

इंटरनेट

मानक

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“जानने का अधिकार, जीने का अधिकार”

Mazdoor Kisan Shakti Sangathan

“The Right to Information, The Right to Live”

“पुराने को छोड़ नये के तरफ”

Jawaharlal Nehru

“Step Out From the Old to the New”

IS 1254 (2007): Corrugated aluminium sheet [MTD 7: Light Metals and their Alloys]



“ज्ञान से एक नये भारत का निर्माण”

Satyanarayan Gangaram Pitroda

“Invent a New India Using Knowledge”



“ज्ञान एक ऐसा खजाना है जो कभी चुराया नहीं जा सकता है”

Bhartrhari—Nitiśatakam

“Knowledge is such a treasure which cannot be stolen”

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भारतीय मानक
एल्युमिनियम की नालीदार चद्वर
(चौथा पुनरीक्षण)

Indian Standard
CORRUGATED ALUMINIUM SHEET
(*Fourth Revision*)

ICS 77.150.10

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FOREWORD

This Indian Standard (Fourth Revision) was adopted by the Bureau of Indian Standards, after the draft finalized by Light Metals and Their Alloys Sectional Committee had been approved by the Metallurgical Engineering Division Council.

This standard was first published in 1958 and revised in 1965, 1975 and 1991. While reviewing this standard, in the light of experience gained during these years, the Committee decided to revise it to bring in line with the present practices being followed by the Indian industry.

In this revision the following changes have been made:

- a) A new clause on references has been incorporated.
- b) Requirement of 19000 H4 has been added in the material clause.
- c) A new clause on depth and pitch of the corrugation has been added.
- d) Figure 2 has been modified.
- e) Marking clause has been modified.

For the purpose of deciding whether a particular requirement of this standard is complied with, the final value, observed or calculated, expressing the result of a test or analysis, shall be rounded off in accordance with IS 2 : 1960 'Rules for rounding off numerical values (*revised*)'. The number of significant places retained in the rounded off value should be the same as that of the specified value in this standard.

Indian Standard
CORRUGATED ALUMINIUM SHEET
(Fourth Revision)

1 SCOPE

This standard specifies the material, profile dimensions and finish for the corrugated aluminium sheets meant for following uses:

- a) General purpose,
- b) Industrial, and
- c) Building.

2 REFERENCES

The following standards contain provisions, which through reference in this text constitute provisions of this standard. At the time of publication, the editions indicated were valid. All standards are subject to revision and parties to agreements based on these standards are encouraged to investigate the possibility of applying the most recent editions of the standards indicated below:

<i>IS No.</i>	<i>Title</i>
737 : 1986	Wrought aluminium and aluminium alloy sheet and strip for general engineering purposes (<i>third revision</i>)
2676 : 1981	Dimensions for wrought aluminium and aluminium alloy sheet and strip (<i>first revision</i>)
10259 : 1982	General condition of delivery and inspection of aluminium and aluminium alloy products

3 FREEDOM FROM DEFECTS

Corrugated sheet shall be clean and reasonably free from harmful defects.

4 SUPPLY OF MATERIAL

General requirements for the supply of material shall be as specified in IS 10259.

5 PROFILE

5.1 Profile of the three types of sheet may preferably be as shown in Fig. 1. However, if agreed between the manufacturer and the purchaser other profiles can also be used.

5.2 The corrugations shall be uniform and parallel with the sides of the sheet.

6 MATERIAL

Corrugated aluminium sheet shall be made from sheets in alloy and temper conforming to alloy 19000 H4 or 31000 H4 or 31500 H4 or 40800 H4 or 51300 H4 as specified in IS 737.

7 DIMENSIONS AND TOLERANCES

7.1 The thickness of the corrugated sheet shall be as agreed to between the purchaser and the supplier. Tolerance on the thickness of the sheet shall be subject to the general thickness tolerance specified in IS 2676.

7.2 Width

The overall width of sheet shall be as given in Fig. 2 subject to a tolerance of ± 10 mm for sheet of 0.45 mm and above in thickness. The tolerance on width for sheet less than 0.45 mm thick, shall be subject to agreement between the purchaser and the supplier.

7.3 Length

The length of the sheet shall be as agreed to between the purchaser and the manufacturer, subject to a tolerance of +6 mm. However, preferred length are 1 800 mm, 2 400 mm, 3 000 mm, and 3 600 mm.

7.4 Squareness

Unless otherwise specified by the purchaser, the diagonal distance between corners of any finished sheet shall not differ by more than 20 mm for sheet of 0.45 mm and above in thickness. The tolerance on squareness for sheets less than 0.45 mm in thickness, shall be subject to mutual agreement between the purchaser and the supplier.

7.5 Depth and Pitch of the Corrugation

The depth of the corrugation shall be 12.5 mm and 17.5 mm subject to a tolerance of +2.5 mm. The pitch of the corrugation shall be 75 mm subject to a tolerance of +5 mm.

8 FINISH

The finish shall be 'as rolled' unless a special surface finish has been agreed to between the manufacturer and the purchaser.

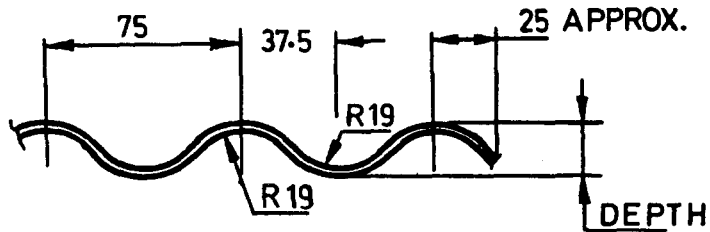
9 MARKING

9.1 Each sheet shall be suitably marked with the name of the manufacturer, grade of material (see 6) thickness, width, length and lot number.

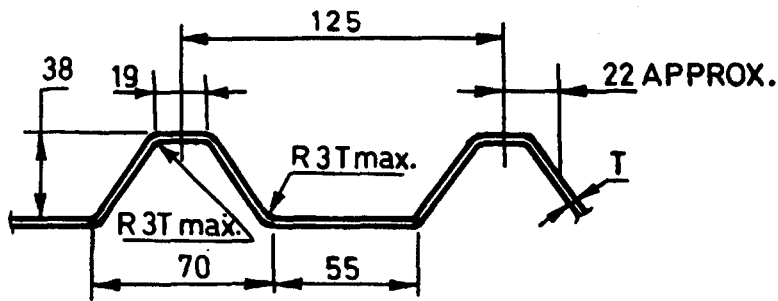
9.1.1 BIS Certification Marking

The material may also be marked with the Standard Mark.

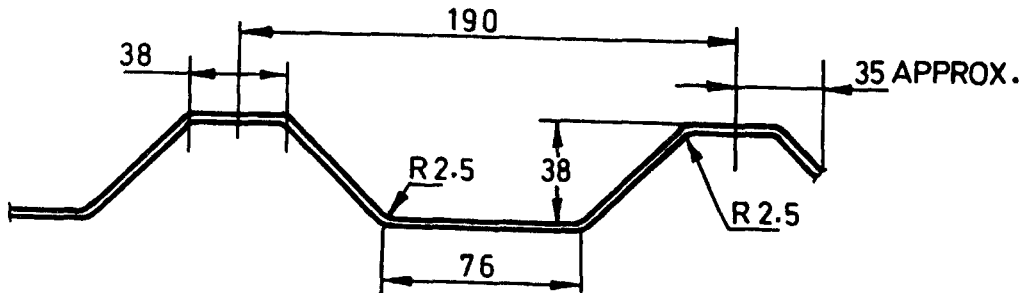
9.1.2 The use of the Standard Mark is governed by the provisions of the *Bureau of Indian Standards Act, 1986* and the Rules and Regulations made thereunder. The details of conditions under which the licence for the use of the Standard Mark may be granted to manufacturers or producers may be obtained from the Bureau of Indian Standards.



General Purpose Sheet



Industrial Sheet

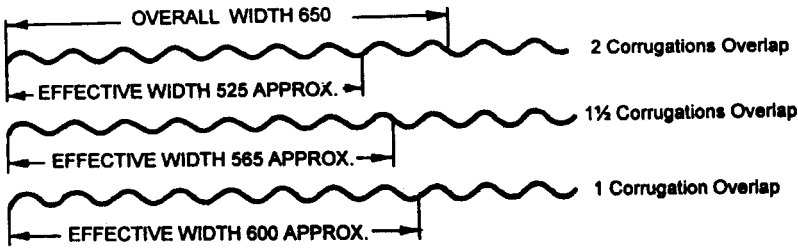


Building Sheet

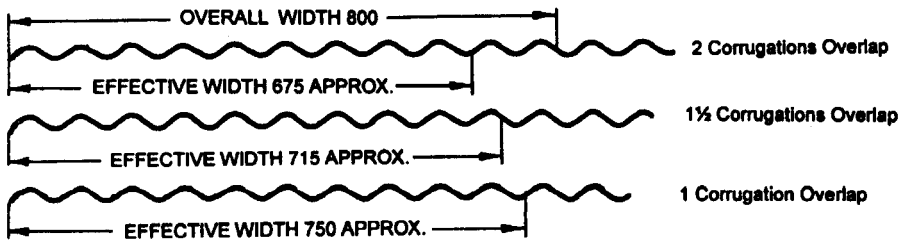
T = thickness of sheet

All dimensions in millimetres.

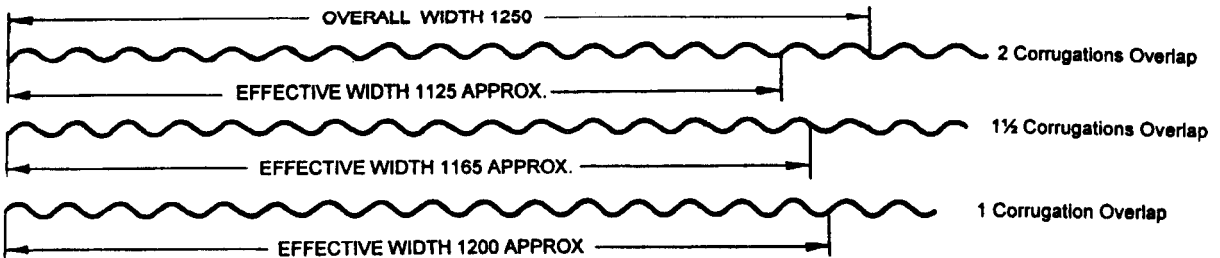
FIG. 1 PROFILES OF CORRUGATED ALUMINIUM SHEET



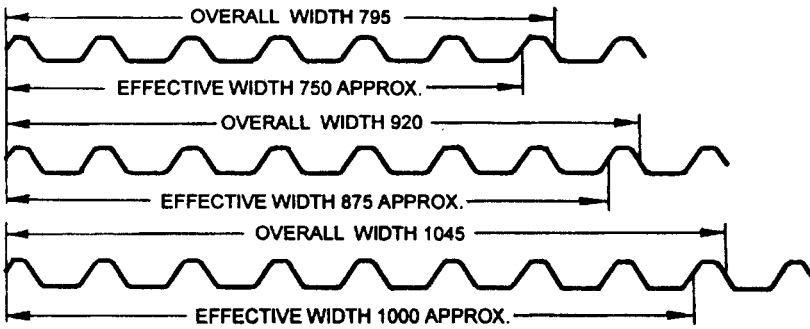
8/75 General Purpose Sheet



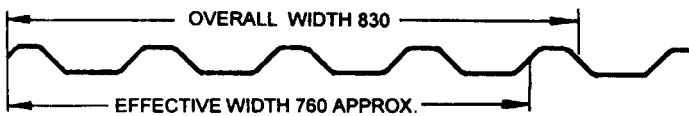
10/75 General Purpose Sheet



16/75 General Purpose Sheet



Industrial Sheet



Building Sheet

FIG. 2 WIDTHS FOR CORRUGATED ALUMINIUM SHEET

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This Indian Standard has been developed from Doc: No. MTD 7 (4441).

Amendments Issued Since Publication

Amend No.	Date of Issue	Text Affected

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