



Designation: A 650/A 650M – 98

Standard Specification for Tin Mill Products, Black Plate, Double Reduced¹

This standard is issued under the fixed designation A 650/A 650M; the number immediately following the designation indicates the year of original adoption or, in the case of revision, the year of last revision. A number in parentheses indicates the year of last reapproval. A superscript epsilon (ϵ) indicates an editorial change since the last revision or reapproval.

1. Scope

1.1 This specification covers double-reduced black plate, produced from low-carbon cold-reduced steel, furnished in coils and cut sizes, for use predominantly in the manufacture of containers. The product may be specified “as rolled,” without the removal of the rolling solution, and with no additional surface or oiling treatment. It may also be specified “cleaned” with the rolling solution removed, with or without surface treatment and oiling. This product is normally supplied with trimmed edges.

1.2 This specification is applicable to orders in either inch-pound units (as A 650) which is supplied in thicknesses from 50-lb base weight (0.0055 in.) to 103-lb base weight (0.0113 in.) or SI units [as A 650M] which is supplied in thicknesses from 0.14 to 0.29 mm.

1.3 The values stated in either inch-pound or SI units are to be regarded as standard. Within the text, the SI units are shown in brackets. The values stated in each system are not exact equivalents; therefore, each system must be used independently of the other. Combining values from the two systems may result in nonconformance with this specification.

2. Referenced Documents

2.1 ASTM Standards:

A 623 Specification for Tin Mill Products, General Requirements²

A 623M Specification for Tin Mill Products, General Requirements [Metric]²

3. Ordering Information

3.1 Orders for material under this specification shall include the following information, as required and applicable, to adequately describe the desired materials.

3.1.1 Name of material (double-reduced black plate),

3.1.1.1 As rolled, with the rolling solution not removed,

3.1.1.2 Cleaned, with the rolling solution removed, not reoiled,

3.1.1.3 Cleaned and oiled, with the rolling solution removed and reoiled,

3.1.1.4 Cleaned, chemically treated and oiled, with the rolling solution removed, chemically treated and reoiled.

3.1.2 Thickness (see Specification A 623 [Specification A 623M]),

3.1.3 Width,

3.1.4 Length, for cut sizes only,

3.1.5 Rolling direction must be specified by underlining the slit (rolling width) for cut sizes (see 4.1),

3.1.6 Steel type (see Specification A 623 [Specification A 623M]),

3.1.7 Mechanical designation requirements (see Specification A 623 [Specification A 623M]),

3.1.8 Intended application,

3.1.9 Quantity, in base boxes [SITAS] (see Note 4),

3.1.10 On coils, specify minimum or range of acceptable inside diameters. The standard inside diameter is approximately 16 in. if ordered to Specification A 650 [410 mm if ordered to Specification A 650M]. Coils should be specified to a maximum coil weight if ordered to Specification A 650 [mass if ordered to Specification A 650M] or maximum outside diameter,

3.1.11 Packaging,

3.1.12 Special requirements where applicable, and

3.1.13 ASTM specification number and year of issue (A 650/A 650M – 88).

NOTE 1—A typical ordering description is as follows: 1200 base boxes double-reduced black plate, cleaned and oiled, 60-lb base weight, 28 by 33 $\frac{1}{16}$ in., MR, DR8, for 401 by 411 can bodies to ASTM Specification A 650.

[250 SITAS, double-reduced black plate, cleaned and oiled, 0.17 mm thickness, 710 by 840 mm, MR, DR8, for 99 mm can bodies to ASTM Specification A 650M.]

NOTE 2—The production of coils does not afford the same opportunity for inspection, grading, and sorting as does the production of cut sizes. Accordingly, appropriate processing and quality control procedures are required by the purchaser to obtain optimum utilization of the material. Cut sizes are line-inspected visually and mechanically during production. Sheets having surface imperfections that will not interfere with their utilization are included.

NOTE 3—Double-reduced black plate is highly susceptible to rusting and must be properly handled during transit and storage.

NOTE 4—In inch-pound units, double-reduced black plate is supplied on an area basis expressed in base boxes. In coils, the number of base

¹ This specification is under the jurisdiction of ASTM Committee A-1 on Steel, Stainless Steel, and Related Alloys and is the direct responsibility of Subcommittee A01.20 on Tin Mill Products.

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² *Annual Book of ASTM Standards*, Vol 01.06.