1 Steel Cord

1.1 General Characteristics

1.1.1 Welds and splices

Continuous lengths are supplied which means that:
  a. filament splices are permitted
  b. cord welds are permitted and should withstand a minimum load equal to 40% of the breaking load of the cord. The increase in diameter of the finished weld should not exceed the cord diameter by more than 15%
  c. number of cord welds will not exceed
     3 per spool type BS40 or BS60
     4 per spool type BS80

1.1.2 Tolerance on individual value

- Cord diameter: ± 5%
- Linear density: ± 5%
- Length of cord per spool:
  ± 0.75% if cord length ≤ 2000 m
  ± 0.50% if cord length > 2000 m and ≤ 8000 m
  ± 0.25% if cord length > 8000 m
  ± 0.75% for HE cord types.

1.1.3 Coating definition

The conversion from mass of coating expressed in g/kg to thickness of coating expressed in micrometers is done according to the following formula
Thickenss = Mass x d x 0.235

<table>
<thead>
<tr>
<th>diameter filament</th>
<th>thickness (μm)</th>
<th>composition (% Cu)</th>
</tr>
</thead>
<tbody>
<tr>
<td>d &lt; 0.27 mm</td>
<td>0.20 +/− 0.04</td>
<td>63.5 +/− 2.5</td>
</tr>
<tr>
<td>0.27 ≤ d ≤ 0.32</td>
<td>0.24 +/− 0.04</td>
<td>63.5 +/− 2.5</td>
</tr>
<tr>
<td>d &gt; 0.32</td>
<td>0.30 +/− 0.04</td>
<td>63.5 +/− 2.6</td>
</tr>
</tbody>
</table>

Standard is the LOW COPPER type.