STEEL COIL ORDERING INFORMATION

Version 2025.3

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, 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 coil is essential in producing cold-formed steel framing. Selecting the appropriate steel coil specification ensures better steel framing performance. In addition to using best-in-class roll-forming equipment such as Scotpanel, Scottruss, and Knudson by Scottsdale KFD and KFS Framemaker models, the quality of steel framing depends on the mechanical properties of the steel coil. This document summarizes the ordering specifications for the significant global codes listed below.

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

This information will help select the correct steel coil for your desired application and ensure compatibility with the Scottsdale and Knudson by Scottsdale roll formers.

The table below provides a quick conversion chart between imperial and metric units.

Mils	mm	in.	Gauge
18	0.47752	0.0188	25
-	0.55626	0.0219	24
27	0.71882	0.0283	22
30	0.79248	0.0312	20-Interior
33	0.87884	0.0346	20
43	1.1455	0.0451	18
54	1.4376	0.0566	16
68	1.811	0.0713	14
97	2.5832	0.1017	12
118	3.1547	0.1242	10

SECTION II AS 1397

The table below outlines the requirements and options for selecting a coil in accordance with AS 1397:2021/2011. Although the code does not mandate all requirements, confirming with the steel supplier before purchasing the coil is recommended.

GENERAL REQUIREMENTS

No	Requirement	Options
1	The number of the corresponding Australian Standards	AS 1397:2021/2011
2	Type of product required	• Coil strip • Coil length
3	Designation of steel grade	Naming convention as per AS 1397/Grade Coating. Refer corresponding roll former section for more details.
4	Designation of coating class	• AM150 • Z275
5	Surface finish, including any chemical treatment required	• Regular spangle – **R** • Spangle free – **f**
6	Quantity (mass, or number of sheets) and delivery instructions (dates, schedules, delivery points)	Based on user/project requirements
7	Defects allowable	Based on user/project requirements
8	Testing requirements, the frequency of testing and whether a test certificate is required	**Requirement Options** – Yes/No **Frequency –** Based on user/project requirements

9	Whether the purchaser intends to inspect the coated steel at the manufacturer's work	Yes/No
10	Any special or supplementary requirements	Based on user/project requirements
11	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

SCOTPANEL AND SCOTTRUSS

SCOTPANEL

Roll former	Grade	Thickness [mm]	F_y [MPa]	F_u [MPa]	Coil Width [mm]
5090	G550	0.75	495	495	192
	G550	0.95	550	550	
	G350	0.75, 0.95, 1.15	350	420	
5140	G550	0.75	495	495	244
	G550	0.95	550	550	
	G350	0.75, 0.95, 1.15	350	420	
7063	G550	0.55	413	413	143
	G550	0.75	495	495	
	G550	0.95	550	550	
	G350	0.55, 0.75, 0.95	350	420	
7070	G550	0.55	413	413	153
	G550	0.75	495	495	
	G550	0.95	550	550	
	G350	0.55, 0.75, 0.95	350	420	
7076	G550	0.55	413	413	156
	G550	0.75	495	495	
	G550	0.95	550	550	
	G350	0.55, 0.75, 0.95	350	420	
7090	G550	0.55	413	413	173
	G550	0.75	495	495	
	G550	0.95	550	550	
	G350	0.75, 0.95, 1.15	350	420	
7140	G550	0.55	413	413	224

Roll former	Grade	Thickness [mm]	F_y [MPa]	F_u [MPa]	Coil Width [mm]
	G550	0.75	495	495	
	G550	0.95	550	550	
	G350	0.75, 0.95, 1.15	350	420	

SCOTTRUSS

Roll former	Grade	Thickness [mm]	F_y [MPa]	F_u [MPa]	Coil Width [mm]
6050	G550	0.55	413	413	173
	G550	0.75	495	495	
	G550	0.95	550	550	
	G350	0.75, 0.95, 1.15	350	420	
6075	G550	0.95	550	550	224
	G500	1.15	500	520	
	G350	0.95, 1.15, 1.55	350	420	

Note:

- All dimensions are in metric units unless otherwise specified.
- For further information, refer to Appendix A of AS 1397:2021.
- All thickness quoted are Base Metal Thickness (BMT) unless otherwise specified.
- F_y = Yield strength
- F_u = Ultimate tensile strength

KNUDSON BY SCOTTSDALE KFD AND KFS FRAMEMAKER

The Knudson by Scottsdale KFD and KFS Framemaker models support multiple profiles to be rolled within a single machine.

The table below shows the steel grades supported by the roll formers.

Roll former	Grade	Thicknesses [mm]	F_y [MPa]	F_u [MPa]
All KFD and KFS roll formers	G350	0.48, 0.72, 0.88, 1.15, 1.44, 1.81, 2.58	350	420
	G450	1.44, 1.81, 2.58	450	480

Note: If AS 1397 is followed, the closest thickness available from the steel supplier must be chosen.

The attached table shows the coil width against all combinations in metric units.

Coil Width [mm]									
Profiles	Roll former	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	-	-	-	-	-
162T200	KFD 2025	Track	145	144	144	-	-	-	-	-
250T200	KFD 2025	Track	167	166	166	-	-	-	-	-
362T200	KFD 2025	Track	195	195	194	-	-	-	-	-
400T200	KFD 2025	Track	205	204	204	-	-	-	-	-
600T200	KFD 2025	Track	256	255	255	-	-	-	-	-
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

Coil Width [mm]									
Profiles	**Roll former**	**Type**	**Material Thickness [mm]**						
			0.48	**0.72**	**0.79**	**0.88**	**1.15**	**1.44**	**1.81**	**2.58**
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	-
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	-	-

Coil Width [mm]									
Profiles	**Roll former**	**Type**	**Material Thickness [mm]**						
			0.48	**0.72**	**0.79**	**0.88**	**1.15**	**1.44**	**1.81**	**2.58**
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	-	-
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.
- All thickness quoted are Base Metal Thickness (BMT) unless otherwise specified.

SECTION III ASTM A653 – 20 (IMPERIAL)

GENERAL REQUIREMENTS

The table below outlines the requirements and options for selecting a coil in accordance with A653/A653M - 20. Although the code does not mandate all requirements, confirming with the steel supplier before purchasing the coil is recommended.

No	Requirement	Options
1	Designation of coating	Zinc-coated
2	Name of the product	Zinc-coated (galvanized)
3	Designation of sheet	• SS • HSLAS • HSLAS-F
4	Designation of steel grade	SS – Grades 33, 50 Class 1, 60, 70 and 80 Class 1 HSLAS and HSLASF – Grade 50, 60, 70 Refer to the sections below for roll former specific requirements.
5	Designation of coating class	G60, G90, AZ50/AZM150
6	Chemically treated or not	No
7	Oiled or not oiled	Not Oiled
8	Surface finish	• Regular spangle • Spangle free
9	Extra smooth (if required)	No
10	Phosphatized	No

11	Dimensions, including thickness, width and length and reference to AS/NZS for applicable tolerances	Refer to the sections below for roll former specific requirements
12	Coil size requirements	Refer to the sections below 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 the sections below for roll former specific requirements

SCOTPANEL AND SCOTTRUSS

SCOTPANEL

Roll former	Grade	Thickness [Mils]	F_y [ksi]	F_u [ksi]	Coil Width [in.]
5090	33	22, 20, 20-Interior, 18	33	45	7.55
	50 Class 1*		50	65	
	60	22, 20, 20-Interior	60	70	
	70		70	80	
	80 Class 1#		80	82	
5140	33	22, 20, 20-Interior, 18	33	45	9.60
	50 Class 1*		50	65	
	60	22, 20, 20-Interior	60	70	
	70		70	80	
	80 Class 1#		80	82	
7063	33	24, 22, 20, 20-Interior	33	45	5.63
	50 Class 1*		50	65	
	60		60	70	
	70		70	80	
	80 Class 1#		80	82	
7070	33	24, 22, 20, 20-Interior	33	45	6.02
	50 Class 1*		50	65	
	60		60	70	
	70		70	80	
	80 Class 1#		80	82	
7076	33	24, 22, 20, 20-Interior	33	45	6.14
	50 Class 1*		50	65	

Roll former	Grade	Thickness [Mils]	F_y [ksi]	F_u [ksi]	Coil Width [in.]
	60		60	70	
	70		70	80	
	80 Class 1#		80	82	
7090	33	24, 22, 20, 20-Interior, 18	33	45	6.81
	50 Class 1*		50	65	
	60	24, 22, 20, 20-Interior	60	70	
	70		70	80	
	80 Class 1#		80	82	
7140	33	24, 22, 20, 20-Interior, 18	33	45	8.81
	50 Class 1*		50	65	
	60	24, 22, 20, 20-Interior	60	70	
	70		70	80	
	80 Class 1#		80	82	

SCOTTRUSS

Roll former	Grade	Thickness [Ga.]	F_y [ksi]	F_u [ksi]	Coil Width [in.]
6050	33	24, 22, 20, 20-Interior, 18	33	45	6.81
	50 Class 1*		50	65	
	60	24, 22, 20, 20-Interior	60	70	
	70		70	80	
	80 Class 1#		80	82	
6075	33	20, 20-Interior, 18, 16	33	45	8.81
	50 Class 1*		50	65	
	60	20, 20-Interior	60	70	
	70		70	80	
	80 Class 1#		80	82	

Note:

- All dimensions are in imperial units unless otherwise specified.
- All thickness quoted are Base Metal Thickness (BMT) unless otherwise specified.
- F_y = Yield strength
- F_u = Ultimate tensile strength
- * - “50 Class 1” grade corresponds to designation “SS”. If HSLAS or HSLAS-F is used, then Fy = 50 ksi and Fu = 60 ksi, respectively.
- * - “80 Class 1” grade corresponds to designation “SS” only.

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 table below shows the steel grades supported by the roll formers.

Roll former	Grade	Thickness [Mils]	F_y [ksi]	F_u [ksi]
All KFD and KFS roll formers	33 ksi	18, 27, 30, 33, 43, 54, 68, 97	33	45
	50 ksi	18, 27, 30, 33, 43, 54, 68, 97	50	65
	60 ksi	18, 27, 30, 33, 43, 54, 68, 97	60	70

The attached table shows the coil width against all combinations in imperial units.

Coil Width [in.]									
Profiles	Roll former	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	-	-	-	-	-
162T200	KFD 2025	Track	5.69	5.66	5.66	-	-	-	-	-
250T200	KFD 2025	Track	6.56	6.54	6.53	-	-	-	-	-
362T200	KFD 2025	Track	7.69	7.66	7.66	-	-	-	-	-
400T200	KFD 2025	Track	8.06	8.04	8.03	-	-	-	-	-
600T200	KFD 2025	Track	10.06	10.04	10.03	-	-	-	-	-
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

Coil Width [in.]									
Profiles	**Roll former**	**Type**	**Material Thickness [Mils]**						
			18	**27**	**30**	**33**	**43**	**54**	**68**	**97**
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	-
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	-	-

Coil Width [in.]									
Profiles	**Roll former**	**Type**	**Material Thickness [Mils]**						
			18	**27**	**30**	**33**	**43**	**54**	**68**	**97**
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	-	-
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.
- All thickness quoted are Base Metal Thickness (BMT) unless otherwise specified.

SECTION IV ASTM A653M – 20 (METRIC)

GENERAL REQUIREMENTS

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 purchase.

No	Requirement	Options
1	Designation of coating	Zinc-coated
2	Name of the product	Zinc-coated (galvanized)
3	Designation of sheet	• SS • HSLAS • HSLAS-F
4	Designation of steel grade	SS – Grades 33, 50 Class 1, 60, 70 and 80 Class 1 HSLAS and HSLASF – Grade 50, 60, 70 Refer to the sections below for roll former specific requirements.
5	Designation of coating class	G60, G90, AZ50/AZM150
6	Chemically treated or not	No
7	Oiled or not oiled	Not Oiled
8	Surface finish	• Regular spangle • Spangle free
9	Extra smooth (if required)	No
10	Phosphatized	No

11	Dimensions, including thickness, width and length and reference to AS/NZS for applicable tolerances	Refer to the sections below for roll former specific requirements
12	Coil size requirements	Refer to the sections below 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 the sections below for roll former specific requirements

SCOTPANEL AND SCOTTRUSS

SCOTPANEL

Roll former	Grade	Thickness [mm]	F_y [MPa]	F_u [MPa]	Coil Width [mm]
5090	230	0.72, 0.79, 0.88, 1.15	230	310	192
	340 Class 1*		340	450	
	410	0.72, 0.79, 0.88	410	480	
	480		480	550	
	550 Class 1#		550	570	
5140	230	0.72, 0.79, 0.88, 1.15	230	310	244
	340 Class 1*		340	450	
	410	0.72, 0.79, 0.88	410	480	
	480		480	550	
	550 Class 1#		550	570	
7063	230	0.55, 0.72, 0.79, 0.88, 1.15	230	310	143
	340 Class 1*		340	450	
	410	0.55, 0.72, 0.79, 0.88	410	480	
	480		480	550	
	550 Class 1#		550	570	
7070	230	0.55, 0.72, 0.79, 0.88	230	310	153
	340 Class 1*		340	450	
	410		410	480	
	480		480	550	
	550 Class 1#		550	570	
7076	230	0.55, 0.72, 0.79, 0.88	230	310	156
	340 Class 1*		340	450	

Roll former	Grade	Thickness [mm]	F_y [MPa]	F_u [MPa]	Coil Width [mm]
	410		410	480	
	480		480	550	
	550 Class 1#		550	570	
7090	230	0.55, 0.72, 0.79, 0.88, 1.15	230	310	173
	340 Class 1*		340	450	
	410	0.55, 0.72, 0.79, 0.88	410	480	
	480		480	550	
	550 Class 1#		550	570	
7140	230	0.55, 0.72, 0.79, 0.88, 1.15	230	310	224
	340 Class 1*		340	450	
	410	0.55, 0.72, 0.79, 0.88	410	480	
	480		480	550	
	550 Class 1#		550	570	

SCOTTRUSS

Roll former	Grade	Thickness [mm]	F_y [MPa]	F_u [MPa]	Coil Width [mm]
6050	230	0.55, 0.72, 0.79, 0.88, 1.15	230	310	173
	340 Class 1*		340	450	
	410	0.55, 0.72, 0.79, 0.88	410	480	
	480		480	550	
	550 Class 1#		550	570	
6075	230	0.88, 1.15, 1.44	230	310	224
	340 Class 1*		340	450	
	410	0.88	410	480	
	480		480	550	
	550 Class 1#		550	570	

Note:

- All dimensions are in imperial units unless otherwise specified.
- All thickness quoted are Base Metal Thickness (BMT) unless otherwise specified.
- F_y = Yield strength
- F_u = Ultimate tensile strength
- * - “340 Class 1” grade corresponds to designation “SS”. If HSLAS or HSLAS-F is used, then Fy = 340 ksi and Fu = 450 ksi, respectively.
- * - “550 Class 1” grade corresponds to designation “SS” only.

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 table below shows the steel grades supported by the roll formers.

Grade	Thicknesses [mm]	Fy [MPa]	Fu [MPa]
230	0.48, 0.72, 0.79, 0.88, 1.15, 1.44, 1.81, 2.58	230	310
340 Class 1*	0.48, 0.72, 0.79, 0.88, 1.15, 1.44, 1.81, 2.58	340	450
410	0.48, 0.72, 0.79, 0.88, 1.15, 1.44, 1.81, 2.58	410	480

The attached table shows the coil width against all combinations in metric units.

Coil Width [mm]									
Profiles	Roll former	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	-	-	-	-	-
162T200	KFD 2025	Track	145	144	144	-	-	-	-	-
250T200	KFD 2025	Track	167	166	166	-	-	-	-	-
362T200	KFD 2025	Track	195	195	194	-	-	-	-	-
400T200	KFD 2025	Track	205	204	204	-	-	-	-	-
600T200	KFD 2025	Track	256	255	255	-	-	-	-	-
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

Coil Width [mm]									
Profiles	**Roll former**	**Type**	**Material Thickness [mm]**						
			0.48	**0.72**	**0.79**	**0.88**	**1.15**	**1.44**	**1.81**	**2.58**
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	-
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	-	-

Coil Width [mm]									
Profiles	**Roll former**	**Type**	**Material Thickness [mm]**						
			0.48	**0.72**	**0.79**	**0.88**	**1.15**	**1.44**	**1.81**	**2.58**
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	-	-
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.
- All thickness quoted are Base Metal Thickness (BMT) unless otherwise specified.
- * - “340 Class 1” grade corresponds to designation “SS”. If HSLAS or HSLAS-F is used, then Fy = 340 ksi and Fu = 450 ksi, respectively.

SECTION V EN 10346

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.

GENERAL REQUIREMENTS

MANDATORY INFORMATION

No	Requirement	Options
A	Quantity to be delivered	Based on user/project requirements
B	Type of product	• Strip • Sheet • Cut length
C	Number of the dimensional standard	EN 10143
D	Dimensions, including thickness, width and length and reference to AS/NZS for applicable tolerances	Refer to the sections below for roll former specific requirements
E	Nominal dimensions and tolerances on dimensions and shape and, if applicable. Letters denoting relevant special tolerances	Not applicable
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	Refer to the sections below for roll former specific requirements
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

SCOTPANEL AND SCOTTRUSS

SCOTPANEL

Roll former	Grade	Thickness [mm]	F_y [MPa]	F_u [MPa]	Coil Width [mm]
5090	S350GD+z	0.75, 0.95, 1.15	350	420	192
	S450GD+z	0.75, 0.95	450	480	
5140	S350GD+z	0.75, 0.95, 1.15	350	420	244
	S450GD+z	0.75, 0.95	450	480	
7063	S350GD+z	0.55, 0.75, 0.95	350	420	143
	S450GD+z	0.55, 0.75, 0.95	450	480	
7070	S350GD+z	0.55, 0.75, 0.95	350	420	153
	S450GD+z	0.55, 0.75, 0.95	450	480	
7076	S350GD+z	0.55, 0.75, 0.95	350	420	156
	S450GD+z	0.55, 0.75, 0.95	450	480	
7090	S350GD+z	0.55, 0.75, 0.95, 1.15	350	420	173
	S450GD+z	0.55, 0.75, 0.95	450	480	
7140	S350GD+z	0.55, 0.75, 0.95, 1.15	350	420	224
	S450GD+z	0.55, 0.75, 0.95	450	480	

SCOTTRUSS

Roll former	Grade	Thickness [mm]	F_y [MPa]	F_u [MPa]	Coil Width [mm]
6050	S350GD+z	0.55, 0.75, 0.95, 1.15	350	420	173
	S450GD+z	0.55, 0.75, 0.95	450	480	
6075	S350GD+z	0.95, 1.15, 1.55	350	420	224
	S450GD+z	0.95	450	480	

Note:

- All dimensions are in metric units unless otherwise specified.
- For further information, refer to Section 5 of EN 10346:2015.
- #S450GD+z 1.15 mm steel is supported only by Scottruss rollformers. S350GD+z 1.15 mm steel must be used on Scotpanel rollformers.
- All thickness quoted are Base Metal Thickness (BMT) unless otherwise specified.
- F_y = Yield strength
- F_u = Ultimate tensile strength

KNUDSON BY SCOTTSDALE KFD AND KFS

The Knudson KFD and KFS Framemaker models support multiple profiles to be rolled within a single machine.

The table below shows the steel grades supported by the roll formers.

Grade	Thicknesses [mm]	Fy [MPa]	Fu [MPa]
S350GD+z	0.48, 0.72, 0.79, 0.88, 1.15, 1.44, 1.81, 2.58	350	420
S450GD+z	0.48, 0.72, 0.79, 0.88, 1.15, 1.44, 1.81, 2.58	450	480

Note: If EN 10346 is followed, the closest thickness available from the steel supplier must be chosen.

The attached table shows the coil width against all combinations in metric units.

Coil Width [mm]									
Profiles	Roll former	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	-	-	-	-	-
162T200	KFD 2025	Track	145	144	144	-	-	-	-	-
250T200	KFD 2025	Track	167	166	166	-	-	-	-	-
362T200	KFD 2025	Track	195	195	194	-	-	-	-	-
400T200	KFD 2025	Track	205	204	204	-	-	-	-	-
600T200	KFD 2025	Track	256	255	255	-	-	-	-	-
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

Coil Width [mm]									
Profiles	**Roll former**	**Type**	**Material Thickness [mm]**						
			0.48	**0.72**	**0.79**	**0.88**	**1.15**	**1.44**	**1.81**	**2.58**
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	-
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	-	-

Coil Width [mm]									
Profiles	**Roll former**	**Type**	**Material Thickness [mm]**						
			0.48	**0.72**	**0.79**	**0.88**	**1.15**	**1.44**	**1.81**	**2.58**
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	-	-
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.
- All thickness quoted are Base Metal Thickness (BMT) unless otherwise specified.

SECTION VI DECOILER SPECIFICATIONS

Scottsdale offers a variety of decoilers for all the roll former models. The table below lists the respective coil handling capacity and specifications.

DECOILER SPECIFICATIONS - METRIC

Designation	Compatible roll formers	Coil width range [mm]	Capacity [kg]	ID range [mm]	Max OD range [mm]
Light duty	Scottsdale	114 to 244	1500	500	1200
Medium duty	Scottsdale and Knudson KFD and KFS Framemaker	610 Max	2041	400 to 520	1524
Medium duty	Scottsdale and Knudson KFD and KFS Framemaker	610 Max	2948	400 to 520	1524
Heavy duty	Scottsdale and Knudson KFD and KFS Framemaker	610 Max	4535	430 to 530	1525

DECOILER SPECIFICATIONS - IMPERIAL

Designation	Compatible roll formers	Coil width range [in.]	Capacity [lbs.]	ID range [in.]	Max OD range [in.]
Light duty	Scottsdale	4.48 to 9.6	3300	19.68	47.24
Medium duty	Scottsdale and Knudson KFD and KFS Framemaker	24	4500	15.8 to 20.4	60
Medium duty	Scottsdale and Knudson KFD and KFS Framemaker	24	6500	15.8 to 20.4	60
Heavy duty	Scottsdale and Knudson KFD and KFS Framemaker	24	10000	18 to 20	60

Note

ID = Inside diameter and OD = Outside diameter

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