordingly.

	Kalama
Max Input Coil Wt	56,000 #
Max Output Coil Wt	56,000 #*
Thickness	0.0120" - 0.0470"^^
Width	28" - 51"***
Coatings	TruZinc/Resin/Oil/Acrylic Single-Coat Paint/Passivate***
Entry OD/ID	79.5" max/20" +/- 0.5"
Delivery OD/ID	79.5" max/20" +/- 0.5"
Cores	Not Available
Coatings	G30, G40, G60, G90, G100, G115, G125****

^ 0.300" thickness and greater is considered non-surface critical for some product grades and end-uses, both bare and painted. Inquire with a Steelscape Sales Representative for additional information.

* Resin coated products may have a different max weight.

** Width restrictions may apply on less than .0130" TCT material

*** Standard passivant is RoHS compliant

**** Less than G60 not recommended for paint line feed. For heavier coating weights, inquire with a Steelscape Sales Representative.

Steelscape is happy to evaluate requests for TruZinc® Steel products not shown on the capability matrix above. Equipment capabilities and hot band supply may impact our production capabilities. Questions regarding TruZinc Steel processing capabilities should be directed to a Steelscape Sales Representative.

PAINTED STEEL

Steelscape is able to paint a wide variety of paint systems. Like the TruZinc® and ZINCALUME® Steel sections, the following pages describe Steelscape's organic coated (painted) steel product.

Pre-painted SDSs can be found at www.Steelscape.com in the **Document Library**.

Four Pre-Painted Technical Bulletins are also available on the website and cover batch sensitive paints, pressure mottling, storage corrosion and Natural Matte® installation.

Details about our branded, painted steel products including Steelscape Prints®, Rawhide, Vintage®, Natural Matte® and Textured Rustics® can be found at www.steelscape.com. Steelscape offers a portfolio of uniquely painted products offering a multitude of creative design options. Don't be limited to a single color.

Steelscape also offers a standard painted product line called Spectrascape®, available on both ZINCALUME and TruZinc substrate. Spectrascape is available in polyester, silicone polyester and PVDF technology. For more details and warranty information please visit www.Steelscape.com or contact Steelscape Sales Representative.

PRE-PAINTED STEEL PROCESSING CAPABILITIES

The capability matrix below was designed to help illustrate the painted steel products Steelscape is capable of producing on a consistent basis. These capabilities grow and change with each new successful trial order we process to completion. As we become more proficient in producing product outside the stated capacity limits we will expand this matrix accordingly.

	Kalama	Rancho
Max Entry Coil Wt	58,000 #	ZINCALUME® 38,000 #, TruZinc® 30,000 #, External supplied 20,000 #
Max Output Coil Wt*	33,000 #	20,000 #
Minimum Lineal Footage**	1,600 ft.	1,600 ft.
Thickness***	0.0115" - 0.039"	Steel: 0.0130" - 0.0460" Al: 0.0320" - 0.0630"
Width***	26" - 50"	28" - 52"
Pretreatment	Chemetall 1500	Chemetall 1500
Substrates	TruZinc (galvanized), ZINCALUME (Galvalume®), Cold-Rolled	TruZinc (galvanized), ZINCALUME (Galvalume), Cold-Rolled, Aluminum, Stainless, TMBP, EG
Finish Coatings	Acrylic, Polyester, SMP Fluorocarbon, Plastisol	Acrylic, Polyester, SMP Fluorocarbon, Plastisol
Primer Coatings	Urethane, Epoxy, Polyester	Urethane, Epoxy, Polyester
Other Coatings	Resin/Passivant (standard or RoHS) by rare exception	Resin/Passivant (standard or RoHS) by rare exception
Entry OD/ID	81.5" max/20"	79"/20" or 24" +/- 0.50"
Delivery OD/ID	72" max/20"	64" max/20"
Cores	Available	Available
Reverse Wrap	Available	Available****
Branding Ink	UV	UV
Branding Characters	275 Standard Text (Steelscape, KA_CPL, Date/Time)	250 Standard Text (Steelscape, RA_CPL, Date/Time)
Branding Size	1/2"	1/2" max
Branding Location	Bottom - 4" in from edge	Bottom - 3.5" in from front edge

* If vertical, skidded max weight is 15,000#.

** Refer to your Steelscape Sales Representative for minimum lineal footage restrictions on multiple pass orders and Steelscape branded paints.

*** Widths outside those listed may be possible depending on thickness, steel grade and post slitting if applicable. Inquire with your Steelscape Sales Representative.

**** Requires additional processing to reverse wrap (slitter/embosser).

Steelscape is happy to evaluate requests for steel products not on the current capability matrix. Equipment capacities and hot band supply constraints may impact production capability. Questions regarding our painted steel capabilities should be directed to a Steelscape Sales Representative.

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	ZINCALUME® Bare	ZINCALUME® Painted†	TruZinc® Bare	TruZinc® Painted†
ORDER ENTRY (in 000's)				
Minimum Order Size~°	50	25	50	25
Order Increments~°	50	25	50	25
Minimum Coil Size	7	7	7	7
Maximum Coil Size	25	20^	50	20^
SURFACE TREATMENT				
Skin Passing	•	•	•	•
Passivation	•		•	
Oil	•		•	
Resin (clear & tinted)*	•		•	

° **BARE COIL:** Widths in the 26" - < 31" range must have a minimum order size of 35K lbs. with additional order increments of 35K lbs. Widths in the 31" - <35" range must have a minimum order size of 40K lbs. with additional order increments of 40K lbs. Widths in the 35" - 38" range must have a minimum order size of 45K lbs. with additional increments of 45K lbs. Please note that we do have significant quantities of steel sourced that have order increments smaller than this stated guideline. We will make every effort to match the quantity you require, but may need to make order quantity adjustments for items using this supply chain.

~ **PAINTED COIL:** Painted steel orders must utilize an entire hot roll coil, based on the bare product width ranges provided above (see the ° footnote). The minimum order size for painted steel is ½ the bare order size IF accompanied by a second order of painted product for the same specification using the remainder of the hot roll coil.

^ If vertical, skidded max weight is 15,000# in Rancho and 15,000# in Kalama.

* For TruZinc and ZINCALUME Steel, .0356 & > is considered non-surface critical. Consult your Steelscape Account Manager for details.

+ Resin coated and mill-applied coated product lead times may vary based on accumulation of a minimum tonnage requirement.

‡ For painted steel thickness >.030", consult your Steelscape Account Manager. Paint systems and color MUST be pre-approved by Steelscape Quality Systems prior to order.

Please reference Steelscape's website, www.steelscape.com, for full offer details on both bare and painted product.

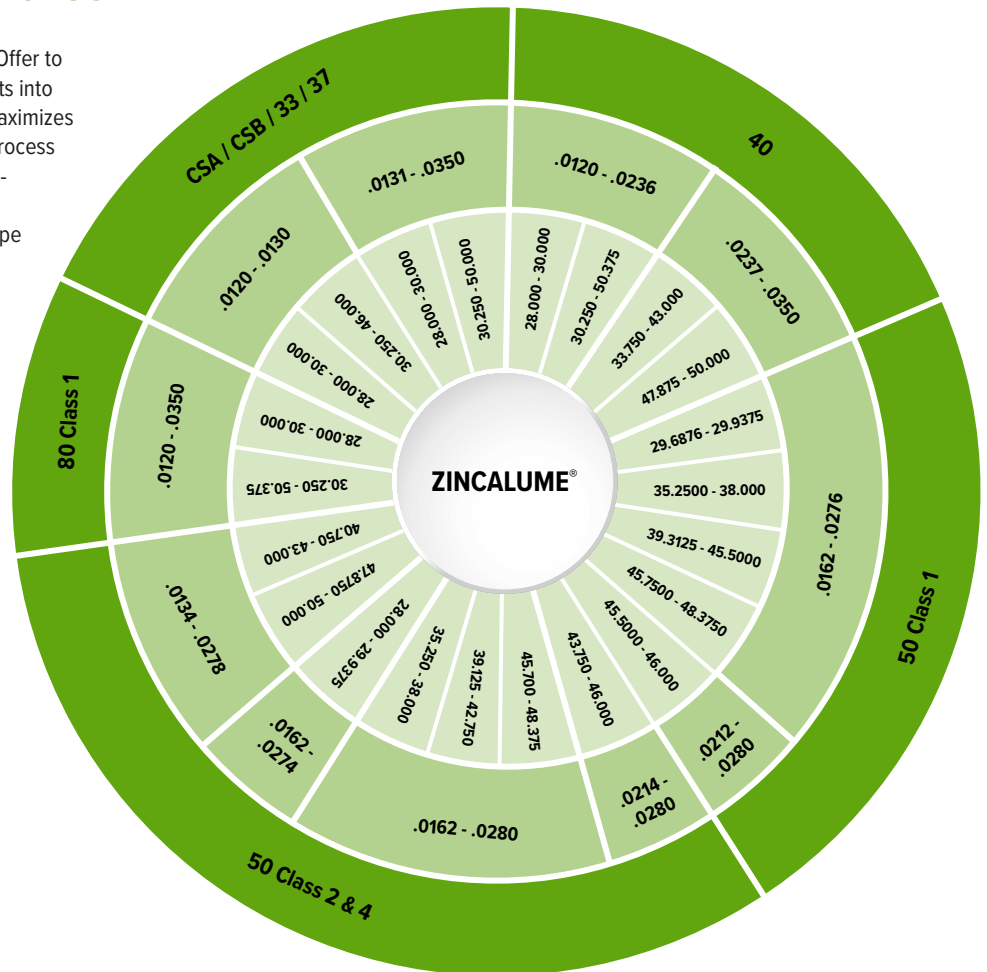
ZINCALUME® STANDARD PRODUCT OFFER

Steelscape designed the Standard Product Offer to streamline and categorize our many products into frequently requested offerings. This offer maximizes Steelscape's ability to reliably and quickly process customer orders and deliver quality metallic-coated and painted steel products. The Standard Product Offer also allows Steelscape to effectively serve customer needs and deliver superior service.

The Product Offer groups products according to coil base metal thickness (BMT), width, metal coating type and product grade.

Steelscape's Standard Product Offer is subject to change. Product outside this offer may be possible on a trial basis, please inquire with your Steelscape Sales Representative.

Wheel Color Key	
	Grade
	Thickness
	Width Options



Material	Substrate	BMT Thickness (in)	Width Options (in)
CSA/CSB/33/37	ZINCALUME	.0120 - .0130	28.0000 - 30.0000 30.2500 - 46.0000
		.0131 - .0350	28.0000 - 30.0000 30.2500 - 50.0000
40	ZINCALUME	.0120 - .0236	28.0000 - 30.0000 30.2500 - 50.3750
		.0237 - .0350	33.7500 - 43.0000 47.8750 - 50.0000
		.0120 - .0350	28.0000 - 30.0000 30.2500 - 50.000
50 Class 1	ZINCALUME	.0162 - .0276	29.6876 - 29.9375 35.2500 - 38.000 39.3125 - 45.5000 45.7500 - 48.3750
		.0212 - .0280	45.5000 - 46.000
		.0162 - .0276	29.6876 - 29.9375 35.2500 - 38.000 39.3125 - 45.5000 45.7500 - 48.3750
50 Class 2 & 4	ZINCALUME	.0134 - .0278	40.7500 - 43.0000 47.8750 - 50.0000
		.0162 - .0274	28.0000 - 29.9375
		.0162 - .0280	35.2500 - 38.0000 39.3125 - 42.75000 45.7500 - 48.3750
		.0214 - .0280	43.7500 - 46.0000
		.0120 - .0350	28.0000 - 30.0000 30.2500 - 50.3750
80 Class 1	ZINCALUME	.0120 - .0350	28.0000 - 30.0000 30.2500 - 50.3750

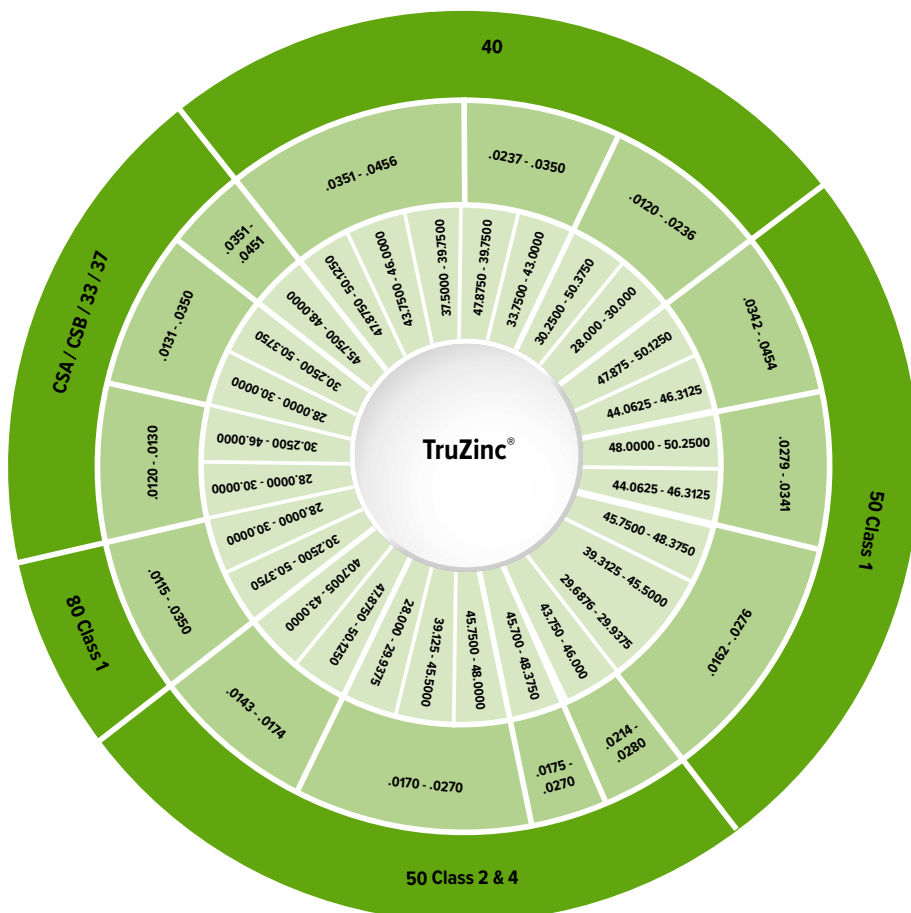
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TRUZINC® STANDARD PRODUCT OFFER

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The Product Offer groups products according to coil base metal thickness (BMT), width, metal coating type and product grade.

Steelscape's Standard Product Offer is subject to change. Product outside this offer may be possible on a trial basis, please inquire with your Steelscape Sales Representative.



Wheel Color Key

Grade

Thickness

Width Options

Material	Substrate	BMT Thickness (in)	Width Options (in)
CSA/CSB/33/37	TRUZINC	.0120 - .0130	28.0000 - 30.0000 30.2500 - 46.0000
		.0131 - .0350	28.0000 - 30.0000 30.2500 - 50.3750
		.0351 - .0451	45.7500 - 48.0000
		.0456	47.8750 - 50.1250
40	TRUZINC	.0120 - .0236	28.0000 - 30.0000 30.2500 - 50.3750
		.0237 - .0350	33.7500 - 43.0000 47.8750 - 50.1250
		.0351 - .0456	37.5000 - 39.7500 43.7500 - 46.0000
		.0456	47.8750 - 50.1250
50 Class 1	TRUZINC	.0162 - .0276	29.6876 - 29.9375 39.3125 - 45.5000 45.7500 - 48.3750
		.0279 - .0341	44.0625 - 46.3125 48.0000 - 50.2500
		.0342 - .0454	44.0625 - 46.3125 47.8750 - 50.1250
		.0454	47.8750 - 50.1250
50 Class 2 & 4	TRUZINC	.0143 - .0174	40.7005 - 43.0000 47.8750 - 50.1250
		.0170 - .0270	28.0000 - 29.9375 39.3125 - 45.5000 45.7500 - 48.0000
		.0175 - .0270	45.7500 - 48.3750
		.0214 - .0280	43.7500 - 46.0000
80 Class 1	TRUZINC	.0115 - .0350	28.0000 - 30.0000 30.2500 - 50.3750
		.0350	45.7500 - 48.0000

STEELSCAPE VALUE-ADD PROCESSES

Steelscape values innovation and progress. In every industry, there are vast opportunities for advancement, growth and overall improvement both in products and processes. However, in most cases, these opportunities do not come easily. It takes time, effort and dedication to find and develop these opportunities into something that is attainable and real. Steelscape, in an effort to lead the steel industry in this innovative quest, devotes resources to doing just that. And the result over the past several years has been a host of new products and processes that Steelscape is now offering to you.

The following pages outline some of the many additional processes that Steelscape has to offer. While not every new development is listed in the section, it should provide you with a brief look at some of the work Steelscape has been doing over the past few years. We highlight our value-add processes such as slitting, embossing, cut-to-length and mill applied coatings.

To learn more about Steelscape's value-added processes, contact a Steelscape Sales Representative. And, as always, any suggestions for new products or processes are always welcome!

Cut-to-Length Sheet

Steelscape provides Cut-to-Length Sheet as a Value Add Service. The Cut-to-Length line is also capable of shearing material. The following matrix shows the Cut-to-Length capabilities for our only CTL line, located in Kalama, WA.

	Kalama
Max Entry Coil Weight	60,000 #
Max Shear Strength	50 KSI
Max Yield Strength	65 KSI (90 KSI up to .030" thick)
Thickness (T)	0.010" - 0.050" Bare 0.0101 - 0.030" Painted*
Width	12" - 60"
Max Pallet Weight	5,000 #**
Min. Cut Length	36"
Max. Cut Length	144" (up to 150" - trial only)
Entry OD/ID	84"/20" +/- 0.5"
Max Stack Height	24" with skid
Strippable Film**	48" (-0.25"/+0.375")

* Maximum thickness is limited for fluorocarbon paint systems due to concern with scratching top surface upon stacking. Inquire with your Steelscape Representative for painted product greater than 0.0236" ordered thickness.

** Heavier weight requires inquiry.

*** Standard width is 48", it can be made available in any width up to 60", but may require longer lead time.

Slitting

Steelscape provides Slitting as a Value Add Service to all customers. The following matrix shows our slitting capabilities by facility. Should you have any questions regarding our slitting capabilities, please contact your Steelscape Sales Representative.

	Kalama	Rancho
Max Entry Coil Weight	55,000 #	20,000 #
Max Delivery Weight	55,000 #	20,000 #*
Thickness (T)	0.010" - 0.050"	0.0110" - 0.0460" Steel 0.0320" - 0.0630" Alum.
Width	16" - 52"	12" - 52"
Max number Mults	24	20 if .025"<T<.050" 40 if T<.025"
Maximum # sizes per setup	Depends on knives & size of mults	Depends on knives & size of mults
Minimum Slit Width (W)**	1.25" bare 2.00" painted**	1.25" bare 2.00" painted**
Entry OD/ID***	79" max/20"	64" max/20"
Delivery OD/ID	79" max/20"	64" max/20"
Cores****	W > 10", T < 0.030"	W > 10"
Min. Slit Drop	0.375"	0.375"

* If vertical, skidded maximum weight is 15,000#.

** For smaller widths inquire with your Steelscape Sales Representative.

*** OD max depends on number of mults and crown in the coil.

**** Cores are "all or nothing" for the whole arm of mults (i.e. if one mult on the arm is less than 10", then none of the mults on the arm can have cores). Please inquire for cores < 10" due to safety issues.

Embossing

Embossing is a Value Add Service to all customers. The following matrix shows our embossing capabilities at our Rancho Cucamonga, CA, facility. Should you have any questions regarding our embossing capabilities, please contact your Steelscape Sales Representative.

	Rancho
Pattern	Non-Directional Stucco
Max Entry Coil Wt	30,000 #
Max Output Coil Wt	12,500 #
Thickness	0.0180" - 0.0296" Coated Steel* 0.0320" - 0.0400" Aluminum
Width	23.937" - 48.5" Coated Steel 18" - 48.5" Aluminum **
Depth	.007" up to .01" thick
Substrates	TruZinc (HDG), ZINCALUME (Galvalume), CRS, ALUM**
Entry OD/ID	20"
Delivery OD/ID	OD 64"/ID 20"
Cores	Required
Reverse Wrap	Available
Packaging	Vertical Only***

* Pattern not guaranteed on thickness above 0.0356".

** Grade/hardness restrictions may apply to some substrates. Cannot process Grade 80 steel. Grade 50 above 0.0236" inquire with your Steelscape Representative.

*** Embossed material will collapse if packaged longitudinally.

RETURN TO TABLE OF CONTENTS**PRODUCT OPTIONS****Skin Passing**

Skin-passing is a critical step to achieving superior surface quality, especially for painted steel products. It is important to define whether a product should be skin-passed when placing an order.

Recommendations for skin-passing are as follows:

- All painted products must be skin-passed. Any question as to skin-passing necessity should be referred to our Sales or Technical Sales Dept. prior to placing an order.
- Resin coated products should not be skin-passed as it is very difficult to measure the resin coating thickness
- Skin-passing produces an extra smooth bare product and is especially beneficial for painted products.

Chemical-Treatment & Oiling

Chemical-treatment and oiling are also critical steps in the metallic coating process. Both processes lengthen finished product shelf life and help to prevent field rejections due to rust. Oil is important in cases where resin is not available and self-lubricating surface characteristics are desired. It is important to specify whether a product should be chemically-treated and/or oiled when placing an order.

Recommendations when chem-treating or oiling are as follows:

- Any questions regarding oiling or chemical-treatment necessity including RoHs compliance should be referred to our Technical Sales Department. We have several options available.
- All resin-coated products (TruZinc® Plus and ZINCALUME® Plus) should not be oiled. Oiling is unnecessary and makes the resin-coated surface too slick.
- Some bare, chemically-treated (non-resin) products require light to medium oiling so adequate lubricating properties are achieved for downstream processing.
- Bare, paint line feed product not painting at Steelscape, may require chemical-treatment to prevent storage and transportation corrosion, consult with our Technical Sales Department.
- All other bare products should be chemically-treated.

Theoretical Minimum Weight

Steelscape provides ZINCALUME® and TruZinc® Steel products on both an actual weight and theoretical minimum weight (TMW) basis. Many of our customers sell their products on a lineal footage basis and it makes sense to purchase the same way. TMW pricing permits customers to pay for the lineal feet of coated steel in a particular coil (or order). If the steel is slightly thicker, width slightly wider or metallic coating slightly heavier than the minimum dimensions ordered customers do not pay for the excess. Customers are charged only for the lineal feet received. There is a small extra charge for the added feature of TMW pricing, please contact your Steelscape Sales Representative for details.

The following values are used to calculate TMW:

Density (Steel) = 0.2833 lb/in³

Density (TruZinc) = 0.2579 lb/in³

Density (ZINCALUME) = 0.1355lb/in³

CT = metallic coating thickness (min, inches)

G30 = 0.0005 in

G40 = 0.0007 in

G60 = 0.0010 in

G90 = 0.0015 in

AZ50 = 0.0016 in

AZ55 = 0.0018 in

W = Width (min, inches) Ordered

T = Thickness (min, inches) Ordered

L = Length (feet) Ordered

$$TMW = [(density\ steel \times (T-CT)) + (density\ TruZinc\ or\ ZINCALUME \times CT)] \times W \times LF \times 12$$

Resin Coating

Steelscape offers a clear resin coating on ZINCALUME® Steel product called ZINCALUME® Plus Steel. We also offer a resin coated TruZinc® Steel, TruZinc® Plus. The resin coating is water-based and is 0.031 to 0.060 mils thick. The resin coating is applied in-line to both top and bottom surface. It is formulated to resist finger printing and scuffing during product handling in addition to improving resistance to wet-stack stains occurring during transport and storage. ZINCALUME Plus and TruZinc Plus Steel virtually eliminates the need for roll forming lubricants.

Steelscape requests that customers notify them if any adhesion properties are required of either ZINCALUME Plus or TruZinc Plus steel products at the time of placing an order. Depending on the adhesion properties required, a different resin system may need to be applied.

RoHS or REACH compliant resins are available but must be discussed with your Steelscape Sales Representative prior to order entry.

Several other, specialty resins are available, including tinted products. Please inquire with your Steelscape Sales Representative for additional information.

PACKAGING

Steelscape's products are packaged in a variety of ways. To be most effective we identified the most commonly requested package options and included them within our Standard Packaging Offer.

Standard Packaging - General Descriptions*	Code
Horizontal, Two Eye Bands	110
Horizontal, Paper Wrap, Two Eye Bands	120
Horizontal, Plastic (VCI) Wrap, Two Eye Bands, ID and OD Protection, Core. For painted only. Required for Rail Gondola	140
Vertical, Plastic (VCI) Wrap, Skid, Core	210
Vertical, Plastic (VCI) Wrap, Skid	220
Side Loaded Skid - CTL	807
Vertical, Wrap, Skid, Rubber Mat, Boxcar (3-run 4x4)	410
Vertical, Exhibit Wrap, Skid, Rubber Mat, Boxcar (3-run 4x6)	430

Steelscape will consider non-standard packaging requests on an inquiry basis. All Non-Standard Packaging may be subject to packaging extras. Please consult a Steelscape Sales Representative for more information.

- * Wrap type depends upon the facility from which the product is shipped.

SHIPPING POLICY & PROCEDURES

Steelscape realizes the important role transportation plays in getting our product to customers. We have established the following policies and procedures to ensure the product shipped is received in the same condition as when it left our facilities.

Carrier Requirements

- The carrier must supply all necessary dunnage.
- The carrier must have tarps or curtain van.
- The carrier must have chains or straps, and appropriate edge protection.
- The carrier must pay for any dunnage Steelscape supplies to ensure safe and damage-free transit of our product.

NOTE: Steelscape reserves the right to refuse loading any carrier vehicle that arrives unprepared.

Preparing Coils for Transit

- All loads must be protected from weather and the elements before leaving the plant site.
- All coils must be appropriately secured in accordance with local and state laws before transit.

Proper loading protection is an important factor in getting products to customers safely and undamaged.

Drivers may be asked to lay tarp over coils and complete tying down outside the loading area if other trucks are waiting to load.

Required Paperwork

Drivers picking up coils at any Steelscape location will be given a bill of lading. The bill of lading must be received and signed by a representative of our customer. Steelscape requires a copy of this signed bill of lading be included with the carrier invoice. Some shipments will also be accompanied by Mill Test Certifications. The certifications must also arrive with the coils and be received by our customers.

Required Attire

All safety protection mentioned below must be supplied by the carrier and worn by the driver while on Steelscape property.

- Hard hat
- Safety glasses
- High visibility vest
- Long sleeved shirt
- Long pants
- Closed-toed shoes

NOTE: If Steelscape supplies required safety attire to an unprepared carrier, we ask that the supplies are returned prior to leaving our facility. Steelscape places both our safety and the safety of visitors to our facilities as the highest priority. We favor vendors and carriers who honor our safety requirements.

Safety

All drivers will be required to follow the **Exclusion Zone Policy** outlined by Steelscape during the driver safety briefing. Any minors or pets accompanying the driver must remain inside the vehicle cab while the truck is inside the loading area or at anytime the truck is being loaded or unloaded. Use of fall protection is mandatory.

Loading Appointments

Customer must notify the Steelscape Dispatcher and acquire a loading appointment at least 24 hours in advance for customer to arrange pick-up. A Steelscape Customer Service Representative can provide the appropriate Steelscape facility's Dispatcher contact information.

Will-Call Shipments

An appointment is required for all Will-Calls. If will-call requests, will all necessary information, are received by customer service by 11am PST an appointment can be scheduled for the next business day. Requests received after 11am PST can be scheduled for the day after.

Steelscape Shipping Hours

Kalama, WA – Monday - Sunday, 24 hrs/day.

Rancho Cucamonga, CA - Monday-Sunday, 24 hrs/day.

Variance from these stated shipping hours will be communicated in advance through normal communication channels.

Standard Delivery & Pick-Up Lead Times

Local Deliveries: Next-day for Steelscape releases received by 11:00 AM. Local deliveries are < 150 miles from Steelscape's Point of Production.

Shipments Outside of Local Area: Shipment within two (2) working days for releases received by noon.

Shipments from Outside Warehouses: Same requirements as that of a Steelscape Point of Production.

Delivery/Load Changes: 6-hour notification required.

Requests outside of Steelscape's Shipping Service Offer will be addressed on a case by case basis and accommodated when schedule, workload and inventory accessibility allows.

Outgoing freight charges can be prepaid or collect as established on the order.

Steelscape will target a minimum load weight, based on released coil weights, for semi loads of no less than 45K lbs. and for maxi loads of no less than 58K lbs.

Should a coil not be available for a planned load, efforts will be made to fill the load with coils from another order or load for the same destination. This may require additional material/orders to be released for shipment.

Steelscape Transportation Incoterms

Incoterm	Text Description for Quote
Incoterm: EXW = EX Works " Carrier - Customer arranges " Freight Costs - Customer " Title - Transfers at Shipping Point	Collect, CUSTWC
Incoterm: FCA = Free Carrier " Carrier - Steelscape arranges " Freight Costs - Customer " Title - Transfers at Shipping Point	Collect, Ship Arrange Frt
Incoterm: CPT = Carriage Paid To " Carrier - Steelscape arranges " Freight Costs - Steelscape " Title - Transfers at Shipping Point	Prepay, Ship Arrange Frt

Storage Policy

Steelscape has a finished goods material storage policy for bare and painted, metallic-coated TruZinc® and ZINCALUME® Steel. This policy applies to finished goods of single-bill products only. Storage of toll-processing (customer-owned) product, please reference the Steelscape Toll Processing Offer.

Our policy ensures the reliability and efficiency of Steelscape is maximized through timely conversion of produced material into shipped products. Efficient use of warehouse space is also necessary for reduced Standard Product Offer lead times.

Details of the Steelscape material storage policy for single-bill orders are as follows:

- Finished goods inventory left in Steelscape's possession for more than thirty (>30) days from the order acknowledged Ship Date may be automatically transferred to an off-site warehouse for storage.
- Steelscape's storage fee will commence beginning thirty-one (31) days from the order acknowledged Ship Date.
- Steelscape will not be liable for coil damage, including storage corrosion, on finished goods inventory order sixty (>60) days from order acknowledge ship date.
- The storage fee, which consists of costs that Steelscape incurs in the transfer, storage and handling of each coil, will be \$7.50 per ton per month.
- Customers will receive a storage invoice for each thirty (30) day period in which their product remains in Steelscape's off-site warehouse facilities.

Steelscape Account Managers or Customer Service Representatives can address questions regarding Steelscape's finished goods material Storage Policy.

FINISHED MATERIAL - RECEIPT & INSPECTION

Once received, the customer is responsible for unloading all material delivered from Steelscape and inspecting the material for visible damage. The material needs to be stored in a covered/enclosed space to protect the metal from inclement weather, water damage and/or condensation.

Prior to unloading any material with visible damage, the customer must notify the carrier's representative of the damage and note the damage as such on the delivery receipt.

If the material received does not meet the specifications on the packing list, the customer must notify the Steelscape Customer Service Representative immediately. At such time, the issue can be investigated and remedied.

If the quantity of material received by the customer is less than the quantity invoiced or if material received appears damaged in transit, the customer shall give written notice to the agent of the delivering carrier for verification of the shortage or damage. The customer will send copy of the same to Steelscape in addition to the receiving records.

Should the customer fail to notify Steelscape promptly of any issues related to damage upon receipt and/or non-conformance of the material, the material will be considered to have been received in good condition and as ordered. The material will also be considered delivered in accordance with the packing list/shipping documents.

CLAIMS POLICY

Steelscape strives to consistently provide high quality products to meet or exceed our customers' needs. Unfortunately, perfection cannot always be attained and products may not fulfill the requirements. Though we prefer getting the job done right the first time, we strive to make doing business with Steelscape as easy as possible when we don't. To that end, we created a claims policy which delineates our procedures for resolving product quality claims in a timely and satisfactory manner.

Steelscape's full claims policy can be found on www.steelscape.com or by clicking here.

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ASTM SPECIFICATIONS

Organized in 1898, ASTM has grown into one of the largest voluntary standards development systems in the world. ASTM is a not-for-profit organization which provides a forum for producers, users, ultimate consumers, and those having a general interest (representatives of government and academia) to meet on common ground and write standards for materials, products, systems and services.

ASTM standards are developed and used voluntarily. Standards become legally binding only when a government body references them in regulations, or when they are cited in a contract. Any item that is produced and marked as conforming to an ASTM standard must meet all applicable requirements of that standard.

ASTM standards are used by thousands of individuals, companies and agencies. Purchasers and sellers incorporate standards into contracts architects and designers use them in plans; government agencies reference them in codes, regulations and laws; and many others refer to the standards for guidance. Steelscape products are manufactured in accordance with the most recent versions of the respective ASTM standards as listed below:

ZINCALUME® products ASTM A792
TruZinc® products ASTM A653
Cold Rolled ASTM A568
Metallic Coated Steel Sheet ASTM A924

Steelscape produces to many other ASTM standards as required by end use or customer request. For more information, please contact your Steelscape Sales Representative.

Due to ASTM membership requirements and copyright law, Steelscape may not provide copies of ASTM standards.

The information in this Bulletin is current as of September 2025. It is possible that the laws and regulations discussed may change from time to time. While Steelscape will endeavor to issue updates to address regulatory changes, Steelscape disclaims any affirmative obligation to do so. Should you have any questions on the current applicability of any of the laws discussed herein to your product purchases, please contact Steelscape's Technical Services Department or your Account Manager.

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REGULATIONS AND SUSTAINABILITY

Steelscape strives to stay current on all regulatory and sustainability initiatives and programs within the construction industry. These programs are vast and ever changing, but Steelscape has prepared guidelines and customer letters for the more common items. These documents can be found on our website, www.steelscape.com, and cover the topics listed below;

USGBC LEED Program
Buy American Act/Surface Transportation Assistance Act/State Buy American
Recycled Content
Cool Roof Rating Council
Zinc Run Off

If you need additional information on these programs, or any not listed, please contact your Steelscape Sales Representative.

STEELSCAPE WEBSITE & XTRASCAPE®

Steelscape has designed an external website that is simple and easy to use. Realizing how important real time information can be, our website strives to inform and assist everyone who logs onto the site.

At www.steelscape.com customers can learn about everything from the Steelscape company culture to product specifications to current publications. Technical product sheets, warranties, regulatory information and other key downloads can be found in our [Document Library](#)

For current, active customers, Steelscape's online transaction system - XtraScape is available. XtraScape provides a vast amount of data on Steelscape orders, coils, shipments and claims. In addition, customers are able to submit online claims submissions.

To request access to XtraScape, click on the "Register Now" link on our website at www.steelscape.com. Customers can also request access by contacting their Steelscape Sales Representative.

Definitions

This section defines the technical terms used in the Service Offer Manual. Unless a term is defined in this section, the most widely-accepted definition appearing in an English dictionary will apply. If any of the following definitions are unclear or you require additional assistance, please contact your Steelscape Sales Representative. Should a term appear in the Service Offer Manual that is not adequately defined, please contact us and we will amend this section as appropriate.

Acknowledged Delivery Date: The date by which Steelscape commits to produce an order and pack it ready for shipment. This date is always a Saturday.

Acrylic Paint: Thermoset acrylic and acrylic coatings are based on resins prepared from acrylic and methacrylic esters, acrylic and methacrylic acids and/or styrene. Acrylics can be modified with other resins. Acrylic latex resins are designed to exceed the polyester resin systems in durability, color retention and outdoor exposure tests. Because they utilize waterborne technology, acrylics reduce toxic VOC (volatile organic compounds) when paint is cured. Acrylic paints are typically found on roll formed sections for commercial, agricultural and pre-engineered buildings.

Aged Material: Material that was ordered by a customer and remains in Steelscape's inventory for > 30 days from the order acknowledge date.

ASTM Standards: The American Society for Testing and Materials is an independent standards organization that regularly publishes testing and performance specifications for a wide variety of industrial products. Steel producers in North America provide most common steel products according to specifications laid out in the ASTM standards. Steelscape adheres to these standards.

ASTM Thickness Tolerance: Allowable variation in strip thickness as designated in the ASTM standards.

Auto Release: Pre-authorization has been given for shipment.

AZ35 Coating: 55% Aluminum/45% zinc coating applied at a minimum coating mass of 0.35 oz/ft² (total, both sides).

AZ50 Coating: ZINCALUME® coating applied at a minimum coating mass of 0.50 oz/ft² (total, both sides).

AZ55 Coating: ZINCALUME® coating applied at a minimum coating mass of 0.55 oz/ft² (total, both sides).

Bill of Lading: A document defining freight terms for a shipment, specifying when ownership of material transfers from seller to buyer, together with assignment of freight charges.

Bonderized: A thin layer of Zinc Phosphate on the surface of the sheet that it is a weldable product and that provides a surface to which paint will readily adhere. This is typically used in rainwater goods.

Branding: A positive identification of product characteristics placed on the coil such as manufacturer, product name, grade, coating, thickness, width and production date. This information may be reproduced at frequent intervals on the bottom side of a coil.

Chromium Passivation (Also Chemical Treating): A surface treatment normally applied to metallic coatings to retard the formation of corrosion products (storage stain) during shipment and storage. It is applied to bare products in-line. Some continuous paint lines may not be able to paint over all types of chromium passivation.

Closed Order: An order which has been shipped complete (within +/- 10%) or has a reason of rejection defined. As noted above the delivery percentage listed can be changed, which will allow the orders to close prior to -10%.

Coil Hardness: The resistance of metallic material to plastic deformation by indentation or penetration.

Coil Number: A unique number, assigned by Steelscape, which identifies a finished coil.

Commercial Steel (CS): Steel sheet intended for applications where product is subjected to bending or moderate forming. Three types of commercial steel exist and are differentiated primarily based on carbon composition limits: Type A (or CSA) which must not contain more than a 0.1% carbon content, Type B (or CSB) which specifies a 0.02 to 0.15% carbon range, and Type C (or CSC) which must not contain more than a 0.08% carbon content.

Cores: A fiber tube located in the bore of a coil, designed to provide protection from handling and mandrel damage.

Credit Terms (.5% 10th, 25th, or Net 30 Days): Standard credit terms under which Steelscape completes commercial transactions. Invoices dated from the 1st to the 15th of the month may be discounted by .5 of 1% if paid by the 25th of the month, and invoices dated from the 16th to the last day of a month may be discounted .5 of 1% if paid by the 10th of the following month. If a discount date falls on a weekend or holiday, the next business day will be acceptable for discounts. As an option to discount, invoices may be paid in 30 days from date of invoice. Postmarks will be used to establish discount dates.

Cross-Break Damage (Also Coil Break or Mandrel Marks): Cross-break is a latitudinal crease extending across the width of the strip, usually found near the inside diameter of the coil.

Customer to arrange: Customer will arrange shipment to or from designated facility.

Cut-To-Length: Sheet steel that is pre-cut to the customers specified length.

CWT (Hundred Weight): Common unit of measure used for commercial transactions in the North American steel industry. Equal to 100 pounds or 1/20th of a short ton.

Drawing: Mechanical forming of steel by tension through or in a die (for example, sheet drawing) and usually carried out at temperatures below the re-crystallization temperature.

Drawing Steel: A grade of steel designated by ASTM as suitable for drawing and other forming applications where very high ductility is required.

Dross: Particles of zinc oxide and other impurities formed on the surface of the metallic coating line pot. Dross is regularly skimmed from the surface of the pot to prevent contact with the steel strip.

Ductility: Relative ability of a metal to deform from a flat condition to a more complex shape, without fracture. Also known as formability or workability.

Dunnage: Wood and other materials used to secure steel coils during transportation. Dunnage allows safe transport while preventing product damage.

Edge Wave: A condition whereby the material at the edge of the strip is slightly longer than the rest of the strip causing a ripple effect at the edge of the strip.

Embossing: The process of inducing a specific depth pattern into the steel base of a strip using textured rolls. Steelscape offers stucco embossing.

End Use: The final use or application of the coated steel product.

Epoxy Paint: Epoxies are known for excellent substrate adhesion and corrosion resistance and have been used in primer applications for years. Poor exterior durability, poor flexibility, and high cost have limited use of epoxies in coil coatings.

Exhibit Wrap: Allows easy and immediate viewing of steel coil color.

Eye-Horizontal: Orientation of a steel coil indicating that the bore or “eye” is positioned horizontal to the ground.

Eye-Vertical: Orientation of a steel coil indicating that the bore or “eye” is positioned vertical to the ground.

Fiber Core: A liner used inside coils to prevent excessive damage from normal handling.

Field Failure: A premature failure of an end product such as fading, corrosion, adherence, etc. while that product is in service.

Film Thickness: Film thickness or dry film thickness (DFT) refers to the thickness of paint film on the strip surface, once the paint has cured. Typical DFT's for painted steel range from 0.0005" (0.5 mil) to 0.0015" (1.5 mil).

Fluorocarbon Paint: Also known as PVDF (Polyvinylidene Fluoride), KYNAR 500® and HYLAR 5000® coatings. The PVDF resin does not absorb UV radiation and therefore does not degrade, chalk or fade like other coatings. Fluorocarbon coatings are the product of choice for exterior durability and demanding end uses.

Forming Steel: Grade of steel designated by the ASTM as suitable for bending, forming and other applications where higher ductility is required.

G30 Coating: TruZinc® steel or hot dipped galvanized coating applied at a minimum coating weight of 0.30 oz/ft² (total, both sides).

G40 Coating: TruZinc® steel or hot dipped galvanized coating applied at a minimum coating weight of 0.40 oz/ft² (total, both sides).

G60 Coating: TruZinc® steel or hot dipped galvanized coating applied at a minimum coating weight of 0.60 oz/ft² (total, both sides).

G90 Coating: TruZinc® steel or hot dipped galvanized coating applied at a minimum coating weight of 0.90 oz/ft² (total, both sides).

G100 Coating: TruZinc® steel or hot dipped galvanized coating applied at a minimum coating weight of 1.0 oz/ft² (total, both sides).

Gloss: Gloss represents the luster or visually reflective properties of a surface. Painted steel surfaces are available in a wide variety of glosses

Grade 33 Steel: ASTM annealed structural grade steel with a minimum base metal yield strength of 33 ksi, minimum tensile strength of 45 ksi, and minimum elongation of 20%.

Grade 37 Steel: ASTM annealed structural grade steel with a minimum base metal yield strength of 37 ksi, minimum tensile strength of 52 ksi, and minimum elongation of 18%.

Grade 40 Steel: ASTM annealed structural grade steel with a minimum base metal yield strength of 40 ksi, minimum tensile strength of 55 ksi, and minimum elongation of 16% (based on Grade 40c1 specifications).

Grade 50 Steel: ASTM annealed structural grade steel with a minimum base metal yield strength of 50 ksi, minimum tensile strength of 65 ksi, and minimum elongation of 12% (based on Grade 50c1 specifications).

Grade 80 Steel: Stress relieved ASTM structural grade steel with a minimum base metal yield strength of 80 ksi, and a minimum tensile strength of 82 ksi (based on Grade 80c1 specifications).

Grade Data Sheet: An information sheet furnished on most Steelscape products which provides a general description of the product, typical uses, coil dimension, capabilities, mechanical property specifications as well as typically produced mechanical properties, chemical composition specifications, supply conditions and fabricating performance ratings.

ID or Inside Diameter: A measurement of the inside diameter or bore diameter of a coil.

Incoterm: Is the agreement to freight terms, regarding transfer of ownership, responsibility of freight costs, from which point to where, and for whom bears the risk of damages.

ksi: Measurement typically used to express strength of a material or force per square area - thousand pounds per square inch. (1000 lb/in²).

Lead Time: A specified and mutually consenting period of time between order placement and order completion to acknowledged delivery date.

LTL (Less than Truck Load): A transit condition that results in less than efficient use of a trucks hauling capacity.

Maximum Coil Size: The maximum size of a finished coil, typically specified by the customer but sometimes limited by Steelscape. This quantity is related to both the physical constraints (e.g. cranes or fork lift carrying capacity) of the customer and Steelscape.

Maximum Order Size: The maximum quantity of a specific gauge, width, grade and paint color combination that Steelscape will accept on orders.

Maximum Skid Weight: The maximum size of a skidded coil, typically specified by the customer but sometimes limited by Steelscape. This quantity is related to both the physical constraints (e.g. cranes or fork lift carrying capacity) of the customer and Steelscape.

Mill Test Certification (MTC): A certification document issued with graded steel orders that includes the product specification & definition, the ship-to and sold-to addresses, the coil numbers, their relative heat chemistry numbers, any product test results pertaining to those coils listed and the heat chemistry analysis on the heat numbers listed.

Minimum Coil Size: The minimum size of a coil, typically specified by the customer but sometimes limited by Steelscape.

Minimum Yield: The minimum yield strength required to meet the mechanical property requirements for a particular grade of metallic coated sheet.

Non-Prime Product: Steelscape products that do not meet our quality standards for “prime” material. Our Secondary products are classified according to the severity of the defect that prevented the “prime” classification. (see “Secondary”)

OD or Outside Diameter: A measurement of the outside diameter of coil.

Oiling: Oil is applied to metallic coated coils on the metallic coating lines when requested by our customers. It is supplied in “Light (L)”, “Medium (M)” or “Heavy (H)” applications. It provides moderate corrosion resistance while coils move between internal processing lines as well as to customer’s facilities.

Open Order: An approved order that has not been shipped complete (within +/- 10%). There are exceptions where coils are in pack and ship status but the order has been shipped complete, the order will appear on the report. Also, the delivery percentage listed above can be changed which will allow orders to stay “open”.

Organisol Paint: A plastisol paint with solvents introduced to lower viscosity. These coatings have the same characteristics as plastisol coatings.

Output Width: The final or finished width of a coil as requested by a customer.

Paper Wrap: Coils enclosed with heavy-duty paper for protection during transit and storage.

Passivation: A treatment applied to the surface of bare metallic coated steel to provide greater resistance to corrosion; achieved by the formation of surface chromate, oxide or phosphate layers.

Pittsburgh Lock Seaming: Process used for joining metal sheet without the use of heat through an overlapping - bending process. Typically utilized for joining edges in HVAC and other sheet metal applications.

Plastic Wrap: Coils enclosed by a plastic, rust-inhibiting stretch wrap.

Plastisol Paint: Plastisol coatings are dispersions of finely divided higher molecular weight polyvinyl chloride resins in plasticizers. During the baking process, the finely divided resin particles dissolve in the plasticizers to create a tough plastic film upon cooling. This coating provides extra tough protection when surfaces are exposed to severe weathering or corrosive atmospheres. The main uses of this system are in building components and interior applications. Use in high UV areas is not recommended.

Polyester Paint: Polyester resins are the condensation products of polybasic acids and polyols. Polyesters are sometimes referred to as oil-free alkyds. They may also be modified by the additional reaction of other monomers, such as styrene or acrylic esters. Polyester resins are generally cross-linked with amino resins during baking.

Post-painted Steel: Steel painted after manufacturing or steel processing.

Preferred Coil Size: A coil size that is a direct multiple of Steelscape order increments.

Release: Customer authorization has been given for shipment.

Release Date: A customer-specified date which designates the shipment day for an order. More information on terms and conditions for release dates is provided in Section 4.20 of this manual.

Resin, Clear: A proprietary clear, odorless acrylic coating applied during the manufacturing process for ZINCALUME Plus steel and TruZinc Plus steel.

Reverse Impact Test: A test procedure used to determine coating adhesion to steel strip. A round-tipped, weighted cylinder is dropped from a specified height onto the test sample creating a round dent. The reverse side of the sample is examined for evidence of adhesion loss. This test is commonly used for both metallic and organic coated products.

Reverse Wrap: Processing a painted coil with the top-side or painted side facing the inside of the coil. This procedure protects the finish during certain down-stream processes.

Roll formed Steel: Sheet steel cold formed in a series of rolling stages.

Safety Data Sheet (SDS): SDS's are prepared in accordance with the OSHA Hazard Communication Standard (29 CFR 1910.1200) and the Supplier Notification Requirements of SARA Title III, Section 313. An information sheet that provides detailed sections of information on products produced at Steelscape facilities.

Secondary Product: Steelscape products that do not meet our quality standards for “prime” material. Our Secondary products are classified according to the severity of the defect that prevented the “prime” classification. (see “Non-Prime”)

Securing Coil, Tarping: A process of applying protective covering to shield finished product from dirt and moisture during transit.

Securing Coil, Chaining: A process of applying chains to secure coils to a truck bed according to department of transportation specifications. Chains are applied with edge protectors to prevent damage to coils during transit.

Ship-to Address: The physical location where a customer order is to be delivered. This location can be a final destination or another processing facility. Specification of ship-to addresses are subject to the terms and conditions identified in Section 4.20 of this manual.

Silicone Modified Polyester (SMP): Silicon modified polyesters were developed to improve the exterior durability of early polyester resin paint systems. Early silicon modified polyester contained up to 50% silicon resin, however current versions contain less silicon as resin technology improves.

Skin Passing (Also Surface Conditioning): An in-line rolling process on both ZINCALUME® and TruZinc® steel processing lines that provides an extra smooth surface on the metallic coating. Skin passing is a must for painted products.

Slitting: Dividing a master coil into several narrower multiples.

Spangle: A term describing the finished appearance of TruZinc and ZINCALUME steels, produced with the hot-dipped process. Spangle is often referred to as minimized, regular or spangle-free. Steelscape only offers spangle-free on TruZinc steel and minimized spangle on ZINCALUME steel.

Strain Damage: Aging which occurs subsequent to the cold working of an alloy. Strain damage in steel is predominantly due to the presence of uncombined nitrogen and results in a marked decrease in ductility.

Strip Thickness: The total coated thickness (includes metallic coating) of a strip or coil.

Strip Width: The width of the strip as measured edge to edge, perpendicular to the rolling direction of a strip or coil.

Structural Steel: Steel grades specified to meet certain ASTM load requirements ranging from 33-80ksi.

Surface Conditioning: See Skin Passing.

Tagged Defect: A small defect found in the middle of a coil and identified with a specific tag.

Technical Service: Group of metallurgical and organic coating specialists within the Steelscape Sales Department responsible for supporting customer's technical needs including product performance, end-use applications, claims investigation and resolution, together with technical training.

Tension Leveling: An in-line process on both Steelscape metallic coating lines and the Kalama Pickle Line, which induces tension into the strip in excess of the yield strength. Tension leveling results in a flatter product with improved properties for subsequent forming.

TMW (Theoretical Minimum Weight): Pricing practice that effectively charges per square or lineal foot of material as opposed to by weight. This practice is particularly useful for customers that sell products by the lineal foot and are concerned about yield loss due to variation in the gauge (thickness) of purchased steel. Refer to the SOM section for a complete commercial definition of Steelscape's TMW price policy.

Toll Processed Steel (Also Customer-Owned or Double Bill): Steel that is provided by customers to Steelscape for processing. Offer includes painting, slitting, embossing or cut-to-length. This is a core business for Steelscape.

Transit Damage: Damage incurred to a coil during loading, unloading, and/or transport.

Underweight Coil: A coil that fails to meet the customer's minimum weight requirements.

Urethane Paint: Urethane is the term for the chemical linkage between an isocyanate and a hydroxyl group. A urethane can be a polyester urethane (polyurethane), an acrylic urethane or an epoxy urethane. Most coil urethanes are polyester urethanes usually used in primer applications. Urethanes are characterized by having a good flexibility to hardness ratio and a good chemical resistance.

Ultimate Tensile Strength: Typically, the breaking strength or highest strength achieved for materials.

Yield Strength: Yield strength represents the stress at which materials transition from elastic to plastic deformation. Once a material has been loaded past its yield point, it is permanently deformed.

Water Damage: Corrosion of the product due to the ingress of water or moisture.

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ZINCALUME® Steel Grade Data Sheets

Appendix A

ZINCALUME® Steel Grade CS (Type A)

Grade Data Sheet

General Description

ZINCALUME® Steel Grade CS (Type A) - hot-dip zinc/aluminum alloy-coated profiling steel with a spangled surface and with good ductility. Suitable for bending and moderate forming.

Typical Uses

Roll-formed roofing, rainwater goods and general manufacturing.

Dimensions				
Typical Thickness (Inches)	Maximum .0356"	Typical Width	Maximum 48.5"	
	Minimum .013"		Minimum 28"	
Maximum and minimum thicknesses outside the typical range stated above may be supplied on an inquiry basis only.				
Mechanical Properties		Chemical Composition		
Steel Base	Guaranteed Minimum	Typical	Maximum Percent by Weight	
Longitudinal tensile				
Yield strength, ksi	-	40-60	Carbon (C)	0.10
Tensile strength, ksi	-	50-70	Phosphorus (P)	0.03
Elongation in 2 inch, minimum %	-	20-45	Manganese (Mn)	0.60
Hardness, HRB	-	50-70	Sulfur (S)	0.035
Supply Condition	Standard	Optional	Fabricating Performance (1-Limited to 5-Excellent, NR-Not Recommended)	
Coating class	AZ50	AZ55	Bending	2
Tension leveling	Leveled		Drawing	NR
Surface conditioning	Not Skin-passed	Skin passed, (paint line feed)	Pressing	NR
			Pittsburgh Lock Seam	NR
			Roll-forming	4
			Welding *	5
Chemical treatment	Passivated		Painting **	5
ZINCALUME® Plus	Resin Coated			
Oiling	Not Oiled	Oiled		
Branding	Not Branded			

Optional supply conditions and coating classes may be subject to dimensional restriction.

* Design must allow for some strength reduction near welds.

** Maximum thickness suitable for organic coil coating is 0.0296". Above .0296 to .0356 considered for non-surface critical finish.

ZINCALUME® Steel Grade CS (Type B)

Grade Data Sheet

General Description

ZINCALUME® Steel Grade CS (Type B) - hot-dip zinc/aluminum alloy-coated profiling steel with a spangled surface and with good ductility. Suitable for bending and moderate forming.

Typical Uses

Roll-formed roofing, rainwater goods and general manufacturing.

Dimensions				
Typical Thickness (Inches)	Maximum .0356"	Typical Width	Maximum 48.5"	
	Minimum .013"		Minimum 28"	
Maximum and minimum thicknesses outside the typical range stated above may be supplied on an inquiry basis only.				
Mechanical Properties		Chemical Composition		
Steel Base	Guaranteed Minimum	Typical	Maximum Percent by Weight	
Longitudinal tensile				
Yield strength, ksi	-	40-60	Carbon (C)	0.02-0.15
Tensile strength, ksi	-	50-70	Phosphorus (P)	0.03
Elongation in 2 inch, minimum %	-	20-45	Manganese (Mn)	0.60
Hardness, HRB	-	50-70	Sulfur (S)	0.035
Supply Condition	Standard	Optional	Fabricating Performance (1-Limited to 5-Excellent, NR-Not Recommended)	
Coating class	AZ50	AZ55	Bending	5
Tension leveling	Leveled		Drawing	2
Surface conditioning	Not Skin-passed	Skin passed, (paint line feed)	Pressing	2
			Pittsburgh Lock Seam	5
			Roll-forming	5
Chemical treatment	Passivated		Welding *	5
			Painting **	5
ZINCALUME® Plus	Resin Coated			
Oiling	Not Oiled	Oiled		
Branding	Not Branded			

Optional supply conditions and coating classes may be subject to dimensional restriction.

* Design must allow for some strength reduction near welds.

** Maximum thickness suitable for organic coil coating is 0.0296". Above .0296 to .0356 considered for non-surface critical finish.

ZINCALUME® Steel Grade 33

Grade Data Sheet

General Description

ZINCALUME® Steel Grade 33 - hot-dip zinc/aluminum alloy-coated structural steel with a spangled surface and guaranteed minimum yield strength of 33 ksi with good ductility.

Typical Uses

Roll-formed roofing and siding.

Dimensions				
Typical Thickness (Inches)	Maximum .0356"	Typical Width	Maximum 48.5"	
	Minimum .013"		Minimum 28"	
Maximum and minimum thicknesses outside the typical range stated above may be supplied on an inquiry basis only.				
Mechanical Properties		Chemical Composition		
Steel Base	Guaranteed Minimum	Typical	Maximum Percent by Weight	
Longitudinal tensile*				
Yield strength, ksi	33	40-56	Carbon (C)	0.20
Tensile strength, ksi	45	53-64	Phosphorus (P)	0.04
Elongation in 2 inch, minimum %	20	25-40	Manganese (Mn)	1.35
Hardness, HRB		50-70	Sulfur (S)	0.04
Supply Condition	Standard	Optional	Fabricating Performance (1-Limited to 5-Excellent, NR-Not Recommended)	
Coating class	AZ50	AZ55	Bending	5
Tension leveling	Leveled		Drawing	NR
Surface conditioning	Not Skin-passed	Skin passed, (paint line feed)	Pressing	NR
			Pittsburgh Lock Seam	NR
			Roll-forming	5
Chemical treatment	Passivated		Welding **	5
		Painting ***	5	
ZINCALUME® Plus	Resin Coated			
Oiling	Not Oiled	Oiled		
Branding	Not Branded			

Optional supply conditions and coating classes may be subject to dimensional restriction.

* Strength for Melted and Poured in USA or High Recycled Content steel may be higher, on average 5-10 ksi.

** Design must allow for some strength reduction near welds.

*** Maximum thickness suitable for organic coil coating is 0.0296". Above .0296 to .0356 considered for non-surface critical finish.

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ZINCALUME® Steel Grade 37

Grade Data Sheet

General Description

ZINCALUME® Steel Grade 37 - hot-dip zinc/aluminum alloy-coated structural steel with a spangled surface and guaranteed minimum yield strength of 37 ksi with good ductility.

Typical Uses

Roll-formed roofing and siding.

Dimensions				
Typical Thickness (Inches)	Maximum .0356"	Typical Width	Maximum 48.5"	
	Minimum .013"		Minimum 28"	
Maximum and minimum thicknesses outside the typical range stated above may be supplied on an inquiry basis only.				
Mechanical Properties		Chemical Composition		
Steel Base	Guaranteed Minimum	Typical	Maximum Percent by Weight	
Longitudinal tensile				
Yield strength, ksi	37	39-59	Carbon (C)	0.20
Tensile strength, ksi	52	54-67	Phosphorus (P)	0.10
Elongation in 2 inch, minimum %	18	20-40	Manganese (Mn)	1.35
Hardness, HRB		50-70	Sulfur (S)	0.04
Supply Condition	Standard	Optional	Fabricating Performance (1-Limited to 5-Excellent, NR-Not Recommended)	
Coating class	AZ50	AZ55	Bending	5
Tension leveling	Leveled		Drawing	NR
Surface conditioning	Not Skin-passed	Skin passed, (paint line feed)	Pressing	NR
			Pittsburgh Lock Seam	NR
			Roll-forming	5
Chemical treatment	Passivated		Welding **	5
			Painting ***	5
ZINCALUME® Plus	Resin Coated			
Oiling	Not Oiled	Oiled		
Branding	Not Branded			

Optional supply conditions and coating classes may be subject to dimensional restriction.

* Strength for Melted and Poured in USA or High Recycled Content steel may be higher, on average 5-10 ksi.

** Design must allow for some strength reduction near welds.

*** Maximum thickness suitable for organic coil coating is 0.0296". Above .0296 to .0356 considered for non-surface critical finish.

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ZINCALUME® Steel Grade 40

Grade Data Sheet

General Description

ZINCALUME® Steel Grade 40 - hot-dip zinc/aluminum alloy-coated structural steel with a spangled surface and guaranteed minimum yield strength of 40 ksi with good ductility.

Typical Uses

Roll-formed roofing and siding.

Dimensions				
Typical Thickness (Inches)	Maximum .0356"	Typical Width	Maximum 48.5"	
	Minimum .012"		Minimum 28"	
Maximum and minimum thicknesses outside the typical range stated above may be supplied on an inquiry basis only.				
Mechanical Properties		Chemical Composition		
Steel Base	Guaranteed Minimum	Typical	Maximum Percent by Weight	
Longitudinal tensile*				
Yield strength, ksi	40	42-55	Carbon (C)	0.25
Tensile strength, ksi	55	55-68	Phosphorus (P)	0.10
Elongation in 2 inch, minimum %	16	26-40	Manganese (Mn)	1.35
Hardness, HRB		50-70	Sulfur (S)	0.04
Supply Condition	Standard	Optional	Fabricating Performance (1-Limited to 5-Excellent, NR-Not Recommended)	
Coating class	AZ50	AZ55	Bending	5
Tension leveling	Leveled		Drawing	NR
Surface conditioning	Not Skin-passed	Skin passed, (paint line feed)	Pressing	NR
			Pittsburgh Lock Seam	NR
			Roll-forming	5
Chemical treatment	Passivated		Welding **	5
		Painting ***	5	
ZINCALUME® Plus	Resin Coated			
Oiling	Not Oiled	Oiled		
Branding	Not Branded			

Optional supply conditions and coating classes may be subject to dimensional restriction.

* Strength for Melted and Poured in USA or High Recycled Content steel may be higher, on average 5-10 ksi.

** Design must allow for some strength reduction near welds.

*** Maximum thickness suitable for organic coil coating is 0.0296". Above .0296 to .0356 considered for non-surface critical finish.

ZINCALUME® Steel Grade 50 (Class 1)

Grade Data Sheet

General Description

ZINCALUME® Steel Grade 50 (Class 1) - hot-dip zinc/aluminum alloy-coated structural steel with a spangled surface and guaranteed minimum yield strength of 50 ksi with good ductility.

Typical Uses

Roll-formed roofing and siding.

Dimensions				
Typical Thickness (Inches)	Maximum .0296"	Typical Width	Maximum 48.5"	
	Minimum .018"		Minimum 28"	
Maximum and minimum thicknesses outside the typical range stated above may be supplied on an inquiry basis only.				
Mechanical Properties		Chemical Composition		
Steel Base	Guaranteed Minimum	Typical	Maximum Percent by Weight	
Longitudinal tensile*				
Yield strength, ksi	50	50-65	Carbon (C)	0.25
Tensile strength, ksi	65	65-75	Phosphorus (P)	0.20
Elongation in 2 inch, minimum %	12	24-35	Manganese (Mn)	1.35
Hardness, HRB		60-80	Sulfur (S)	0.04
Supply Condition	Standard	Optional	Fabricating Performance (1-Limited to 5-Excellent, NR-Not Recommended)	
Coating class	AZ50	AZ55	Bending	3
Tension leveling	Leveled		Drawing	NR
Surface conditioning	Not Skin-passed	Skin passed, (paint line feed)	Pressing	NR
			Pittsburgh Lock Seam	NR
			Roll-forming	5
			Welding **	5
Chemical treatment	Passivated		Painting ***	5
ZINCALUME® Plus	Resin Coated			
Oiling	Not Oiled	Oiled		
Branding	Not Branded			

Optional supply conditions and coating classes may be subject to dimensional restriction.

* Strength for Melted and Poured in USA or High Recycled Content steel may be higher, on average 5-10 ksi.

** Design must allow for some strength reduction near welds.

*** Maximum thickness suitable for organic coil coating is 0.0296"

ZINCALUME® Steel Grade 50 (Class 2)

Grade Data Sheet

General Description

ZINCALUME® Steel Grade 50 (Class 2) - hot-dip zinc/aluminum alloy-coated structural steel with a spangled surface and guaranteed minimum yield strength of 50 ksi with good ductility.

Typical Uses

Roll-formed roofing and siding.

Dimensions				
Typical Thickness (Inches)	Maximum .0296"	Typical Width	Maximum 48.5"	
	Minimum .018"		Minimum 28"	
Maximum and minimum thicknesses outside the typical range stated above may be supplied on an inquiry basis only.				
Mechanical Properties		Chemical Composition		
Steel Base	Guaranteed Minimum	Typical	Maximum Percent by Weight	
Longitudinal tensile*				
Yield strength, ksi	50	50-65	Carbon (C)	0.25
Tensile strength, ksi	-	65-75	Phosphorus (P)	0.20
Elongation in 2 inch, minimum %	12	22-36	Manganese (Mn)	1.35
Hardness, HRB		65-80	Sulfur (S)	0.04
Supply Condition	Standard	Optional	Fabricating Performance (1-Limited to 5-Excellent, NR-Not Recommended)	
Coating class	AZ50	AZ55	Bending	3
Tension leveling	Leveled		Drawing	NR
Surface conditioning	Not Skin-passed	Skin passed, (paint line feed)	Pressing	NR
			Pittsburgh Lock Seam	NR
			Roll-forming	5
Chemical treatment	Passivated		Welding **	5
		Painting ***	5	
ZINCALUME® Plus	Resin Coated			
Oiling	Not Oiled	Oiled		
Branding	Not Branded			

Optional supply conditions and coating classes may be subject to dimensional restriction.

* Strength for Melted and Poured in USA or High Recycled Content steel may be higher, on average 5-10 ksi.

** Design must allow for some strength reduction near welds.

*** Maximum thickness suitable for organic coil coating is 0.0296"

ZINCALUME® Steel Grade 50 (Class 4)

Grade Data Sheet

General Description

ZINCALUME® Steel Grade 50 (Class 4) - hot-dip zinc/aluminum alloy-coated structural steel with a spangled surface and guaranteed minimum yield strength of 50 ksi with good ductility.

Typical Uses

Roll-formed roofing and siding.

Dimensions				
Typical Thickness (Inches)	Maximum .0296"	Typical Width	Maximum 48.5"	
	Minimum .0150"		Minimum 28"	
Maximum and minimum thicknesses outside the typical range stated above may be supplied on an inquiry basis only.				
Mechanical Properties		Chemical Composition		
Steel Base	Guaranteed Minimum	Typical	Maximum Percent by Weight	
Longitudinal tensile*				
Yield strength, ksi	50	50-65	Carbon (C)	0.25
Tensile strength, ksi	60	60-70	Phosphorus (P)	0.20
Elongation in 2 inch, minimum %	12	20-25	Manganese (Mn)	1.35
Hardness, HRB		60-70	Sulfur (S)	0.04
Supply Condition	Standard	Optional	Fabricating Performance (1-Limited to 5-Excellent, NR-Not Recommended)	
Coating class	AZ50	AZ55	Bending	3
Tension leveling	Leveled		Drawing	NR
Surface conditioning	Not Skin-passed	Skin passed, (paint line feed)	Pressing	NR
			Pittsburgh Lock Seam	NR
Roll-forming	5			
Chemical treatment	Passivated		Welding **	5
			Painting ***	5
ZINCALUME® Plus	Resin Coated			
Oiling	Not Oiled	Oiled		
Branding	Not Branded			

Optional supply conditions and coating classes may be subject to dimensional restriction.

* Strength for Melted and Poured in USA or High Recycled Content steel may be higher, on average 5-10 ksi.

** Design must allow for some strength reduction near welds.

*** Maximum thickness suitable for organic coil coating is 0.0296"

ZINCALUME® Steel Grade 80 (Class 1)

Grade Data Sheet

General Description

ZINCALUME® Steel Grade 80 - hot-dip zinc/aluminum alloy-coated structural steel with a spangled surface and guaranteed minimum yield strength of 80 ksi with good ductility.

Typical Uses

Roll-formed roofing and siding.

Dimensions				
Typical Thickness (Inches)	Maximum .0236"	Typical Width	Maximum 48.5"	
	Minimum .012"		Minimum 28"	
Maximum and minimum thicknesses outside the typical range stated above may be supplied on an inquiry basis only.				
Mechanical Properties		Chemical Composition		
Steel Base	Guaranteed Minimum	Typical	Maximum Percent by Weight	
Longitudinal tensile*				
Yield strength, ksi	80	80-120	Carbon (C)	0.20
Tensile strength, ksi	82	90-120	Phosphorus (P)	0.04
Elongation in 2 inch, minimum %	-	0-10	Manganese (Mn)	1.35
Hardness, HRB		85-99	Sulfur (S)	0.04
Supply Condition	Standard	Optional	Fabricating Performance (1-Limited to 5-Excellent, NR-Not Recommended)	
Coating class	AZ50	AZ55	Bending	2
Tension leveling	Leveled		Drawing	NR
Surface conditioning	Not Skin-passed	Skin passed, (paint line feed)	Pressing	NR
			Pittsburgh Lock Seam	NR
			Roll-forming	4
Chemical treatment	Passivated		Welding **	5
			Painting ***	5
ZINCALUME® Plus	Resin Coated			
Oiling	Not Oiled	Oiled		
Branding	Not Branded			

Optional supply conditions and coating classes may be subject to dimensional restriction.

* Strength for Melted and Poured in USA or High Recycled Content steel may be higher, on average 5-10 ksi.

** Design must allow for some strength reduction near welds.

*** Maximum thickness suitable for organic coil coating is 0.0236"

TruZinc® Steel Grade Data Sheets

Appendix B

TruZinc® Steel Grade CS (Type A)

Grade Data Sheet

General Description

TruZinc® Steel Grade CS (Type A) - hot-dip zinc coated commercial steel with a zero spangle surface and with good ductility. Suitable for bending and moderate forming.

Typical Uses

Roll-formed roofing, rainwater goods, HVAC and general manufacturing.

Dimensions				
Typical Thickness (Inches)	Maximum .039"	Typical Width	Maximum 48.9"	
	Minimum .012"		Minimum 28"	
Maximum and minimum thicknesses outside the typical range stated above may be supplied on an inquiry basis only.				
Mechanical Properties		Chemical Composition		
Steel Base	Guaranteed Minimum	Typical	Maximum Percent by Weight	
Longitudinal tensile				
Yield strength, ksi	-	35-57	Carbon (C)	0.10
Tensile strength, ksi	-	53-65	Phosphorus (P)	0.030
Elongation in 2 inch, minimum %	-	25-40	Manganese (Mn)	0.60
Hardness, HRB	-	50-67	Sulfur (S)	0.035
Supply Condition	Standard	Optional	Fabricating Performance (1-Limited to 5-Excellent, NR-Not Recommended)	
Coating class	G40, G60	G30, G90	Bending	5
Tension leveling	Leveled		Drawing	2
Surface conditioning	Not Skin-passed	Skin passed, (paint line feed)	Pressing	2
			Pittsburgh Lock Seam	5
			Roll-forming	5
Chemical treatment	Passivated	Not Passivated	Welding *	5
TruZinc Plus	Resin Coated		Painting **	5
Oiling	Not Oiled	Oiled		
Branding	Not Branded			

Optional supply conditions and coating classes may be subject to dimensional restriction.

* Design must allow for some strength reduction near welds.

** Thickness range suitable for organic coil coating is 0.0140" to 0.0359"

TruZinc® Steel Grade CS (Type B)

Grade Data Sheet

General Description

TruZinc® Steel Grade CS (Type B) - hot-dip zinc coated commercial steel with a zero spangle surface and with good ductility. Suitable for bending and moderate forming.

Typical Uses

Roll-formed roofing, rainwater goods, HVAC and general manufacturing.

Dimensions				
Typical Thickness (Inches)	Maximum .039"	Typical Width	Maximum 48.9"	
	Minimum .012"		Minimum 28"	
Maximum and minimum thicknesses outside the typical range stated above may be supplied on an inquiry basis only.				
Mechanical Properties		Chemical Composition		
Steel Base	Guaranteed Minimum	Typical	Maximum Percent by Weight	
Longitudinal tensile				
Yield strength, ksi	-	35-57	Carbon (C)	0.02-0.15
Tensile strength, ksi	-	53-65	Phosphorus (P)	0.030
Elongation in 2 inch, minimum %	-	25-40	Manganese (Mn)	0.60
Hardness, HRB	-	50-67	Sulfur (S)	0.035
Supply Condition	Standard	Optional	Fabricating Performance (1-Limited to 5-Excellent, NR-Not Recommended)	
Coating class	G40, G60	G30, G90	Bending	5
Tension leveling	Leveled		Drawing	2
Surface conditioning	Not Skin-passed	Skin passed, (paint line feed)	Pressing	2
			Pittsburgh Lock Seam	5
			Roll-forming	5
Chemical treatment	Passivated	Not Passivated	Welding *	5
TruZinc Plus	Resin Coated		Painting **	5
Oiling	Not Oiled	Oiled		
Branding	Not Branded			

Optional supply conditions and coating classes may be subject to dimensional restriction.

* Design must allow for some strength reduction near welds.

** Thickness range suitable for organic coil coating is 0.0140" to 0.0359"

TruZinc® Steel Grade 33

Grade Data Sheet

General Description

TruZinc® Steel Grade 33 - hot-dip zinc coated structural steel with a zero spangle surface and guaranteed minimum yield strength of 33 ksi with good ductility.

Typical Uses

Roll-formed roofing, siding and steel studs.

Dimensions				
Typical Thickness (Inches)	Maximum .039"	Typical Width	Maximum 48.9"	
	Minimum .012"		Minimum 28"	
Maximum and minimum thicknesses outside the typical range stated above may be supplied on an inquiry basis only.				
Mechanical Properties		Chemical Composition		
Steel Base	Guaranteed Minimum	Typical	Maximum Percent by Weight	
Longitudinal tensile*				
Yield strength, ksi	33	37-50	Carbon (C)	0.20
Tensile strength, ksi	45	49-62	Phosphorus (P)	0.04
Elongation in 2 inch, minimum %	20	20-46	Manganese (Mn)	1.35
Hardness, HRB		53-65	Sulfur (S)	0.04
Supply Condition	Standard	Optional	Fabricating Performance (1-Limited to 5-Excellent, NR-Not Recommended)	
Coating class	G40, G60	G30, G90	Bending	5
Tension leveling	Leveled		Drawing	NR
Surface conditioning	Not Skin-passed	Skin passed, (paint line feed)	Pressing	NR
			Pittsburgh Lock Seam	NR
			Roll-forming	5
Chemical treatment	Passivated	Not Passivated	Welding **	5
			Painting ***	5
TruZinc® Plus	Resin Coated	Oiled		
Oiling	Not Oiled			
Branding	Not Branded			

Optional supply conditions and coating classes may be subject to dimensional restriction.

* Strength for Melted and Poured in USA or High Recycled Content steel may be higher, on average 5-10 ksi

** Design must allow for some strength reduction near welds.

** Thickness range suitable for organic coil coating is 0.0140" to 0.0359"

TruZinc® Steel Grade 37

Grade Data Sheet

General Description

TruZinc® Steel Grade 37 - hot-dip zinc coated structural steel with a zero spangle surface and guaranteed minimum yield strength of 37 ksi with good ductility.

Typical Uses

Roll-formed roofing, siding and steel studs.

Dimensions				
Typical Thickness (Inches)	Maximum .039"	Typical Width	Maximum 48.9"	
	Minimum .012"		Minimum 28"	
Maximum and minimum thicknesses outside the typical range stated above may be supplied on an inquiry basis only.				
Mechanical Properties		Chemical Composition		
Steel Base	Guaranteed Minimum	Typical	Maximum Percent by Weight	
Longitudinal tensile*				
Yield strength, ksi	37	44-50	Carbon (C)	0.20
Tensile strength, ksi	52	58-63	Phosphorus (P)	0.10
Elongation in 2 inch, minimum %	18	35-42	Manganese (Mn)	1.35
Hardness, HRB		60-70	Sulfur (S)	0.04
Supply Condition	Standard	Optional	Fabricating Performance (1-Limited to 5-Excellent, NR-Not Recommended)	
Coating class	G40, G60	G30, G90	Bending	5
Tension leveling	Leveled		Drawing	NR
Surface conditioning	Not Skin-passed	Skin passed, (paint line feed)	Pressing	NR
			Pittsburgh Lock Seam	NR
			Roll-forming	5
Chemical treatment	Passivated	Not Passivated	Welding **	5
			Painting ***	5
TruZinc® Plus	Resin Coated			
Oiling	Not Oiled	Oiled		
Branding	Not Branded			

Optional supply conditions and coating classes may be subject to dimensional restriction.

* Strength for Melted and Poured in USA or High Recycled Content steel may be higher, on average 5-10 ksi

** Design must allow for some strength reduction near welds.

** Thickness range suitable for organic coil coating is 0.0140" to 0.0359"

TruZinc® Steel Grade 40

Grade Data Sheet

General Description

TruZinc® Steel Grade 40 - hot-dip zinc coated structural steel with a zero spangle surface and guaranteed minimum yield strength of 40 ksi with good ductility.

Typical Uses

Roll-formed roofing, siding and steel studs.

Dimensions				
Typical Thickness (Inches)	Maximum .039"	Typical Width	Maximum 48.9"	
	Minimum .012"		Minimum 28"	
Maximum and minimum thicknesses outside the typical range stated above may be supplied on an inquiry basis only.				
Mechanical Properties			Chemical Composition	
Steel Base	Guaranteed Minimum	Typical	Maximum Percent by Weight	
Longitudinal tensile*				
Yield strength, ksi	40	40-51	Carbon (C)	0.25
Tensile strength, ksi	55	55-63	Phosphorus (P)	0.10
Elongation in 2 inch, minimum %	16	20-45	Manganese (Mn)	1.35
Hardness, HRB		51-66	Sulfur (S)	0.04
Supply Condition	Standard	Optional	Fabricating Performance (1-Limited to 5-Excellent, NR-Not Recommended)	
Coating class	G40, G60	G30, G90	Bending	5
Tension leveling	Leveled		Drawing	NR
Surface conditioning	Not Skin-passed	Skin passed, (paint line feed)	Pressing	NR
			Pittsburgh Lock Seam	NR
			Roll-forming	5
Chemical treatment	Passivated	Not Passivated	Welding **	5
			Painting ***	5
TruZinc® Plus	Resin Coated			
Oiling	Not Oiled	Oiled		
Branding	Not Branded			

Optional supply conditions and coating classes may be subject to dimensional restriction.

* Strength for Melted and Poured in USA or High Recycled Content steel may be higher, on average 5-10 ksi

** Design must allow for some strength reduction near welds.

** Thickness range suitable for organic coil coating is 0.0140" to 0.0359"

TruZinc® Steel Grade 50 (Class 1) Grade Data Sheet

General Description

TruZinc® Steel Grade 50 (Class 1) - hot-dip zinc coated structural steel with a zero spangle surface and guaranteed minimum yield strength of 50 ksi with good ductility.

Typical Uses

Roll-formed roofing and decking.

Dimensions					
Typical Thickness (Inches)		Maximum .039"		Typical Width	Maximum 48.9"
		Minimum .019"		Minimum 28"	
Maximum and minimum thicknesses outside the typical range stated above may be supplied on an inquiry basis only.					
Mechanical Properties			Chemical Composition		
Steel Base	Guaranteed Minimum	Typical <.017" >.017" BMT BMT		Maximum Percent by Weight	
Longitudinal tensile*					
Yield strength, ksi	50	50-60	50-60	Carbon (C)	0.25
Tensile strength, ksi	65	65-70	67-73	Phosphorus (P)	0.20
Elongation in 2 inch, minimum %	12	20-40	20-40	Manganese (Mn)	1.35
Hardness, HRB		65-75	65-75	Sulfur (S)	0.04
Supply Condition	Standard	Optional		Fabricating Performance (1-Limited to 5-Excellent, NR-Not Recommended)	
Coating class	G40, G60	G30, G90		Bending	3
Tension leveling	Leveled			Drawing	NR
Surface conditioning	Not Skin-passed	Skin passed, (paint line feed)		Pressing	NR
				Pittsburgh Lock Seam	NR
				Roll-forming	5
				Welding **	5
Chemical treatment	Passivated	Not Passivated		Painting ***	5
TruZinc Plus	Resin Coated				
Oiling	Not Oiled	Oiled			
Branding	Not Branded				

Optional supply conditions and coating classes may be subject to dimensional restriction.

* Strength for Melted and Poured in USA or High Recycled Content steel may be higher, on average 5-10 ksi

** Design must allow for some strength reduction near welds.

*** Thickness range suitable for organic coil coating is 0.0157" to 0.0359"

TruZinc® Steel Grade 50 (Class 2)

Grade Data Sheet

General Description

TruZinc® Steel Grade 50 (Class 2) - hot-dip zinc coated structural steel with a zero spangle surface and guaranteed minimum yield strength of 50 ksi with good ductility.

Typical Uses

Roll-formed roofing and siding.

Dimensions					
Typical Thickness (Inches)	Maximum .039"	Typical Width	Maximum 48.9"		
	Minimum .0157"		Minimum 28"		
Maximum and minimum thicknesses outside the typical range stated above may be supplied on an inquiry basis only.					
Mechanical Properties			Chemical Composition		
Steel Base	Guaranteed Minimum	Typical <.017" >.017" BMT BMT	Maximum Percent by Weight		
Longitudinal tensile*					
Yield strength, ksi	50	50-65 50-65	Carbon (C)		0.20
Tensile strength, ksi	-	60-73 65-75	Phosphorus (P)		0.10
Elongation in 2 inch, minimum %	12	15-40 15-40	Manganese (Mn)		1.35
Hardness, HRB		56-70 64-75	Sulfur (S)		0.04
Supply Condition	Standard	Optional	Fabricating Performance (1-Limited to 5-Excellent, NR-Not Recommended)		
Coating class	G40, G60	G30, G90	Bending		3
Tension leveling	Leveled		Drawing		NR
Surface conditioning	Not Skin-passed	Skin passed, (paint line feed)	Pressing		NR
			Pittsburgh Lock Seam		NR
			Roll-forming		5
			Welding **		5
Chemical treatment	Passivated	Not Passivated	Painting ***		5
TruZinc Plus	Resin Coated				
Oiling	Not Oiled	Oiled			
Branding	Not Branded				

Optional supply conditions and coating classes may be subject to dimensional restriction.

* Strength for Melted and Poured in USA or High Recycled Content steel may be higher, on average 5-10 ksi

** Design must allow for some strength reduction near welds.

** Thickness range suitable for organic coil coating is 0.0157" to 0.0359"

TruZinc® Steel Grade 50 (Class 4)

Grade Data Sheet

General Description

TruZinc® Steel Grade 50 (Class 4) - hot-dip zinc coated structural steel with a zero spangle surface and guaranteed minimum yield strength of 50 ksi with good ductility.

Typical Uses

Roll-formed roofing and siding.

Dimensions						
Typical Thickness (Inches)		Maximum .039"		Typical Width	Maximum 48.9"	
		Minimum .0157"		Minimum 28"		
Maximum and minimum thicknesses outside the typical range stated above may be supplied on an inquiry basis only.						
Mechanical Properties			Chemical Composition			
Steel Base		Guaranteed Minimum	Typical <.017" >.017" BMT BMT		Maximum Percent by Weight	
Longitudinal tensile*						
Yield strength, ksi		50	50-60	50-61	Carbon (C)	0.25
Tensile strength, ksi		-	60-73	65-75	Phosphorus (P)	0.20
Elongation in 2 inch, minimum %		12	26-32	23-31	Manganese (Mn)	1.35
Hardness, HRB			56-70	64-75	Sulfur (S)	0.04
Supply Condition		Standard	Optional		Fabricating Performance (1-Limited to 5-Excellent, NR-Not Recommended)	
Coating class		G40, G60	G30, G90		Bending	3
Tension leveling		Leveled			Drawing	NR
Surface conditioning		Not Skin-passed	Skin passed, (paint line feed)		Pressing	NR
					Pittsburgh Lock Seam	NR
					Roll-forming	5
					Welding **	5
Chemical treatment	Passivated	Not Passivated		Painting ***	5	
TruZinc Plus	Resin Coated					
Oiling	Not Oiled	Oiled				
Branding	Not Branded					

Optional supply conditions and coating classes may be subject to dimensional restriction.

* Strength for Melted and Poured in USA or High Recycled Content steel may be higher, on average 5-10 ksi

** Design must allow for some strength reduction near welds.

** Thickness range suitable for organic coil coating is 0.0157" to 0.0359"

TruZinc® Steel Grade 80 (Class 1)

Grade Data Sheet

General Description

TruZinc® Steel Grade 80 (Class 1) - hot-dip zinc coated structural steel with a zero spangle surface and guaranteed minimum yield strength of 80 ksi with good ductility.

Typical Uses

Roll-formed roofing and decking.

Dimensions				
Typical Thickness (Inches)	Maximum .0249"	Typical Width	Maximum 48.9"	
	Minimum .012"		Minimum 28"	
Maximum and minimum thicknesses outside the typical range stated above may be supplied on an inquiry basis only.				
Mechanical Properties		Chemical Composition		
Steel Base	Guaranteed Minimum	Typical	Maximum Percent by Weight	
Longitudinal tensile*				
Yield strength, ksi	80	83-117	Carbon (C)	0.20
Tensile strength, ksi	82	88-120	Phosphorus (P)	0.04
Elongation in 2 inch, minimum %	-	-	Manganese (Mn)	1.35
Hardness, HRB		85-99	Sulfur (S)	0.04
Supply Condition	Standard	Optional	Fabricating Performance (1-Limited to 5-Excellent, NR-Not Recommended)	
Coating class	G40, G60	G30, G90	Bending	2
Tension leveling	Leveled		Drawing	NR
Surface conditioning	Not Skin-passed	Skin passed, (paint line feed)	Pressing	NR
			Pittsburgh Lock Seam	NR
			Roll-forming	4
			Welding **	5
Chemical treatment	Passivated	Not Passivated	Painting ***	5
TruZinc Plus	Resin Coated			
Oiling	Not Oiled	Oiled		
Branding	Not Branded			

Optional supply conditions and coating classes may be subject to dimensional restriction.

* Strength for Melted and Poured in USA or High Recycled Content steel may be higher, on average 5-10 ksi

** Design must allow for some strength reduction near welds.

** Thickness range suitable for organic coil coating is 0.0140" to 0.0249"