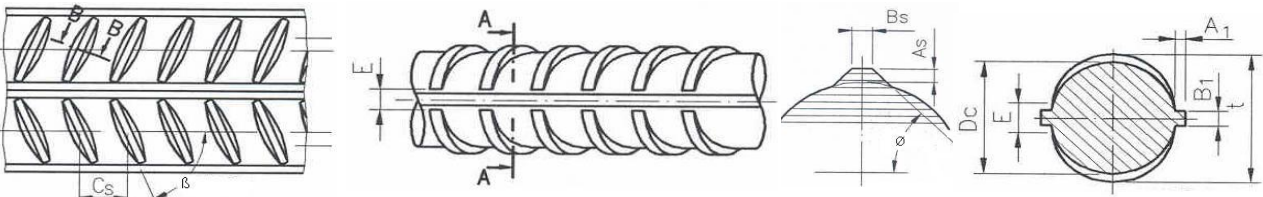


RIB GEOMETRY



DEFORMATION REQUIREMENTS

		8	10	12	14	16	18	20	22	24	25	26	28	30	32	40	EXPLANATIONS	
Cross sectional area (mm <sup>2</sup> )		50.3	78.5	113.0	153.9	201.0	254.5	314.0	380.1	452.4	491.0	530.9	615.8	706.9	804.0	1257.0	(Table: 8)	
Unit Weight (kg/m)	min	0.371	0.589	0.848	1.154	1.51	1.91	2.36	2.85	3.39	3.68	3.98	4.62	5.30	6.03	9.42	±6.0% for 8 mm ±4.5% for more than 8 mm (Table: 7)	
	nom	0.395	0.617	0.888	1.208	1.58	2.00	2.47	2.98	3.55	3.85	4.17	4.83	5.55	6.31	9.86		
	max	0.418	0.644	0.928	1.263	1.65	2.09	2.58	3.12	3.71	4.02	4.36	5.05	5.80	6.59	10.30		
Transversal rib height	As	min	0.24	0.30	0.36	0.42	0.48	0.54	0.60	0.66	0.72	0.75	0.78	0.84	0.90	0.96	1.20	(Table: 8)
	max	1.20	1.50	1.80	2.10	2.40	2.70	3.00	3.30	3.60	3.75	3.90	4.20	4.50	4.80	6.00		
Transversal rib width	Bs	min																
	max																	
Transversal rib space	Cs	min	3.20	4.00	4.80	5.60	6.40	7.20	8.00	8.80	9.60	10.00	10.40	11.20	12.00	12.80	16.00	(Table: 8)
	max	9.60	12.00	14.40	16.80	19.20	21.60	24.00	26.40	28.80	30.00	31.20	33.60	36.00	38.40	48.00		
Rib-Tip distance	E	min															Sec.7.4.2.2	
	max	3.1	3.9	4.7	5.5	6.3	7.1	7.9	8.6	9.4	9.8	10.2	11.0	11.8	12.6	15.7		
Longitudinal rib height	A1	min															Sec.7.4.2.3	
	max	0.80	1.00	1.20	1.40	1.60	1.80	2.00	2.20	2.40	2.50	2.60	2.80	3.00	3.20	4.00		
Longitudinal Rib Width	B1	min																
	max																	
Rib slope	β	min	35°	35°	35°	35°	35°	35°	35°	35°	35°	35°	35°	35°	35°	35°	(Table :8)	
	max	75°	75°	75°	75°	75°	75°	75°	75°	75°	75°	75°	75°	75°	75°	75°		
Rib angle	Ø	min	45°	45°	45°	45°	45°	45°	45°	45°	45°	45°	45°	45°	45°	45°	Sec.7.4.2.2	
	max																	
Rib Area (mm <sup>2</sup> )	Fr	min	0.040	0.040	0.040	0.056	0.056	0.056	0.056	0.056	0.056	0.056	0.056	0.056	0.056	0.056	(Table: 9)	
	max																	
Diameter of mandrel for bend (mm)		4d	4d	4d	4d	4d	7d	7d	7d	7d	7d	7d	7d	7d	7d	7d	≥90° bend, wait 60-75 min at 90-110°C . Cooling on air, ≥20° rebend	
Diameter of mandrel for re-bend (mm)		4d	4d	4d	4d	4d	7d	7d	7d	7d	7d	7d	7d	7d	7d	7d		

MECHANICAL REQUIREMENTS

CHEMICAL REQUIREMENTS

			EXPLANATIONS								EXPLANATIONS							
Yield Strength	R <sub>e</sub>	MPa	min	500	(Upper Yield Point)				Heat %	Product %	Heat %	Product %						
			max	650														
Tensile Strength	R <sub>m</sub>	MPa	min						C	min	P	min	50	55				
			max												0,0	max	22	24
Rm / Re			min	1.08					Si	min	S	min	50	55				
			max												0,0	max		
Uniform elongation	A <sub>5</sub>	%	min						Mn	min	N	min	12	14				
			max												0,0	max		
Elongation to fracture	A <sub>gt</sub>	%	min	5					Cu	min	Ce <sub>q</sub>	min	50	52	Ce <sub>q</sub> = C+ (Mn/6) + (Cr+Mo+V)/5 + (Ni+Cu)/15			
			max															

MARKING

