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DILLIMAX TL

High strength fine grained structural steel with close tolerances on dimension and shape

Specification DH-E48-D, edition April 2016[1]

DILLIMAX TL steel plates are delivered with very close tolerances on dimension and shape. These close tolerances are for example necessary for telescopic booms.

Product description

Designation and range of application
This specification can be specified for the following steel grades in addition to the DILLIMAX data sheets of Dillinger or EN 10025-6:

- DILLIMAX 690 B/T/E (S690Q/QL/QL1 gemäß EN 10025-6)
- DILLIMAX 890 B/T/E (S890Q/QL/QL1 gemäß EN 10025 6)
- DILLIMAX 965 B/T/E (S960Q/QL/QL1 gemäß EN 10025-6)
- DILLIMAX 1100

The steel is designated as e.g. DILLIMAX 965 T TL or S960QL TL.
Other specifications may be possible on request.
DILLIMAX TL plates can be delivered in the following dimensions:

Plate thickness t [mm] (in.)[a]	Width B [mm] (in.)[a]	Length L [mm] (in.)[a]
6 (¼) ≤ t < 8 (0.31)[b]	1 000 (39) ≤ B ≤ 2 500 (98)	2 000 (79) ≤ L ≤ 18 000 (708)
8 (0.31) ≤ t < 9.5 (0.37)	1 000 (39) ≤ B ≤ 3 200 (126)[c]	
9.5 (0.37) ≤ t < 15 (0.6)	1 000 (39) ≤ B ≤ 3 300 (130)[d]	
15 (0.6) ≤ t ≤ 25 (1)	1 000 (39) ≤ B ≤ 3 300 (130)[e]	

[a] The approximately converted values in brackets are for information only.
[b] DILLIMAX 1100 for t ≥ 8 mm (0.31 in.)[a]
[c] 3 050 mm (120 in.)[a] for DILLIMAX 890/965 and 2 500 mm (98 in.)[a] for DILLIMAX 1100
[d] 2 500 mm (98 in.)[a] for DILLIMAX 1100
[e] 3 050 mm (120 in.)[a] for DILLIMAX 1100

[1] The current version of this specification can be also found on: www.dillinger.de.

Identification

Unless otherwise agreed, the marking is carried out via steel stamps with at least the following information:

- Steel grade (e.g. DILLIMAX 965 T TL or S960QL TL)
- Heat number
- Number of mother plate and individual plate
- The manufacturer's symbol
- Inspection representative's sign

General technical delivery requirements

Unless otherwise agreed, the general technical delivery requirements in accordance with EN 10021 apply.

Tolerances

Tolerances on nominal plate thickness

For TL plates, the very close thickness range Δ (upper value – lower value) is distributed as given in the following table. Other distributions of the thickness range Δ, e.g. as in EN 10029, can be agreed.

Nominal plate thickness t [mm]	Lower limit of thickness B [mm]	Upper limit of thickness L [mm]
6 ≤ t < 16[a]	-0.2	+0.4
16 ≤ t ≤ 20	-0.3	+0.5
20 < t < 25	-0.3	+0.8

The difference in thickness along the bending line (axis in rolling direction from tip to toe of a plate) does not exceed 0.3 mm (0.012 in.)[2].

Tolerances on width and length

Unless otherwise agreed, the tolerances will be in accordance with EN 10029.

Tolerances on flatness

The following tolerances on flatness apply:

- 3 mm/1 m (0.12 in./3.3 ft)[2] for a corrugation ≤ 1 m (3.3 ft)[2]
- 4 mm/1 m (0.16 in./3.3 ft)[2] for a corrugation > 1 m (3.3 ft)[2] und ≤ 2 m (6.6 ft)[2]
- 5 mm/2 m (0.20 in./6.6 ft)[2] for a corrugation > 2 m (6.6 ft)[2]

A maximum of 2 ripples or corrugations per m (3.3 ft)[2] of plate length is allowed. A ripple or corrugation is defined as a flatness deviation > 1 mm (> 0.04 in.)[2]. The flatness control is carried out on a flat support according to EN 10029 using a 1 m (3.3 ft)[2] or 2 m (6.6 ft)[2] levelling staff.

[2] The approximately converted values in brackets are for information only.

Surface quality

Unless otherwise agreed, the specification will be in accordance with EN 10163-2, class B2.
Steel grid blasting and shop primer can be agreed.

General note

If special requirements, which are not covered in this specification, are to be met by the steel due to its intended use or processing, these requirements are to be agreed before placing the order.
The information in this specification is a product description. This specification is updated at irregular intervals. The current version is relevant. The latest version is available from the mill or as download at www.dillinger.de.

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