

AN OVERVIEW OF MANUFACTURING METHODS OF TIN MILL
BLACK PLATE (TMBP) AND ITS QUALITY REQUIREMENTS

P.K. Banerjee
The Tinplate Company of India Ltd
Jamshedpur 831003

ABSTRACT

Cold rolled coil/sheet is a versatile and sophisticated steel product with a wide range of applications in the industrial, agricultural and transportation sectors. Tin Mill Black Plate (TMBP) is a thin gauge, low carbon cold rolled product meant for electrolytic tinning. Burgeoning applications and ever growing consumption of cold rolled coils/sheets make it imperative for all of us to have an understanding of quality requirements of this product and inter-relationship between manufacturing steps and properties to be achieved.

In this paper an attempt will be made to describe briefly important steps, alongwith process parameters involved in the manufacture of TMBP and how shape, dimensions, surface appearance and finish and uniform mechanical properties along the length and across the width of the coils can be attained.

Characteristics of H.R coil, pickling, primary rolling, electrolytic cleaning, annealing -- continuous and batch, and temper rolling will be discussed alongwith the salient features of TMBP.