

3塗3烤彩色烤漆線 製品規範表

Production Table For 3 Coating 3 Baking Pre-Painted Color Coating Line

3塗3烤彩色烤漆線(PPGI / PPGL)製品規範表

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規格種類 Specification				製造厚度 (mm) Production thickness	製造寬度 (mm) Production width	用途 Material Grade
JIS	ASTM	EN	AS			
G3312 G3322	A755(M)	10169	2728	0.20 ≤ T ≤ 1.00	600 ≤ W ≤ 1350	一般、成型用 CS (Commercial Steel) CQ (Commercial Quality) FS (Forming Steel)
CGCC CGLCC	CS(A、B、C) FS(A、B)	DX51D	G1.G250			
CGC340 ---	SS33(230) SS37(255)	S250GD	---	0.30 ≤ T ≤ 1.00	600 ≤ W ≤ 1350	結構用 SS (Structural Steel) SQ (Structural Quality)
CGC400 CGLC400	SS40(275)	S280GD	G300	0.30 ≤ T ≤ 1.00	600 ≤ W ≤ 1350	
CGC 440 CGLC400	SS50(340)	S320GD	G350	0.30 ≤ T ≤ 1.00	600 ≤ W ≤ 1350	
CGC 490 CGLC490	SS55 (380) SS60 (410)	---	G450	0.30 ≤ T ≤ 1.00	600 ≤ W ≤ 1350	
CGC 570 CGCH CGLC570	SS80(550)	S550GD	G550	①0.20 ≤ T < 0.45 ②0.45 ≤ T ≤ 1.00	①600 ≤ W < 1350 ②600 ≤ W ≤ 1255	全硬板 FH (Full Hard)
CGCD1 CGLCD	DDS TYPE C	DX52D	G3	0.40 ≤ T ≤ 1.00	600 ≤ W ≤ 1350	深衝級用 (Deep Drawing)
塗裝膜厚 Coating Thickness	(1)正面漆一道塗裝最大膜厚 65 μ (Primer+Top Max Coating Thickness 1pass) (2)背面漆一道塗裝最大膜厚 40 μ (Primer+Back Max Coating Thickness 1pass)					
塗料種類 Paint Type	(1)PE : (2)PU : (3)SMP : (4)PVDF : (5)EPOXY					

備註
Remark

- (1) 厚度、寬度、平坦度 等之公差容許範圍，依 JIS G 3312/G3322、ASTM A924(M)、EN 10169 及 AS 2728 之要求。
- (2) 鋼捲內徑 (Inner dia.) 為 508 或 610mm；外徑最大容許值 (Outer dia.) 為 2000mm；最大鋼捲單重 (Weight Max.) 為 10 tons。
- (3) 鋼 / 紙套筒使用規定：
 - a. 外銷 coil 厚度低於 0.3mm 以下，使用 4mm 鋼套筒 (Sleeve) 或 25mm 紙套筒。
 - b. 內銷 coil 厚度 ≤ 0.28 使用鐵套筒，若有分切時，可使用 6mm 紙套筒替代。
- (4) 若客戶於規範外要求加紙套筒或鐵套筒需個別詢問。
- (5) 不在上述範圍之產品：
如尺寸、鍍層、規格等，請以個案諮詢，專案開發方式討論進行。
- (6) 一般常態樣品：指生產單位討論決議後，所提供之樣品。
- (7) 若首次接單之規格，如尺寸、鍍層、規格等，請以小量測試訂單試產 50 噸以下為原則。

- (1) The tolerance range of thickness, width, flatness and ...etc must meet JIS G3312/G3322, ASTM A924(M), EN10169 and AS 2728 requirements.
- (2) Coil I.D: Either 508mm or 610mm, O.D(Max.) :2000mm, Weight(Single coil): 10 tons.
- (3) Steel sleeve usage:
 - a. Coils for export use (thickness ≤ 0.3 mm), use 4mm steel sleeve or 25mm paper sleeve.
 - b. Coils for domestic use (Substrate thickness ≤ 0.28 mm), use steel sleeve.
For cutted coil, use 6mm paper sleeve.
- (4) Please inquiry if need to apply paper sleeve or steel sleeve.
- (5) The product is not on the above table will be handled as a special case.
- (6) General sample: Defined as a sample which provided by production Dept.
- (7) It is recommended to place a running test order if any primary size, coating mass, specification. (Q'ty: less than 50 tons)