



SLOVENSKI STANDARD

SIST EN 10067:1998

01-avgust-1998

Vroče valjano ploščato žmulasto jeklo - Mere, mejni odstopki in tolerance oblik

Hot rolled bulb flats - Dimensions and tolerances on shape, dimensions and mass

Warmgewalzter Wulstflachstahl - Maße, Grenzabmaße und Formtoleranzen

Plats a boudin laminés a chaud - Dimensions et tolérances sur la forme, les dimensions et la masse

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ICS:

77.140.50	Ploščati jekleni izdelki in polizdelki	Flat steel products and semi-products
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en

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EUROPEAN STANDARD

EN 10067

NORME EUROPÉENNE

EUROPÄISCHE NORM

October 1996

ICS 77.140.50; 77.140.60

Descriptors: iron and steel products, hot rolled products, metal bars, flat bars, designation, dimensions, dimensional tolerances, form tolerances

English version

Hot rolled bulb flats - Dimensions and tolerances on shape, dimensions and mass

Plats à boudin laminés à chaud - Dimensions et tolérances sur la forme, les dimensions et la masse

Wärmegewalzter Wulstflachstahl - Maße, Grenzabmaße und Formtoleranzen

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Up-to-date lists and bibliographical references concerning such national standards may be obtained on application to the Central Secretariat or to any CEN member.

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CEN members are the national standards bodies of Austria, Belgium, Denmark, Finland, France, Germany, Greece, Iceland, Ireland, Italy, Luxembourg, Netherlands, Norway, Portugal, Spain, Sweden, Switzerland and United Kingdom.

CEN

European Committee for Standardization
Comité Européen de Normalisation
Europäisches Komitee für Normung

Central Secretariat: rue de Stassart, 36 B-1050 Brussels

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Foreword

This draft European Standard has been prepared by Technical Committee ECISS/TC 11 "Structural steel sections", the secretariat of which is held by BSI.

The discussions within ECISS/TC11 were based on Euronorm 67 (1978).

This European Standard shall be given the status of a national standard, either by publication of an identical text or by endorsement, at the latest by April 1997, and conflicting national standards shall be withdrawn at the latest by April 1997.

According to the CEN/CENELEC Internal Regulations, the national standards organizations of the following countries are bound to implement this European Standard: Austria, Belgium, Denmark, Finland, France, Germany, Greece, Iceland, Ireland, Italy, Luxembourg, Netherlands, Norway, Portugal, Spain, Sweden, Switzerland and the United Kingdom.

1 Scope

This European Standard specifies requirements for the nominal dimensions and tolerances on shape, dimensions and mass of hot rolled bulb flats. These requirements do not apply to bulb flats rolled from stainless steel.

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2 Normative references

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This European Standard incorporates by dated or undated reference provisions from other publications. These normative references are cited at the appropriate places in the text and the publications are listed hereafter. For dated references, subsequent amendments to or revisions of any of these publications apply to this European Standard only when incorporated in it by amendment or revision. For undated references the latest edition of the publication referred to applies.

EN 10079 Definition of steel products

3 Definitions

For the purposes of this European Standard the definitions in EN 10079 apply.

4 Designation

The designation of the hot rolled bulb flats shall comprise:

- 1) the term 'bulb flat'
- 2) the number of this European Standard
- 3) the nominal width b (in mm)
- 4) the nominal thickness t (in mm)

Example: Bulb flat EN 10067-200 x 10.

5 Dimensions

Hot rolled bulb flats complying with this European Standard shall be delivered with the dimensions given in table 1 and illustrated in figure 1.

NOTE: The geometric properties, the data on the cross-section, and the surface area are derived from the nominal dimensions.

6 Tolerances on shape and dimensions

6.1 Width and thickness

The width and thickness tolerances shall be as given in table 2.

The width shall be measured on the longer side of the leg.

6.2 Tolerance for out of squareness of weld edge

The angle by which the weld edge deviates from the vertical (II) shall not exceed 4° (see figure 2).

6.3 Corner radius

The maximum values for the corner radius r_1 shall be as given in table 3.

6.4 Length

6.4.1 Hot rolled bulb flats shall be delivered in lengths up to and including 18 m. Lengths greater than 18 m shall be agreed at the time of ordering.

6.4.2 The length tolerances shall be $^{+100}_{-0}$ mm. Closer length tolerances shall be specially agreed at the time of ordering.

6.5 Straightness

The straightness tolerance q shall be $0,0035 L$. The dimension q shall be measured as illustrated in figure 3 along the entire length L .

7 Tolerance on mass

The mass tolerances shall be:

$\begin{matrix} +6 \\ -2 \end{matrix}$ % of the total mass for deliveries of 5 t or more,

and

$\begin{matrix} +8 \\ -2,7 \end{matrix}$ % of the total mass for deliveries of less than 5t.

The mass deviation shall be the difference between the actual delivery mass and the theoretical mass. The theoretical mass shall be calculated from the data in table 1 and the ordered length in metres.

NOTE: The masses given in table 1 are derived from the sectional areas using a density of 7,85 kg/dm³.

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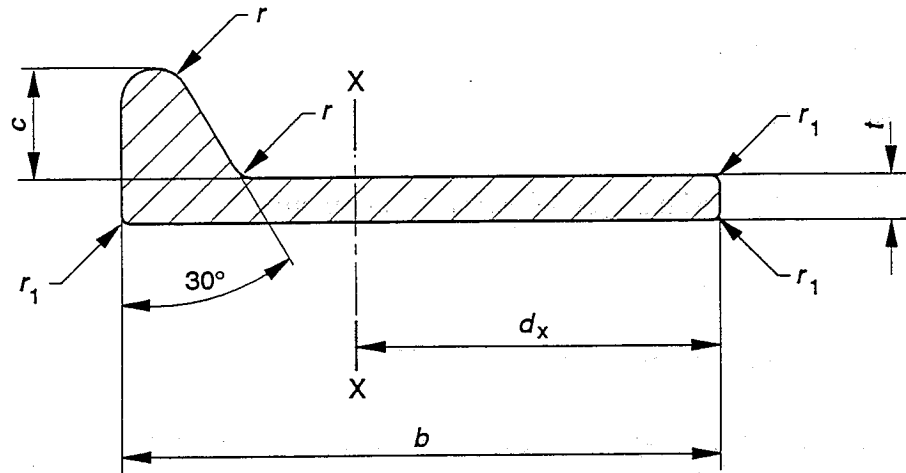


Figure 1: Shape of bulb flat

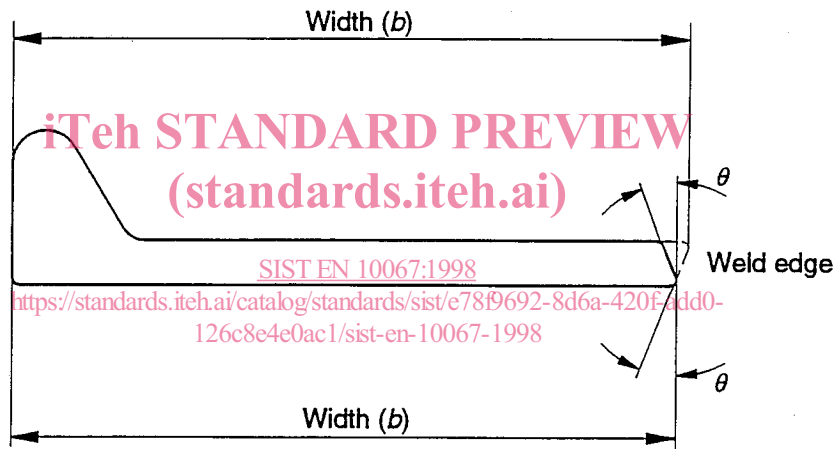


Figure 2: Tolerance for out of squareness of weld edge

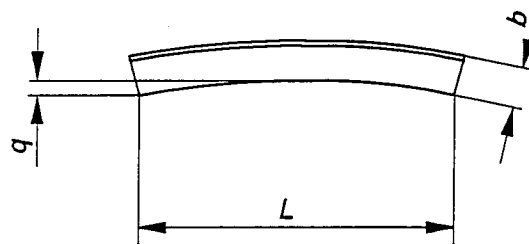


Figure 3: Tolerance on straightness

Table 1: Dimensions, sectional areas, mass/unit length, surface areas and geometric properties of bulb flats

Nominal size	Dimensions for				Area of section A cm ²	Mass/unit length G kg/m	Surface area U m ² /m	Distance to centre of gravity d _x cm	Geometric properties about the x-x axis	
	b (mm)	t (mm)	c (mm)	r (mm)					I _x cm ⁴ moment of inertia	W _x cm ³ elastic modulus
80 x 5 80 x 6	80	5 6	14	4	5,41 6,21	4,25 4,88	0,189 0,191	4,9 4,78	33,87 38,7	6,91 8,1
100 x 7 100 x 8	100	7 8	15,5	4,5	8,74 9,74	6,86 7,65	0,236 0,238	5,87 5,78	85,3 94,3	14,5 16,3
120 x 6 120 x 7 120 x 8	120	6 7 8	17	5	9,32 10,52 11,72	7,32 8,26 9,2	0,276 0,278 0,28	7,21 7,07 6,96	133 149 165	18,5 21 23,6
140 x 7 140 x 8 140 x 10	140	7 8 10	19	5,5	12,43 13,83 16,63	9,75 10,85 13,05	0,32 0,322 0,326	8,32 8,18 7,99	241 266 315	29 32,5 39,5
160 x 7 160 x 8 160 x 9 160 x 11	160	7 8 9 11	22	6	14,6 16,2 17,8 21	11,46 12,72 13,97 16,49	0,365 0,367 0,369 0,373	9,66 9,5 9,37 9,16	373 411 449 522	38,6 43,3 47,9 57
180 x 8 180 x 9 180 x 10 180 x 11	180	8 9 10 11	25	7	18,86 20,66 22,46 24,26	14,8 16,22 17,63 19,04	0,411 0,413 0,415 0,417	10,89 10,73 10,59 10,47	609 664 717 770	55,9 61,8 67,7 73,5
200 x 9 200 x 10 200 x 11 200 x 12	200	9 10 11 12	28	8	23,66 25,66 27,66 29,66	18,57 20,14 21,71 23,28	0,457 0,459 0,461 0,463	12,12 11,96 11,82 11,69	942 1017 1091 1164	77,7 85,1 92,3 99,5
220 x 10 220 x 11 220 x 12	220	10 11 12	31	9	29 31,2 33,4	22,77 24,5 26,22	0,503 0,506 0,507	13,35 13,19 13,04	1396 1496 1595	105 114 122
240 x 10 240 x 11 240 x 12	240	10 11 12	34	10	32,49 34,89 37,29	25,5 27,39 29,27	0,547 0,549 0,551	14,77 14,58 14,42	1865 1997 2127	126 137 148
260 x 10 260 x 11 260 x 12	260	10 11 12	37	11	36,11 38,71 41,31	28,35 30,39 32,43	0,591 0,593 0,596	16,22 16 15,81	2434 2605 2774	150 163 175