Serving the industry since 1896

GALVANIZED STEEL COIL

GREGORY INDUSTRIES

Why Gregory?

- Ready inventory
- Quick turnaround
- Coat-to-order
- Material conversion
- Stocking programs
- ISO Cert. 9001.2008

SPECIALIZING IN MADE-TO-ORDER GALVANIZING

Galvanizing

Gregory Industries specializes in made-to-order, quality galvanized and slit steel coil. Fast inquiry response, competitive pricing, attention to detail and timely delivery are Gregory advantages.

Coating weights from G30 to G400, automotive specifications and UL Certified coatings are available to order. We also provide steel slitting and toll processing according to your requirements, with ISO 9001 compliance.

NO BARE EDGES
When greater corrosion protection is required, Gregory's custom narrow width continuous hot-dip galvanizing line has the unique ability to apply a zinc coating to the coil's unprotected slit edge.

COMMITMENT TO OPERATIONAL EXCELLENCE
Continuous galvanizing line technologies ensure uniform, quality coatings to specification.

Slitting

Combine coat-to-order galvanizing with precision slitting capabilities. Gregory's Braner-Loopco slitter handles coils up to 56,000 pounds and 75 inches wide. It provides precise tolerances of +/- 0.002 in. on gauges from 0.025 to 0.188. It also accommodates up to 14 cuts per setup and produces mult widths as narrow as 2 inches.

SLITTER SPECIFICATIONS

- Maximum coil weight/width: 56,000 lbs./75 in.
- Minimum/maximum gauge: 0.025 in./0.188 in.
- Slit width tolerance: +/- 0.002 in.
- Minimum edge trim: 3/16 per side
- Minimum mult size: 2 in.
- Cuts per set-up: 14
- Minimum/maximum coil ID: 20 in./30 in.

TOLL SLITTING
Gregory will slit your hot roll, cold roll or galvanized steel. Material may arrive in master coil or slit mults for further slitting.

Toll Processing

Gregory will galvanize your hot or cold rolled dry material. Material may arrive pre-slit or in master coil form to be slit, coated and re-slit to your requirements.

DIMENSIONS

Master coils up to 75 inches and 56,000 pounds are acceptable for slitting, coating and re-slitting.

- Coil shape and flatness must meet ASTM specifications and have commercially uniform dimensions throughout. The maximum deviation from horizontal, flat surface is 1/2 (0.5) in.
- PIW of coils must be between 250 min. and 1,000 max.
- Maximum galvanizing line width is 19.5 in. (See chart for limitations)

CHEMISTRY

Heat numbers and chemistries are required before steel arrives. The following limitations apply:

- Silicon (Si) content must not exceed 0.10%
- Chromium (Cr) content must not exceed 0.05%
- Phosphorus (P) content must not exceed 0.035%

SURFACE

Be aware that surface defects are not corrected and will sometimes be highlighted by galvanizing (i.e. pickle stains, pitting, rolled-in scale, etc.). The following conditions will prevent good coating results:

- Rolled-in scale
- Paint or identity caulk marks on sidewalls
- Presence of oil or pre-lubed coatings
- Heavy rust or flaky scale

STEEL DIMENSIONS AND GAUGES

GAUGE	MIN. WIDTH	MAX. WIDTH
.030	2”	15.0”
.035	2”	15.5”
.040	2”	15.5”
.045	2”	16.0”
.050	2”	16.0”
.055	2”	17.0”
.060	2”	18.0”
.065	2”	18.5”
.070	2”	19.0”
.075	2”	19.5”
.080	2”	19.5”
.085	2”	19.5”
.090	2”	19.5”
.095	2”	19.5”
.100	2”	19.5”
.105	2”	19.5”
.110	2”	19.0”
.115	2”	19.0”
.120	2”	16.0”
.125	2”	15.0”
.130	2”	13.5”
.135	2”	12.5”
.140	2”	11.5”
.145	2”	11.0”
.150	2”	10.0”
.155	2”	9.5”
.160	2”	9.0”
.165	2”	8.5”
.170	2”	8.0”
.18	2”	4.0” **

** *Consult factory for steel property limitations on heaviest gauges.*

GALVANIZED COATING SPECIFICATIONS

GALVANIZED COATING DESIGNATION		MIN. TRIPLE SPOT, TOTAL BOTH SIDES OZ/FT² OR G/M²		MIN. SINGLE SPOT, TOTAL ONE SIDE OZ/FT² OR G/M²		MIN. SINGLE SPOT, TOTAL BOTH SIDES OZ/FT² OR G/M²	
Standard	Metric	Standard	Metric	Standard	Metric	Standard	Metric
G360	(Z1100)	3.60	1100	1.28	3.90	3.20	975
G300	(Z900)	3.00	900	1.04	316	2.60	760
G235	(Z700)	2.35	700	0.80	238	2.00	595
G210	(Z600)	2.10	600	0.72	204	1.80	510
G185	(Z550)	1.85	550	0.64	190	1.60	475
G165	(Z500)	1.65	500	0.56	170	1.40	425
G140	(Z450)	1.40	450	0.48	154	1.20	385
G115	(Z350)	1.15	350	0.40	120	1.00	300
G90	(Z275)	0.90	275	0.32	94	0.80	235
G60	(Z180)	0.60	180	0.20	60	0.50	150
G40	(Z120)	0.40	120	0.12	36	0.30	90
G30	(Z90)	0.30	90	0.10	30	0.25	75

Toll Processing

COIL CHARACTERISTICS

Processing operations produce only minor changes in the metal's physical properties, retaining the original characteristics of the uncoated metal.

- CAMBER
  Camber must be within guidelines as established in ASTM specification A924, Table 6.
- SECONDARY FLAWS
  Folded edges, kinks or welds are not permitted.
- IMPERFECTIONS
  Galvanizing does not cover up or pickle-out surface flaws and cosmetic blemishes such as those found on some secondary steel coils. Material labeled prime or excess prime will yield the best surface coating.

AUTOMOTIVE GALVANIZED COATING SPECIFICATIONS

GALVANIZED COATING DESIGNATION		MIN. PER SIDE, OZ/FT² OR G/M²		MAX. PER SIDE, OZ/FT² OR G/M²	
Standard	Metric	Standard	Metric	Standard	Metric
30G	30G	0.10	30	0.23	70
40G	40G	0.13	40	0.26	80
50G	50G	0.16	50	0.31	95
60G	60G	0.20	60	0.36	110
70G	70G	0.23	70	0.39	120
80G	80G	0.26	80	0.43	130
90G	90G	0.30	90	0.46	140
98G	98G	0.32	98	0.52	160

APPROXIMATE ADDED THICKNESS OF ZINC

COATING WEIGHT	ADDED THICKNESS
40G/40G	0.001
50G/50G	0.001
60G/60G	0.002
70G/70G	0.002
80G/80G	0.002
90G/90G	0.002
G60	0.002
G90	0.002
G115	0.003
G165	0.004
G185	0.004
G210	0.004
G235	0.006
G400	0.009

GREGORY INDUSTRIES

4100 13th St. SW, Canton, OH 44710 1-866-994-4929
bchufar@gregorycorp.com
esommer@gregorycorp.com

gregorycorp.com