STEEL COIL ORDERING INFORMATION

Version 2025.2

SCOTTSDALE

THE TRUSTED STEEL-FRAMING PARTNER

DISCLOSURES

The SCOTTSDALE CONSTRUCTION SYSTEMS mission is to take care of its customers by being the safest, highest quality, lowest cost, most productive and most profitable load-bearing light-gauge steel framing products company in the world.

This manual outlines the ordering requirements for steel coils based on various country codes, including those of Australia, North America, and the Eurocode. It consolidates the current practices, methods, tools, and requirements utilized by SCOTTSDALE CONSTRUCTION SYSTEMS to ensure the quality of steel used in its roll formers to produce steel frames. Adhering to these guidelines enables SCOTTSDALE CONSTRUCTION SYSTEMS to maintain compliance with international standards and meet customer expectations. The information presented here provides a valuable resource for training, audits, and both internal and external reviews.

The contents of this manual will be reviewed annually and updated as required by the Industrial Engineering function within the manufacturing organization for SCOTTSDALE CONSTRUCTION SYSTEMS, to assure accuracy and completeness of the information.

SCOTTSDALE
THE TRUSTED STEEL-FRAMING PARTNER

STEEL COIL ORDERING INFORMATION

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SECTION I:INTRODUCTION

Steel coils are a critical component in the manufacturing process of cold-formed steel frames. Selecting the appropriate specifications for the steel coils is essential to ensuring the smooth production of steel frames using Scottsdale roll formers. The quality of the steel frames produced depends entirely on the quality and mechanical properties of the steel coil used. Therefore, it is crucial to choose the correct steel coil for the roll-forming process. This document summarizes the ordering specifications for major country codes as listed below.

- Australia – AS 1397:2021
- North America – ASTM A653/A653M - 20
- Europe – EN 10346

This information will help in choosing the correct steel coil for your desired application and ensuring compatibility with the Scottsdale roll formers.

Note: Only options related to Scottsdale roll formers are listed in this document.

SECTION II: AS 1397:2021

Requirements and corresponding options in choosing coil in accordance with AS 1397:2021 are tabulated below. Not all requirements are mandatory according to the code, but it is advisable to check with the steel supplier before the coil purchase.

SCOTPANEL AND SCOTTRUSS

<table>
<tr><th>No</th><th>Requirement</th><th colspan="3">Options</th></tr>
<tr><td>1</td><td>The number of the corresponding Australian Standards</td><td colspan="3">AS 1397:2021</td></tr>
<tr><td>2</td><td>Type of product required</td><td colspan="3">• Coil strip
• Coil length</td></tr>
<tr><td>3</td><td>Designation of steel-grade</td><td colspan="3">Naming convention is as follows.
AS 1397/Grade Coating
Grade Options
• G350
• G450
• G500
• G550</td></tr>
<tr><td>4</td><td>Designation of coating class</td><td colspan="3">• AM150
• Z275</td></tr>
<tr><td>5</td><td>Surface finish, including any chemical treatment required</td><td colspan="3">• Regular spangle – R
• Spangle free – f</td></tr>
<tr><td>6</td><td>Quantity (mass, or number of sheets) and delivery instructions (dates, schedules, delivery points)</td><td colspan="3">Based on user/project requirements</td></tr>
<tr><td rowspan="3">7*</td><td rowspan="3">Dimensions, including thickness, width and length and reference to AS/NZS for applicable tolerances</td><td colspan="3">SCOTPANEL Options</td></tr>
<tr><td>Roll former</td><td>Coil Width (mm)</td><td>Thickness (mm)</td></tr>
<tr><td>5090</td><td>190</td><td>0.75, 0.95,1.15</td></tr>
</table>

		5140	244	0.75, 0.95, 1.15
		7063	143	0.55, 0.75, 0.95
		7070	153	0.55, 0.75, 0.95
		7076	156	0.55, 0.75, 0.95
		7090	173	0.55, 0.75, 0.95, 1.15
		7140	224	0.55, 0.75, 0.95, 1.15
		SCOTTRUSS Options		
		6050	173	0.55, 0.75, 0.95, 1.15
		6075	224	0.95, 1.15, 1.55
8	Defects allowable	Based on user/project requirements		
9	Testing requirements, the frequency of testing and whether a test certificate is required	**Requirement Options** – Yes/No **Frequency –** Based on user/project requirements		
10	Whether the purchaser intends to inspect the coated steel at the manufacturer's work	Yes/No		
11	Any special or supplementary requirements	Based on user/project requirements		
12	Any information concerning processing or end use that the purchaser considers would assist the manufacturer. Note that soldering of material having an aluminum/zinc coating is not practicable	Based on user/project requirements		

Note:

- All dimensions are in Metric units unless otherwise specified.
- For further information refer to Appendix A of AS 1397:2021.
- * - Refer to the Knudson section for KFD and KFS Framemaker coil widths.

KNUDSON BY SCOTTSDALE KFD AND KFS

The Knudson by Scottsdale KFD and KFS Framemaker models support multiple profiles to be rolled within a single machine. The attached table shows the coil width against all combinations in metric units.

Coil Width [mm]									
Profiles	Rollformer	Type	Material Thickness [mm]						
			0.48	0.72	0.79	0.88	1.15	1.44	1.81	2.58
162S125	KFD 2025	Stud	112	111	111	-	-	-	-	-
250S125	KFD 2025	Stud	134	133	133	-	-	-	-	-
362S125	KFD 2025	Stud	163	162	162	-	-	-	-	-
400S125	KFD 2025	Stud	172	172	171	-	-	-	-	-
600S125	KFD 2025	Stud	223	222	222	-	-	-	-	-
162T125	KFD 2025	Track	107	107	107	-	-	-	-	-
250T125	KFD 2025	Track	130	129	129	-	-	-	-	-
362T125	KFD 2025	Track	158	158	158	-	-	-	-	-
400T125	KFD 2025	Track	168	168	168	-	-	-	-	-
600T125	KFD 2025	Track	219	218	218	-	-	-	-	-
600S200	KFS 1218	Stud	-	-	-	-	275	274	272	268
800S200	KFS 1218	Stud	-	-	-	-	326	324	323	319
1000S200	KFS 1218	Stud	-	-	-	-	377	375	373	370
1200S200	KFS 1218	Stud	-	-	-	-	427	426	424	420
600S250	KFS 1218	Stud	-	-	-	-	300	299	297	293
800S250	KFS 1218	Stud	-	-	-	-	351	350	348	344
1000S250	KFS 1218	Stud	-	-	-	-	402	401	399	395
1200S250	KFS 1218	Stud	-	-	-	-	453	451	450	446
600T150	KFS 1218	Track	-	-	-	-	227	232	232	231
800T150	KFS 1218	Track	-	-	-	-	278	283	282	282
1000T150	KFS 1218	Track	-	-	-	-	329	333	333	333
1200T150	KFS 1218	Track	-	-	-	-	379	384	384	384
362S162	KFS 1420	Stud	191	-	-	191	189	188	186	-
400S162	KFS 1420	Stud	200	-	-	200	199	197	196	-
600S162	KFS 1420	Stud	251	-	-	251	250	248	246	-
800S162	KFS 1420	Stud	302	-	-	302	300	299	297	-
1000S162	KFS 1420	Stud	353	-	-	352	351	350	348	-
1200S162	KFS 1420	Stud	404	-	-	403	402	401	399	-

Coil Width [mm]									
Profiles	**Rollformer**	**Type**	**Material Thickness [mm]**						
			0.48	**0.72**	**0.79**	**0.88**	**1.15**	**1.44**	**1.81**	**2.58**
362S200	KFS 1420	Stud	216	-	-	216	215	213	211	-
400S200	KFS 1420	Stud	226	-	-	225	224	223	221	-
600S200	KFS 1420	Stud	277	-	-	276	275	274	272	-
800S200	KFS 1420	Stud	327	-	-	327	326	324	323	-
1000S200	KFS 1420	Stud	378	-	-	378	377	375	373	-
1200S200	KFS 1420	Stud	429	-	-	429	427	426	424	-
362S250	KFS 1420	Stud	242	-	-	241	240	239	237	-
400S250	KFS 1420	Stud	251	-	-	251	250	248	246	-
600S250	KFS 1420	Stud	302	-	-	302	300	299	297	-
800S250	KFS 1420	Stud	353	-	-	352	351	350	348	-
1000S250	KFS 1420	Stud	404	-	-	403	402	401	399	-
1200S250	KFS 1420	Stud	454	-	-	454	453	451	450	-
362T150	KFS 1420	Track	167	-	-	167	167	167	166	-
400T150	KFS 1420	Track	176	-	-	176	176	176	176	-
600T150	KFS 1420	Track	227	-	-	227	227	227	227	-
800T150	KFS 1420	Track	278	-	-	278	278	278	278	-
1000T150	KFS 1420	Track	329	-	-	329	329	329	328	-
1200T150	KFS 1420	Track	380	-	-	380	379	379	379	-
350S162	KFS 1622	Stud	-	189	189	189	187	186	-	-
362S162	KFS 1622	Stud	-	193	192	192	191	189	-	-
400S162	KFS 1622	Stud	-	202	202	201	200	199	-	-
550S162	KFS 1622	Stud	-	240	240	239	238	237	-	-
600S162	KFS 1622	Stud	-	253	253	252	251	249	-	-
800S162	KFS 1622	Stud	-	304	303	303	302	300	-	-
350S200	KFS 1622	Stud	-	215	214	214	213	211	-	-
362S200	KFS 1622	Stud	-	218	218	217	216	215	-	-
400S200	KFS 1622	Stud	-	228	227	227	225	224	-	-
550S200	KFS 1622	Stud	-	266	265	265	264	262	-	-
600S200	KFS 1622	Stud	-	278	278	278	276	275	-	-
800S200	KFS 1622	Stud	-	329	329	328	327	326	-	-
350S250	KFS 1622	Stud	-	240	240	239	238	237	-	-
362S250	KFS 1622	Stud	-	243	243	243	241	240	-	-
400S250	KFS 1622	Stud	-	253	253	252	251	249	-	-
550S250	KFS 1622	Stud	-	291	291	290	289	288	-	-
600S250	KFS 1622	Stud	-	304	303	303	302	300	-	-

Coil Width [mm]									
Profiles	**Rollformer**	**Type**	**Material Thickness [mm]**						
			0.48	**0.72**	**0.79**	**0.88**	**1.15**	**1.44**	**1.81**	**2.58**
800S250	KFS 1622	Stud	-	355	354	354	352	351	-	-
350T150	KFS 1622	Track	-	164	164	164	164	164	-	-
362T150	KFS 1622	Track	-	168	168	168	167	167	-	-
400T150	KFS 1622	Track	-	177	177	177	177	177	-	-
550T150	KFS 1622	Track	-	215	215	215	215	215	-	-
600T150	KFS 1622	Track	-	228	228	228	228	228	-	-
800T150	KFS 1622	Track	-	279	279	279	279	278	-	-

Note:

- All dimensions are in Metric units unless otherwise specified.
- For further information refer to Appendix A of AS 1397:2021.
- Knudson KFD and KFS Framemaker series of roll formers can support a maximum steel grade of 450 MPa yield strength and 520 MPa ultimate tensile strength.

SECTION III: ASTM A653 – 20 (IMPERIAL)

SCOTPANEL AND SCOTTRUSS

Requirements and corresponding options in choosing coil in accordance with AS A653/A653M - 20 are tabulated below. Not all requirements are mandatory according to the code, but it is advisable to check with the steel supplier before the coil purchase.

<table>
<tr><th>No</th><th>Requirement</th><th colspan="3">Options</th></tr>
<tr><td>1</td><td>Designation of coating</td><td colspan="3">Zinc-coated</td></tr>
<tr><td>2</td><td>Name of the product</td><td colspan="3">Zinc-coated (galvanized)</td></tr>
<tr><td>3</td><td>Designation of sheet</td><td colspan="3">• SS
• HSLAS
• HSLAS-F</td></tr>
<tr><td>4</td><td>Designation of steel-grade</td><td colspan="3">SS – Grades 33 and 50 ksi - Class 1
HSLAS and HSLASF – Grade 50 ksi – Class 1</td></tr>
<tr><td>5</td><td>Designation of coating class</td><td colspan="3">Z275</td></tr>
<tr><td>6</td><td>Chemically treated or not</td><td colspan="3">No</td></tr>
<tr><td>7</td><td>Oiled or not oiled</td><td colspan="3">No</td></tr>
<tr><td>8</td><td>Surface finish</td><td colspan="3">• Regular spangle
• Spangle free</td></tr>
<tr><td>9</td><td>Extra smooth (if required)</td><td colspan="3">No</td></tr>
<tr><td>10</td><td>Phosphatized</td><td colspan="3">No</td></tr>
<tr><td rowspan="4">11*</td><td rowspan="4">Dimensions, including thickness, width and length and reference to AS/NZS for applicable tolerances</td><td colspan="3">SCOTPANEL Options</td></tr>
<tr><td>Roll former</td><td>Coil Width (in.)</td><td>Thickness (Ga.)</td></tr>
<tr><td>5090</td><td>7.48</td><td>22, 20, 18</td></tr>
<tr><td>5140</td><td>9.60</td><td>22, 20, 18</td></tr>
</table>

		7063	5.63	24, 22, 20
		7070	6.02	24, 22, 20
		7076	6.14	24, 22, 20
		7090	6.81	24, 22, 20, 18
		7140	8.81	0.55, 0.75, 0.95, 1.15
		SCOTTRUSS Options		
		6050	173	24, 22, 20, 18
		6075	224	20, 18, 16
12	Coil size requirements	Refer to row 11 for roll former specific requirements		
13	Packaging	Based on user/project requirements		
14	Certification if required, heat analysis and mechanical property report	**Requirement Options** – Yes/No **Frequency –** Based on user/project requirements		
15	Application	Part identification and description		
16	Any special or supplementary requirements	Based on user/project requirements		
17	If required, the product Base Metal Thickness	Refer to row 11 for roll former specific requirements		

Note:

- All dimensions are in Imperial units unless otherwise specified.
- * - Refer to the Knudson section for KFD and KFS Framemaker coil widths.

KNUDSON BY SCOTTSDALE KFD AND KFS

The Knudson by Scottsdale KFD and KFS Framemaker models support multiple profiles to be rolled within a single machine. The attached table shows the coil width against all combinations in imperial units.

Coil Width [in]									
Profiles	**Rollformer**	**Type**	**Material Thickness [Mils]**						
			18	**27**	**30**	**33**	**43**	**54**	**68**	**97**
162S125	KFD 2025	Stud	4.40	4.38	4.37	-	-	-	-	-
250S125	KFD 2025	Stud	5.28	5.25	5.25	-	-	-	-	-
362S125	KFD 2025	Stud	6.40	6.38	6.37	-	-	-	-	-
400S125	KFD 2025	Stud	6.78	6.75	6.75	-	-	-	-	-
600S125	KFD 2025	Stud	8.78	8.75	8.75	-	-	-	-	-
162T125	KFD 2025	Track	4.23	4.22	4.22	-	-	-	-	-
250T125	KFD 2025	Track	5.10	5.10	5.10	-	-	-	-	-
362T125	KFD 2025	Track	6.23	6.22	6.22	-	-	-	-	-
400T125	KFD 2025	Track	6.60	6.60	6.60	-	-	-	-	-
600T125	KFD 2025	Track	8.60	8.60	8.60	-	-	-	-	-
600S200	KFS 1218	Stud	-	-	-	-	10.83	10.77	10.70	10.55
800S200	KFS 1218	Stud	-	-	-	-	12.83	12.77	12.70	12.55
1000S200	KFS 1218	Stud	-	-	-	-	14.83	14.77	14.70	14.55
1200S200	KFS 1218	Stud	-	-	-	-	16.83	16.77	16.70	16.55
600S250	KFS 1218	Stud	-	-	-	-	11.83	11.77	11.70	11.55
800S250	KFS 1218	Stud	-	-	-	-	13.83	13.77	13.70	13.55
1000S250	KFS 1218	Stud	-	-	-	-	15.83	15.77	15.70	15.55
1200S250	KFS 1218	Stud	-	-	-	-	17.83	17.77	17.70	17.55
600T150	KFS 1218	Track	-	-	-	-	8.94	9.12	9.12	9.10
800T150	KFS 1218	Track	-	-	-	-	10.94	11.12	11.12	11.10
1000T150	KFS 1218	Track	-	-	-	-	12.94	13.12	13.12	13.10
1200T150	KFS 1218	Track	-	-	-	-	14.94	15.12	15.12	15.10
362S162	KFS 1420	Stud	7.52	-	-	7.50	7.45	7.39	7.32	-
400S162	KFS 1420	Stud	7.89	-	-	7.88	7.83	7.77	7.70	-
600S162	KFS 1420	Stud	9.89	-	-	9.88	9.83	9.77	9.70	-
800S162	KFS 1420	Stud	11.89	-	-	11.88	11.83	11.77	11.70	-
1000S162	KFS 1420	Stud	13.89	-	-	13.88	13.83	13.77	13.70	-
1200S162	KFS 1420	Stud	15.89	-	-	15.88	15.83	15.77	15.70	-
362S200	KFS 1420	Stud	8.52	-	-	8.50	8.45	8.39	8.32	-

Coil Width [in]									
Profiles	**Rollformer**	**Type**	**Material Thickness [Mils]**						
			18	**27**	**30**	**33**	**43**	**54**	**68**	**97**
400S200	KFS 1420	Stud	8.89	-	-	8.88	8.83	8.77	8.70	-
600S200	KFS 1420	Stud	10.89	-	-	10.88	10.83	10.77	10.70	-
800S200	KFS 1420	Stud	12.89	-	-	12.88	12.83	12.77	12.70	-
1000S200	KFS 1420	Stud	14.89	-	-	14.88	14.83	14.77	14.70	-
1200S200	KFS 1420	Stud	16.89	-	-	16.88	16.83	16.77	16.70	-
362S250	KFS 1420	Stud	9.52	-	-	9.50	9.45	9.39	9.32	-
400S250	KFS 1420	Stud	9.89	-	-	9.88	9.83	9.77	9.70	-
600S250	KFS 1420	Stud	11.89	-	-	11.88	11.83	11.77	11.70	-
800S250	KFS 1420	Stud	13.89	-	-	13.88	13.83	13.77	13.70	-
1000S250	KFS 1420	Stud	15.89	-	-	15.88	15.83	15.77	15.70	-
1200S250	KFS 1420	Stud	17.89	-	-	17.88	17.83	17.77	17.70	-
362T150	KFS 1420	Track	6.57	-	-	6.57	6.57	6.56	6.55	-
400T150	KFS 1420	Track	6.95	-	-	6.95	6.94	6.94	6.93	-
600T150	KFS 1420	Track	8.95	-	-	8.95	8.94	8.94	8.93	-
800T150	KFS 1420	Track	10.95	-	-	10.95	10.94	10.94	10.93	-
1000T150	KFS 1420	Track	12.95	-	-	12.95	12.94	12.94	12.93	-
1200T150	KFS 1420	Track	14.95	-	-	14.95	14.94	14.94	14.93	-
350S162	KFS 1622	Stud	-	7.46	7.44	7.43	7.38	7.32	-	-
362S162	KFS 1622	Stud	-	7.58	7.57	7.55	7.50	7.45	-	-
400S162	KFS 1622	Stud	-	7.96	7.94	7.93	7.88	7.82	-	-
550S162	KFS 1622	Stud	-	9.46	9.44	9.43	9.38	9.32	-	-
600S162	KFS 1622	Stud	-	9.96	9.94	9.93	9.88	9.82	-	-
800S162	KFS 1622	Stud	-	11.96	11.94	11.93	11.88	11.82	-	-
350S200	KFS 1622	Stud	-	8.46	8.44	8.43	8.38	8.32	-	-
362S200	KFS 1622	Stud	-	8.58	8.57	8.55	8.50	8.45	-	-
400S200	KFS 1622	Stud	-	8.96	8.94	8.93	8.88	8.82	-	-
550S200	KFS 1622	Stud	-	10.46	10.44	10.43	10.38	10.32	-	-
600S200	KFS 1622	Stud	-	10.96	10.94	10.93	10.88	10.82	-	-
800S200	KFS 1622	Stud	-	12.96	12.94	12.93	12.88	12.82	-	-
350S250	KFS 1622	Stud	-	9.46	9.44	9.43	9.38	9.32	-	-
362S250	KFS 1622	Stud	-	9.58	9.57	9.55	9.50	9.45	-	-
400S250	KFS 1622	Stud	-	9.96	9.94	9.93	9.88	9.82	-	-
550S250	KFS 1622	Stud	-	11.46	11.44	11.43	11.38	11.32	-	-
600S250	KFS 1622	Stud	-	11.96	11.94	11.93	11.88	11.82	-	-
800S250	KFS 1622	Stud	-	13.96	13.94	13.93	13.88	13.82	-	-

Coil Width [in]										
Profiles	Rollformer	Type	Material Thickness [Mils]							
			18	27	30	33	43	54	68	97
350T150	KFS 1622	Track	-	6.47	6.47	6.47	6.47	6.46	-	-
362T150	KFS 1622	Track	-	6.60	6.60	6.60	6.59	6.59	-	-
400T150	KFS 1622	Track	-	6.97	6.97	6.97	6.97	6.96	-	-
550T150	KFS 1622	Track	-	8.47	8.47	8.47	8.47	8.46	-	-
600T150	KFS 1622	Track	-	8.97	8.97	8.97	8.97	8.96	-	-
800T150	KFS 1622	Track	-	10.97	10.97	10.97	10.97	10.96	-	-

Note:

- All dimensions are in Imperial units unless otherwise specified.
- Knudson KFD and KFS Framemaker series of roll formers can support a maximum steel grade of 65 ksi yield strength and 75 ksi ultimate tensile strength.

SECTION IV:ASTM A653M – 20 (METRIC)

SCOTPANEL AND SCOTTRUSS

Requirements and corresponding options in choosing coil in accordance with AS A653/A653M - 20 are tabulated below. Not all requirements are mandatory according to the code, but it is advisable to check with the steel supplier before the coil purchase.

<table>
<tr><th>No</th><th>Requirement</th><th colspan="3">Options</th></tr>
<tr><td>1</td><td>Designation of coating</td><td colspan="3">Zinc-coated</td></tr>
<tr><td>2</td><td>Name of the product</td><td colspan="3">Zinc-coated (galvanized)</td></tr>
<tr><td>3</td><td>Designation of sheet</td><td colspan="3">• SS
• HSLAS
• HSLAS-F</td></tr>
<tr><td>4</td><td>Designation of steel-grade</td><td colspan="3">SS – Grades 230 and 340 MPa - Class 1
HSLAS and HSLASF – Grade 340 MPa – Class 1</td></tr>
<tr><td>5</td><td>Designation of coating class</td><td colspan="3">Z275</td></tr>
<tr><td>6</td><td>Chemically treated or not</td><td colspan="3">No</td></tr>
<tr><td>7</td><td>Oiled or not oiled</td><td colspan="3">No</td></tr>
<tr><td>8</td><td>Surface finish</td><td colspan="3">• Regular spangle
• Spangle free</td></tr>
<tr><td>9</td><td>Extra smooth (if required)</td><td colspan="3">No</td></tr>
<tr><td>10</td><td>Phosphatized</td><td colspan="3">No</td></tr>
<tr><td rowspan="6">11*</td><td rowspan="6">Dimensions, including thickness, width and length and reference to AS/NZS for applicable tolerances</td><td colspan="3">SCOTPANEL Options</td></tr>
<tr><td>Roll former</td><td>Coil Width (mm)</td><td>Thickness (mm)</td></tr>
<tr><td>5090</td><td>190</td><td>0.75, 0.95,1.15</td></tr>
<tr><td>5140</td><td>244</td><td>0.75, 0.95, 1.15</td></tr>
<tr><td>7063</td><td>143</td><td>0.55, 0.75, 0.95</td></tr>
<tr><td>7070</td><td>153</td><td>0.55, 0.75, 0.95</td></tr>
</table>

		7076	156	0.55, 0.75, 0.95
		7090	173	0.55, 0.75, 0.95, 1.15
		7140	224	0.55, 0.75, 0.95, 1.15
		SCOTTRUSS Options		
		6050	173	0.55, 0.75, 0.95, 1.15
		6075	224	0.95, 1.15, 1.55
12	Coil size requirements	Refer row 11 for roll former specific requirements		
13	Packaging	Based on user/project requirements		
14	Certification if required, heat analysis and mechanical property report	**Requirement Options** – Yes/No **Frequency –** Based on user/project requirements		
15	Application	Part identification and description		
16	Any special or supplementary requirements	Based on user/project requirements		
17	If required, the product Base Metal Thickness	Refer to row 11 for roll former specific requirements		

Note:

- All dimensions are in Metric units unless otherwise stated.
- * - Refer to the Knudson section for KFD and KFS Framemaker coil widths.

KNUDSON BY SCOTTSDALE KFD AND KFS

The Knudson by Scottsdale KFD and KFS Framemaker models support multiple profiles to be rolled within a single machine. The attached table shows the coil width against all combinations in metric units.

Coil Width [mm]									
Profiles	**Rollformer**	**Type**	**Material Thickness [mm]**						
			0.48	**0.72**	**0.79**	**0.88**	**1.15**	**1.44**	**1.81**	**2.58**
162S125	KFD 2025	Stud	112	111	111	-	-	-	-	-
250S125	KFD 2025	Stud	134	133	133	-	-	-	-	-
362S125	KFD 2025	Stud	163	162	162	-	-	-	-	-
400S125	KFD 2025	Stud	172	172	171	-	-	-	-	-
600S125	KFD 2025	Stud	223	222	222	-	-	-	-	-
162T125	KFD 2025	Track	107	107	107	-	-	-	-	-
250T125	KFD 2025	Track	130	129	129	-	-	-	-	-
362T125	KFD 2025	Track	158	158	158	-	-	-	-	-
400T125	KFD 2025	Track	168	168	168	-	-	-	-	-
600T125	KFD 2025	Track	219	218	218	-	-	-	-	-
600S200	KFS 1218	Stud	-	-	-	-	275	274	272	268
800S200	KFS 1218	Stud	-	-	-	-	326	324	323	319
1000S200	KFS 1218	Stud	-	-	-	-	377	375	373	370
1200S200	KFS 1218	Stud	-	-	-	-	427	426	424	420
600S250	KFS 1218	Stud	-	-	-	-	300	299	297	293
800S250	KFS 1218	Stud	-	-	-	-	351	350	348	344
1000S250	KFS 1218	Stud	-	-	-	-	402	401	399	395
1200S250	KFS 1218	Stud	-	-	-	-	453	451	450	446
600T150	KFS 1218	Track	-	-	-	-	227	232	232	231
800T150	KFS 1218	Track	-	-	-	-	278	283	282	282
1000T150	KFS 1218	Track	-	-	-	-	329	333	333	333
1200T150	KFS 1218	Track	-	-	-	-	379	384	384	384
362S162	KFS 1420	Stud	191	-	-	191	189	188	186	-
400S162	KFS 1420	Stud	200	-	-	200	199	197	196	-
600S162	KFS 1420	Stud	251	-	-	251	250	248	246	-
800S162	KFS 1420	Stud	302	-	-	302	300	299	297	-
1000S162	KFS 1420	Stud	353	-	-	352	351	350	348	-
1200S162	KFS 1420	Stud	404	-	-	403	402	401	399	-
362S200	KFS 1420	Stud	216	-	-	216	215	213	211	-

Coil Width [mm]									
Profiles	**Rollformer**	**Type**	**Material Thickness [mm]**						
			0.48	**0.72**	**0.79**	**0.88**	**1.15**	**1.44**	**1.81**	**2.58**
400S200	KFS 1420	Stud	226	-	-	225	224	223	221	-
600S200	KFS 1420	Stud	277	-	-	276	275	274	272	-
800S200	KFS 1420	Stud	327	-	-	327	326	324	323	-
1000S200	KFS 1420	Stud	378	-	-	378	377	375	373	-
1200S200	KFS 1420	Stud	429	-	-	429	427	426	424	-
362S250	KFS 1420	Stud	242	-	-	241	240	239	237	-
400S250	KFS 1420	Stud	251	-	-	251	250	248	246	-
600S250	KFS 1420	Stud	302	-	-	302	300	299	297	-
800S250	KFS 1420	Stud	353	-	-	352	351	350	348	-
1000S250	KFS 1420	Stud	404	-	-	403	402	401	399	-
1200S250	KFS 1420	Stud	454	-	-	454	453	451	450	-
362T150	KFS 1420	Track	167	-	-	167	167	167	166	-
400T150	KFS 1420	Track	176	-	-	176	176	176	176	-
600T150	KFS 1420	Track	227	-	-	227	227	227	227	-
800T150	KFS 1420	Track	278	-	-	278	278	278	278	-
1000T150	KFS 1420	Track	329	-	-	329	329	329	328	-
1200T150	KFS 1420	Track	380	-	-	380	379	379	379	-
350S162	KFS 1622	Stud	-	189	189	189	187	186	-	-
362S162	KFS 1622	Stud	-	193	192	192	191	189	-	-
400S162	KFS 1622	Stud	-	202	202	201	200	199	-	-
550S162	KFS 1622	Stud	-	240	240	239	238	237	-	-
600S162	KFS 1622	Stud	-	253	253	252	251	249	-	-
800S162	KFS 1622	Stud	-	304	303	303	302	300	-	-
350S200	KFS 1622	Stud	-	215	214	214	213	211	-	-
362S200	KFS 1622	Stud	-	218	218	217	216	215	-	-
400S200	KFS 1622	Stud	-	228	227	227	225	224	-	-
550S200	KFS 1622	Stud	-	266	265	265	264	262	-	-
600S200	KFS 1622	Stud	-	278	278	278	276	275	-	-
800S200	KFS 1622	Stud	-	329	329	328	327	326	-	-
350S250	KFS 1622	Stud	-	240	240	239	238	237	-	-
362S250	KFS 1622	Stud	-	243	243	243	241	240	-	-
400S250	KFS 1622	Stud	-	253	253	252	251	249	-	-
550S250	KFS 1622	Stud	-	291	291	290	289	288	-	-
600S250	KFS 1622	Stud	-	304	303	303	302	300	-	-
800S250	KFS 1622	Stud	-	355	354	354	352	351	-	-

Coil Width [mm]									
Profiles	**Rollformer**	**Type**	**Material Thickness [mm]**						
			0.48	**0.72**	**0.79**	**0.88**	**1.15**	**1.44**	**1.81**	**2.58**
350T150	KFS 1622	Track	-	164	164	164	164	164	-	-
362T150	KFS 1622	Track	-	168	168	168	167	167	-	-
400T150	KFS 1622	Track	-	177	177	177	177	177	-	-
550T150	KFS 1622	Track	-	215	215	215	215	215	-	-
600T150	KFS 1622	Track	-	228	228	228	228	228	-	-
800T150	KFS 1622	Track	-	279	279	279	279	278	-	-

Note:

- All dimensions are in Metric units unless otherwise specified.

Knudson KFD and KFS Framemaker series of roll formers can support a maximum steel grade of 450 MPa yield strength and 520 MPa ultimate tensile strength.

SECTION V:EN 10346:2015

Requirements and corresponding options in choosing coil in accordance with EN 10346:2015 are tabulated below. Some requirements are mandatory according to the code while there is some optional information provided as well. It is advisable to check with the steel supplier before the coil purchase.

SCOTPANEL AND SCOTTRUSS MANDATORY INFORMATION

<table>
<tr><th>No</th><th>Requirement</th><th colspan="3">Options</th></tr>
<tr><td>A</td><td>Quantity to be delivered</td><td colspan="3">Based on user/project requirements</td></tr>
<tr><td>B</td><td>Type of product</td><td colspan="3">• Strip
• Sheet
• Cut length</td></tr>
<tr><td>C</td><td>Number of the dimensional standard</td><td colspan="3">EN 10143</td></tr>
<tr><td rowspan="12">D*</td><td rowspan="12">Dimensions, including thickness, width and length and reference to AS/NZS for applicable tolerances</td><td colspan="3">SCOTPANEL Options</td></tr>
<tr><td>Roll former</td><td>Coil Width (mm)</td><td>Thickness (mm)</td></tr>
<tr><td>5090</td><td>190</td><td>0.75, 0.95,1.15</td></tr>
<tr><td>5140</td><td>244</td><td>0.75, 0.95, 1.15</td></tr>
<tr><td>7063</td><td>143</td><td>0.55, 0.75, 0.95</td></tr>
<tr><td>7070</td><td>153</td><td>0.55, 0.75, 0.95</td></tr>
<tr><td>7076</td><td>156</td><td>0.55, 0.75, 0.95</td></tr>
<tr><td>7090</td><td>173</td><td>0.55, 0.75, 0.95, 1.15</td></tr>
<tr><td>7140</td><td>224</td><td>0.55, 0.75, 0.95, 1.15</td></tr>
<tr><td colspan="3">SCOTTRUSS Options</td></tr>
<tr><td>6050</td><td>173</td><td>0.55, 0.75, 0.95, 1.15</td></tr>
<tr><td>6075</td><td>224</td><td>0.95, 1.15, 1.55</td></tr>
<tr><td>E</td><td>Nominal dimensions and tolerances on dimensions</td><td colspan="3">Not applicable</td></tr>
</table>

	and shape and, if applicable. Letters denoting relevant special tolerances	
F	Nomenclature	Steel
G	Number of the standard	EN 10346
H	Steel name or steel number and symbol for the type of hot-dip coating as given in Tables 1 to 5	• S350GD+z • S450GD+z
I	Number designating the nominal mass of coating	Z275 – 275 g/m^2
J	Letter denoting the coating finish	N (Normal spangle)
K	Letter denoting the surface quality	• A (As coated surface) • B (Improved surface) • C (Best quality surface)
L	Letter denoting the surface treatment	C (Chemical passivation)

OPTIONAL INFORMATION

1	Specification of product thickness deviating from those generally covered in the scope (i.e. t<0.20 mm or 3 mm ≤ t ≤ 6.5 mm)	Not applicable
2	Specification of hot-rolled products deviating from those generally covered in the scope	Not applicable
3	Verification of the product analysis	Physical verification if needed
4	Date of supply of products free from stretcher strains when cold forming	Not applicable
5	Products supplied suitable for the manufacturer of a specific part	Not applicable
6	Coating masses different from those of Table 12 and/or special requirements for different coating masses on each surface	Not applicable
7	Special coating and/or surface qualities	Not applicable

8	Hot-dip zinc-coated products with pronounced spangle	Not applicable
9	Special requirements for a maximum Al-Fe-Si alloy layer mass occurring during hot-dip aluminum-silicon coating	Not applicable
10	Hot-dip coated products with surface quality A without skin passing	Not applicable
11	Requirement for special applications on bright appearance for aluminum-silicon coated products (type B surface)	Not applicable
12	Range and verification of surface roughness	Not applicable
13	Selection of protective oil	Not applicable
14	Type of S coating	Not applicable
15	Products free from coil breaks	Based on user/project requirements
16	Maximum or Minimum value for the coating mass on each product side	Not applicable
17	Type of inspection and if applicable, inspection document to be delivered	Based on user/project requirements
18	Determination of the tensile properties/ and or the Bake-Hardening Index BH2 and/or the coating mass by calculation	Not applicable
19	Notification of which surface has been inspected	Based on user/project requirements
20	Marking desired by branding of the products	Based on user/project requirements
21	Requirement for packing	Based on user/project requirements

Note:

- All dimensions are in Metric units unless otherwise specified.
- For further information refer to Section 5 of EN 10346:2015.
- * - Refer to the Knudson section for KFD and KFS Framemaker coil widths.

KNUDSON BY SCOTTSDALE KFD AND KFS

The Knudson KFD and KFS Framemaker models support multiple profiles to be rolled within a single machine. The attached table shows the coil width against all combinations in metric units.

Coil Width [mm]										
Profiles	**Rollformer**	**Type**	**Material Thickness [mm]**							
			0.48	**0.72**	**0.79**	**0.88**	**1.15**	**1.44**	**1.81**	**2.58**
162S125	KFD 2025	Stud	112	111	111	-	-	-	-	-
250S125	KFD 2025	Stud	134	133	133	-	-	-	-	-
362S125	KFD 2025	Stud	163	162	162	-	-	-	-	-
400S125	KFD 2025	Stud	172	172	171	-	-	-	-	-
600S125	KFD 2025	Stud	223	222	222	-	-	-	-	-
162T125	KFD 2025	Track	107	107	107	-	-	-	-	-
250T125	KFD 2025	Track	130	129	129	-	-	-	-	-
362T125	KFD 2025	Track	158	158	158	-	-	-	-	-
400T125	KFD 2025	Track	168	168	168	-	-	-	-	-
600T125	KFD 2025	Track	219	218	218	-	-	-	-	-
600S200	KFS 1218	Stud	-	-	-	-	275	274	272	268
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600S250	KFS 1218	Stud	-	-	-	-	300	299	297	293
800S250	KFS 1218	Stud	-	-	-	-	351	350	348	344
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1200S250	KFS 1218	Stud	-	-	-	-	453	451	450	446
600T150	KFS 1218	Track	-	-	-	-	227	232	232	231
800T150	KFS 1218	Track	-	-	-	-	278	283	282	282
1000T150	KFS 1218	Track	-	-	-	-	329	333	333	333
1200T150	KFS 1218	Track	-	-	-	-	379	384	384	384
362S162	KFS 1420	Stud	191	-	-	191	189	188	186	-
400S162	KFS 1420	Stud	200	-	-	200	199	197	196	-
600S162	KFS 1420	Stud	251	-	-	251	250	248	246	-
800S162	KFS 1420	Stud	302	-	-	302	300	299	297	-
1000S162	KFS 1420	Stud	353	-	-	352	351	350	348	-
1200S162	KFS 1420	Stud	404	-	-	403	402	401	399	-
362S200	KFS 1420	Stud	216	-	-	216	215	213	211	-

Coil Width [mm]									
Profiles	**Rollformer**	**Type**	**Material Thickness [mm]**						
			0.48	**0.72**	**0.79**	**0.88**	**1.15**	**1.44**	**1.81**	**2.58**
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1000S200	KFS 1420	Stud	378	-	-	378	377	375	373	-
1200S200	KFS 1420	Stud	429	-	-	429	427	426	424	-
362S250	KFS 1420	Stud	242	-	-	241	240	239	237	-
400S250	KFS 1420	Stud	251	-	-	251	250	248	246	-
600S250	KFS 1420	Stud	302	-	-	302	300	299	297	-
800S250	KFS 1420	Stud	353	-	-	352	351	350	348	-
1000S250	KFS 1420	Stud	404	-	-	403	402	401	399	-
1200S250	KFS 1420	Stud	454	-	-	454	453	451	450	-
362T150	KFS 1420	Track	167	-	-	167	167	167	166	-
400T150	KFS 1420	Track	176	-	-	176	176	176	176	-
600T150	KFS 1420	Track	227	-	-	227	227	227	227	-
800T150	KFS 1420	Track	278	-	-	278	278	278	278	-
1000T150	KFS 1420	Track	329	-	-	329	329	329	328	-
1200T150	KFS 1420	Track	380	-	-	380	379	379	379	-
350S162	KFS 1622	Stud	-	189	189	189	187	186	-	-
362S162	KFS 1622	Stud	-	193	192	192	191	189	-	-
400S162	KFS 1622	Stud	-	202	202	201	200	199	-	-
550S162	KFS 1622	Stud	-	240	240	239	238	237	-	-
600S162	KFS 1622	Stud	-	253	253	252	251	249	-	-
800S162	KFS 1622	Stud	-	304	303	303	302	300	-	-
350S200	KFS 1622	Stud	-	215	214	214	213	211	-	-
362S200	KFS 1622	Stud	-	218	218	217	216	215	-	-
400S200	KFS 1622	Stud	-	228	227	227	225	224	-	-
550S200	KFS 1622	Stud	-	266	265	265	264	262	-	-
600S200	KFS 1622	Stud	-	278	278	278	276	275	-	-
800S200	KFS 1622	Stud	-	329	329	328	327	326	-	-
350S250	KFS 1622	Stud	-	240	240	239	238	237	-	-
362S250	KFS 1622	Stud	-	243	243	243	241	240	-	-
400S250	KFS 1622	Stud	-	253	253	252	251	249	-	-
550S250	KFS 1622	Stud	-	291	291	290	289	288	-	-
600S250	KFS 1622	Stud	-	304	303	303	302	300	-	-
800S250	KFS 1622	Stud	-	355	354	354	352	351	-	-

Coil Width [mm]									
Profiles	Rollformer	Type	Material Thickness [mm]							
			0.48	0.72	0.79	0.88	1.15	1.44	1.81	2.58
350T150	KFS 1622	Track	-	164	164	164	164	164	-	-
362T150	KFS 1622	Track	-	168	168	168	167	167	-	-
400T150	KFS 1622	Track	-	177	177	177	177	177	-	-
550T150	KFS 1622	Track	-	215	215	215	215	215	-	-
600T150	KFS 1622	Track	-	228	228	228	228	228	-	-
800T150	KFS 1622	Track	-	279	279	279	279	278	-	-

Note:

- All dimensions are in Metric units unless otherwise specified.

Knudson KFD and KFS Framemaker series of roll formers can support a maximum steel grade of 450 MPa yield strength and 520 MPa ultimate tensile strength.

SCOTTSDALE

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