

DANA is one of the biggest supplier of Hot Dipped galvanized coils [GI], Prepainted galvanized coils [PPGI], Prepainted Alumnump [PPAL], Aluzinc coils [AZ], Electro-galvanized coils [EG], Alumnum coils [AL], Cold Rolled coils [CR] & Hot Rolled coils [HR], Cold rolled Annealed coil, Prepainted Steel Coil, Prepainted galvanized steel coil. Having abundant storage & handling facilities for coils/sheets/slits along with a highly competent coil service center with most modern cutting & slitting facilities Makes DANA a fast and efficient business service centre.

Applicable Standards

The following list contains specification references for products we can offer. Applicable Standards describe specification requirements our suppliers can meet.

	Applicable Standards
Grade designations	JIS G3312
Physical properties of paint coating	JIS G3312
Paint coating durability	JIS G3312
Weight & Thickness of Zinc Coating	JIS G3312
Standard Dimension	JIS G3312
Dimensional Tolerances	JIS G3312
Camber	JIS G3312
Flatness	JIS G3312

JIS G3312 - 94

Prepainted Hot-dip Zinc-coated Steel Sheets and Coils

- Grades & Thickness

Application	Classified Symbol	Nominal Thickness(mm)	Classified Symbol of base metal	Remarks
Commercial	CGCC	0.25 and over, up to and incl.1.6	SGCC	For the classification of coating and the coating mass on the base metal for paint
Commercial-Hard	CGCH	0.11 and over, up to and incl.1.0	SGCH	
Drawing	CGCD1	0.40 and over, up to and incl.1.6	SGCD 1	
Structural	CGC 340	0.25 and over, up to and incl.1.6	SGC 340	
	CGC 400	0.25 and over, up to and incl.1.6	SGC 400	
	CGC 440	0.25 and over, up to and incl.1.6	SGC 440	
	CGC 490	0.25 and over, up to and incl.1.6	SGC 490	
	CGC 570	0.25 and over, up to and incl.1.6	SGC 570	

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		0.25 and over, up to and incl.1.6		coating,. JIS G 3302 shall apply.
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- Physical Properties of Paint Coatings

Item	Test method	CGCH, CHC570	CGCC,CGCD1 CGC340, 400, 440, 490	Physical Properties
Bending adhesion	Bend test	-	O	No peeling on the outer surface of the bent portion not less than 7mm from each side edge of the test piece.
Paint film hardness	Pencil hardness test	O	O	No scratch marks on the paint film
Impact resistance	Impact test	-	O	No Peeling
Adhesion	Cross-scoring test	O	-	No irregularities on the tested portion

- Paint Coating durability

Class	Salt spray Test	Weathering Test(Dew cycle)
1	200 hours	-
2	500 hours	-
3	2000 hours	1500 hours

- Weight of Zinc Coating & Equivalent Thickness(mm)

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Symbol indicating weight of zinc coating	Z 06	Z 08	Z 10	Z 12	Z 18	Z 20
Equivalent thickness of coating	0.013	0.017	0.021	0.026	0.034	0.040
Symbol indicating weight of zinc coating	Z 22	Z 25	Z 27	Z 35	Z 45	Z 60
Equivalent thickness of coating	0.043	0.049	0.054	0.064	0.080	0.102
Symbol indicating weight of zinc coating	F 04	F 06	F 08	F 10	F 12	F 18
Equivalent thickness of coating	0.008	0.013	0.017	0.021	0.026	0.034

- Standard Dimension

Standard Nominal Thickness (mm)

0.25 0.27 0.30 0.35 0.40 0.50 0.60 0.80 1.0 1.2 1.4 1.6

Standard Widths and Sheet Lengths (mm)

Width (mm)	Sheet Length (mm)						
762	1829	2134	2438	2743	3048	3353	3658
914	1829	2134	2438	2743	3048	3353	3658
1000	2000						
1219	2438	3048	3658				

- Thickness Tolerances (Applicable for classes 1 and 2 for one side and class 1 for both sides in the classification of paint coating durability)

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Specified Thickness(mm)	Specified Width(mm)		
	Under 630	630 to 1000 excl	1000 to 1250 excl
Under 0.25	+0.08	+0.08	+0.08
	-0.03	-0.03	-0.03
0.25 to 0.40 excl	+0.09	+0.09	+0.09
	-0.04	-0.04	-0.04
0.40 to 0.60 excl	+0.10	+0.10	+0.10
	-0.05	-0.05	-0.05
0.60 to 0.80 excl	+0.11	+0.11	+0.11
	-0.06	-0.06	-0.06
0.80 to 1.00 excl	+0.12	+0.12	+0.13
	-0.07	-0.07	-0.08
1.00 to 1.25 excl	+0.13	+0.13	+0.14
	-0.08	-0.08	-0.09
1.25 to 1.60 excl	+0.14	+0.15	+0.16
	-0.09	-0.10	-0.11
1.60	+0.15	+0.16	+0.17
	-0.10	-0.11	-0.12

- Thickness Tolerances (Applicable for class 3 for one side and classes 2 and 3 for both sides in the classification of paint coating durability)

Specified Thickness(mm)	Specified Width(mm)		
	Under 630	630 to 1000 excl	1000 to 1250 excl
Under 0.25	+0.10	+0.10	+0.10
	-0.02	-0.02	-0.02
0.25 to 0.40 excl	+0.11	+0.11	+0.11
	-0.03	-0.03	-0.03
0.40 to 0.60 excl	+0.12	+0.12	+0.12
	-0.04	-0.04	-0.04
0.60 to 0.80 excl	+0.13	+0.13	+0.13

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	-0.05	-0.05	-0.05
0.80 to 1.00 excl	+0.14	+0.14	+0.15
	-0.06	-0.06	-0.07
1.00 to 1.25 excl	+0.15	+0.15	+0.16
	-0.07	-0.07	-0.08
1.25 to 1.60 excl	+0.16	+0.17	+0.18
	-0.08	-0.09	-0.10
1.60	+0.17	+0.18	+0.19
	-0.09	-0.10	-0.11

- Tolerances on Width and Length (mm)

Item	Tolerance
Width	+ 7,0
Length	+15,0

- Weight Tolerances

Calculated Weight of One Lot	Tolerance, %	Remarks
Under 600kg (1,300 lb)	+/- 10	One lot consists of sheets of the same quality, same style and size, and same coating weight
600Kg to 2 tons (4,409 lb) excl	+/- 7.5	
2tons and over	+/- 5	

- Camber (mm)

Width	Length	Flat Sheet		coil
		Up to 2000	2000 and over	

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Up to 630	4	4 in any 2000 of length
630 and over	2	2 in any 2000 of length

- Flatness (mm)

Width	Classification	Bow	Edge Wave	Center Wave
	Up to 1000		12 Max,	8 Max,
1000 and over, Up to 1000		15 Max,	10 Max,	8 Max,

We export steel to Qatar(Doha), SaudiArabia(Dammam,Jeddah,Riyadh,Dahran,Jubail,Yanbu), Kuwait,Iraq,Bahrain(Manama),Oman(Muscat,Sohar,Seeb), Nigeria, Kenya, Uganda, Mauritius, Sudan, Africa, Morocco, Algeria, Sudan, Syria, Jordan, Burundi, Comoros, Djibouti, Ethiopia, Kenya, Madagascar, Libya, Mauritius, Rwanda, Seychelles, Somalia, Tanzania Rep and Uganda. Besides the above,we also have a strong marker presence in the West African Region:: Sierra Leone/Gambia/Senegal/Ghana/Mauritania/Chad/Liberia/Sao Tome/Congo and the South African Region :: South Africa/Mozambique/Malawi/Zimbabwe/Zambia/Angola/Dr Congo.