

**ROUTING -PROCESS DESIGN FOR 1050-H22-HSRP APPLICATION**

**1.0 Purpose**

To set up a process route practice of Aluminium coil for AA1050-H22

**2.0 Scope**

Supply of Aluminium coil/Sheet as per below specification

1.) AA1050 / 'H22' -Thk 1 mm- Chromium coating coils

**3.0 Responsibility & Authority**

Managers/Section-in-Charge of the departments using this process is responsible for implementing this procedure.

**4.0 PPEs**

1. Safety helmet 2. Safety shoes 3. Gloves (if required)

**5.0 Process Method**

- Caster coil is to be selected from standard cast coil composition.

Chemical Compositions-As per Internal Chart

Alloy	Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	Al
AA1050	0.2 max	0.35 max	0.01 max	0.01 max	0.01 max	0.01 max	0.01 max	0.02- 0.03	99.50 Min

- Process route for AA1050 / H22 / is followed  
(UTS to achieve 85-125 MPa, Elongation: Minimum 5 %)

CC 1mm (FG) ⇒ CRM ⇒ HOMO AT 3.6MM ⇒ CRM ⇒ TA at 1.33 MM ⇒  
TLL → STAMCO (1220MM-2 T, 508 MM ID) → Chromitizing  
at Pune → Return to JAL-DF → STAMCO (101MM, 121MM) → PACKING

Width Tolerance: ±0.5mm  
Thk Tol: No negative, +40mic

APPROVED BY, PROCESS REVIEW COMMITTEE

NH  


→ SKS  


→ ONU  


→ SD  
*on leave*

→ RNS  
  
12/06

JINDAL ALUMINIUM LIMITED  
(Rolling Mill Division)  
K.I.A.D.B. Industrial Area  
Yedahalli Village, Tumkur Road  
Dabbaspeta, Bengaluru-562 111  
Ph: 080-27735051-27735003