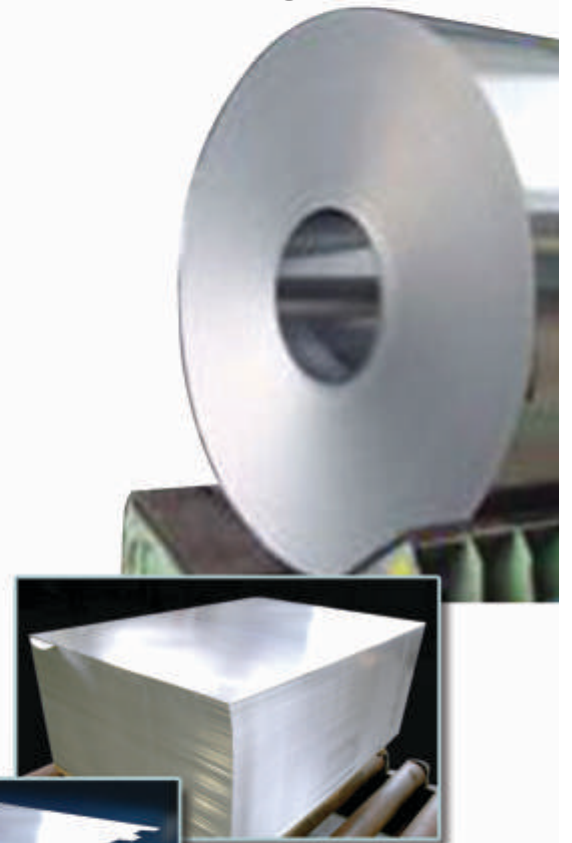


Poised to meet the growing demand and challenges...



**THE TINPLATE COMPANY OF INDIA LIMITED**  
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A **TATA** Enterprise



# Enhancing Facilities to Match Customer Needs



**The Tinplate Company of India Limited (TCIL)**, an associate company of TATA STEEL, pioneered Tinplate production in India in 1920. Today, TCIL is the industry leader in India, providing metal packaging solutions for a wide variety of food and non-food products through the manufacturing and marketing of Tinplate (ETP) and Tin Free Steel (TFS), under the brand name of **Tata Tinplate**. It derives more than 25% of business from global markets like West Asia, South East Asia, Europe, Africa and neighbouring ASEAN countries.

TCIL has enhanced its facilities over the last couple of years and currently has an installed capacity of 380,000 MT of ETP / TFS. The commissioning of the second Tinning line in 2008 coupled with all units of a new CRM Complex going on stream in 2011, TCIL has more than doubled its capacity over the last 3 years. With its downstream Solution Centre producing lacquered & printed sheets, TCIL is now poised to offer customers an entire range of value added products.

Tata Tinplate continues to be a preferred packaging medium, both for food products like fresh and processed edibles, beverages and for non-food packaging such as paints, aerosols, battery jackets, chemicals, closures, etc. This green packaging medium is 100% bio-degradable and eco-friendly; perfectly suited to an age in which commercial success depends on sound environmental credentials.



## OPEN TOP SANITARY CAN (OTSC) TINPLATE

OTSC Tinplate from Tata Tinplate is differentially coated ETP, available in both Single/Double Reduced forms and ideally suited for packaging processed food like mango pulp, baked beans, pineapple rings, fruits and juices, mushroom, fish, meat, etc.

### Tin Coating

OTSC Tinplates from Tata Tinplate are available in the following grades:  
D 11.2 / 5.6  
D 8.4 / 5.6

### Special Properties

ISV = 20 micrograms max.  
Tin Grain Size = ASTM 9 or less numerically.

**Note: Above properties are guaranteed on the heavier coated side. Coating weight tolerances are as per IS 1993 / ISO 11949**



## SINGLE REDUCED (SR) TINPLATE

Tata Tinplate SR variety is tailor-made within the following ranges:

Thickness	- 0.19 mm to 0.40 mm
Width	- 700 mm to 1020 mm
Cut Lengths	- 500 mm to 1115 mm

**Note: Tolerances as per IS 1993 (ISO 11949)**

Available in batch annealed condition in 4 categories of temper classification as per IS 1993 (ISO 11949)



Temper Classification	Rockwell Hardness (HR 30T)
T 52	52 +4 -4
T 55	55 +4 -3
T 57	57 +4 -3
T 61	61 +4 -4

## DOUBLE REDUCED (DR) TINPLATE

Double Reduced (DR) Tinplate is normally

- **Thinner**
- **Stronger**
- **Brighter**, as compared to conventional Single Reduced Tinplate
- **Gives more cans** per ton of tinplate.

DR Tinplates from Tata Tinplate are available as per following specifications:

Thickness in mm	Classification	Proof Stress (0.2% non proportional elongation) longitudinal in N/sq.mm.	Rockwell Hardness (HR 30T)
0.15 to 0.21	DR 480 (DR 48)	480+70 -70	65+3 -3
	DR 550 (DR 08)	550+70 -70	73+3 -3

**Both Tinplate and TFS from Tata Tinplate are available in the following finishes**

Stone	= 0.45 +/- 0.1 Micron CLA
Silver / Matt	= 1.0 +/- 0.2 Micron CLA

## TIN FREE STEEL (TFS)

Tin Free Steel is an electrolytic chromium & chromium oxide coated steel, consisting of a thin layer of metallic chromium and a layer of chromium oxide deposited on the steel base which gives it a beautiful, lustrous metallic finish on both sides. TFS offers outstanding corrosion resistance, lacquer adhesion as well as printability. No wonder it is an economical and high quality replacement for tinplate, especially for the screw and crown cap market. Tata Tinplate TFS is available in the same range of dimensions/temper/mechanical properties and oil film as that of ETP.

**Average chromium / chromium in oxide coating mass**

Form of Chromium	Average coating mass on each surface (mg/sq.mtr.)	
	Min.	Max.
Metallic Chromium	50	140
Chromium in oxides	7	35

Coating as per IS 12591 / ISO 11950



## TECHNICAL SPECIFICATION

### ETL 1

LINE DESIGNER	: WEAN UNITED, USA
TECHNOLOGY	: FERROSTAN PSA
LINE CAPACITY	: Upgraded to 180,000 MT per annum
TYPE OF LINE	: Cut Sheets
LINE SPEED	: 300 MPM (upgraded)
PRODUCTS	: ETP

### ETL 2

LINE DESIGNER	: NIPPON STEEL ENGG. CORPN
TECHNOLOGY	: FERROSTAN PSA
LINE CAPACITY	: 200,000 ton per annum
TYPE OF LINE	: Coil to Coil, Cut Sheets & Scroll Sheets
LINE SPEED	: 350 MPM (max.)
PRODUCTS	: ETP & TFS



## PROCESS TYPE

### ETL 1

TINPLATING (ETP) : Soluble anode system

### ETL 2

A. TINPLATING (ETP) : Soluble anode system  
B. CHROME PLATING (TFS) : Two step process

## PRODUCT SPECIFICATIONS

STRIP THICKNESS	: 0.14 to 0.40 mm
STRIP WIDTH	: 700 ~ 1020 mm
COIL INSIDE DIAMETER	: 508 mm (+/- 2 mm)
COIL OUTSIDE DIAMETER	: 1900 mm (max.)
COIL WEIGHT	: 15 Ton (max.)
SHEAR CUT	
LENGTH RANGE	: 500 ~ 1115mm
PACKET WEIGHT	: 1500 Kg (approx.)

