**TECHNICAL DATA SHEET FOR CORRUGATED STEEL MOULDS**

Corrugated steel sheets are used as moulds or interleavers in the production of fibre cement sheets.

**PROFILE**

Sitomeca has designed more than 35 different profiles that can be produced in a thickness of 2-3 mm with a sheet length of up to 6.3 m in one piece, and up to 12 m in two welded pieces perfectly grinded on both sides.

**MATERIAL**

|  |  |  |  |
| --- | --- | --- | --- |
|  | Min. Yield Strength ReH  N/mm² | Min.-Max Tensile Strength Rm  N/mm² | Min. Elongation after fracture A N/mm² |
| Hot-rolled - S315MC | 315 | 390-510 | 20 % |
| Hot-rolled - S355MC | 355 | 430-550 | 19 % |
| Hot-rolled - S420MC | 420 | 480-620 | 16 % |
| Galvanized S350GD+Z450MAC | 350 | 420-560 | 16 % |
| Stainless steel 304/2H | 500 | 690-860 | 15 % |

**TOLERANCES OF THE STEEL MOULDS**

|  |  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- | --- |
|  | Length  mm | Width  mm | Thickness  mm | Parallelism Mm/m | Pitch mm | X x pitch  mm | Height  mm |
| CORRUGATED | +/-2.0 | +2.0/-3.0 | +/- 0.2 | +/-2.0 | +0.4/-0.8 | +1.0/-2.5 | +1.0/-0.5 |

**MANUFACTURE**

The steel sheets are cut at right angles, the edges deburred and the corners rounded. In order to prevent the templates from rusting during transport, each mould is individually treated with special rust preventive oil.

Inside the wooden cases or on the pallets, the templates are wrapped in a special foil with a volatile corrosion inhibitor

**QUALITY CONTROL**

The flat steel sheets undergo checks at each phase of the production. Moreover, random quality checks are carried out, the results of which are sent to the customer. Quality control is carried out for the pitch of the corrugation and for the depth of corrugation.

**REPROFILING**

After many years of use, the templates are no longer within the acceptable range of tolerances. Sitomeca is equipped to considerably extend the lifetime of your moulds by reprofiling them.