

CONTENTS

	Page
	Chapter I
The Development of the Tinsplate Manufacturing Industry	1
Historical note on tinned iron. The earliest tinsplates. History of tinsplate in Britain, in France	
In the United State of America	1
The Development of manufacturing technique; the introduction of steel base, modern method	9
The uses of tinsplate, the rise of the canning industry. Examination of historic tinsplates	18
Chronology	23
	Chapter 2
The Manufacturing Sequence	28
Operations. Plant design.	28
Steel manufacture. Open hearth process. Bessemer process. Top-blown oxygen processes	
Choice of process	32
Ingots; steel types; killed steel, effervescent steels. Steel composition.	36
Tin, mining, smelting , brands. The properties of tin.	39
	Chapter 3
Hot Rolling	49
The Four-high mill. Rolling of ingots. Slab heating. The continuous hot strip mill. Semi-	
Continuous roughing mill. Steckel hot mill.	49
Hot mill equipment, manipulation, rolls, instrumentation and control.	60
Characteristics of the hot-rolled band.	63
	Chapter 4
Hot-strip Pickling	66
Iron oxide scales. Fundamentals of pickling. Pickling inhibitors.	66
Pickling practice. Horizontal continuous strip pickler. Treatment of waste pickle liquor.	
Vertical continuous strip pickler.	73
Pickling defects.	84
	Chapter 5
Cold Reduction	88
Effect of rolling and annealing on structure. The constituents of steel, the iron-carbon	
Diagram. Cold rolling and plastic deformation. Annealing, recovery, recrystallisation	
Grain growth.	88
Temper rolling; the load-extension diagram. Temper grades	94
The rolling operation. Mill designs. The mill stand. Rolls. Tension. Sendzimir mill. Double	
Reduction mills	102
Lubrication and cooling. Automatic gauge control.	118
Temper rolling; mill design, work rolls	124
Instrumentation; thickness gauges, load meters, extension and width gauges, hardness	
Gauges	127
Coil preparation and cut-up lines	129
	Chapter 6
Annealing	136
Cleaning lines	136
The batch annealing process. The continuous-strand annealing furnace: vertical furnaces,	
horizontal furnaces.	138
The metallurgy of annealing. The Garber annealing cycle. Open coil annealing. Annealing	
Atmospheres: composition and properties, production of annealing atmosphere gases	154

Annealing defects	160
	Chapter 7
Hot-dip Tinning	163
The tinhouse. The tinning process. Feeding. Pickling.	163
The tinning unit; double-sweep units, single-sweep units. Tinpot and grease-pot rollers, Grease-pot brushes. Tinning machine drives. Heating the tinning unit. Catcher section	174
The cleaning operation; soda bath, branning machines, cleaning defects.	187
Inspection and assorting, quality grades	190
Tinning heavily-coated tinplate. Charcoal tinplates. Re-dipping unit. Player tinning unit. Unit for large sizes. Hot tinning of continuous strip	192
The reaction iron-tin: the constitutional diagram, the liquidus, the properties of FeSn ₂	196
The fluxing action. Iron-tin compound. Recovery of tin from scruff.	199
Action of the grease-pot machine; speed, temperature, surface finish	203
Palm oil; origin, composition and properties, ageing of tinning oils, palm oil recirculation.	206
	Chapter 8
Electrolytic Tinning	213
Development of plating electrolytes	214
Acid sulphate lines. Entry section, preparation section, cleaning section, pickling section	
Plating section, post-plating treatment section, marking, passivation, oiling, exit section	215
The Halogen line, plating section, flow-melting	239
Alkaline stannate lines. Fluoborate process. Other processes	245
Choice of electroplating process	252
Process and quality control. Process control tests. Hull cell. Circulating electrolyte cell. Quality control tests. Scanners	254
	Chapter 9
The Structure of the Tin Coating	264
Basic conversion factors	264
The compound layer in hot-dipped tinplate; mottle greyness. The compound layer in electrolytic tinplate; optical and electron photomicrographs	265
The free tin coating. Grain size. Wood grain. Coating Thickness variation Tin ridges and Grease marks. Porosity. Reflectivity and surface aspect.	281
The oxidation film. The oil film.	296
Methods of examination. Metallography of tin coatings. Optical microscopy. Electron Microscopy . Interferometry. Magnetic method	300
	Chapter 10
The Corrosion of Tinplate	307
The tin-iron couple. Absorption and diffusion of hydrogen. The tin-iron compound. Composition of steel. Dissolved tin ions. Corrosivity of foodstuffs, classification	308
The tin coating: coating weight, coating continuity. Sulphur blackening. Lacquers. Protective oxide films. Corrosion in the atmosphere. Corrosion in washing and cooling water. Corrosion by organic liquids	314
Corrosion testing; heat discoloration test, sulphur dioxide test, thiocyanate test, iron solution test, sulphide stain test, pickle lag test, alloy-tin couple test	329
	Chapter 11
Testing	341
Introduction. Sampling	341
Mechanical property tests: temper classification, indentation hardness, alternating bend tests, other bend tests, ductility tests, cupping tests, Erichsen test, Olsen test, tensile tests. Sheet dimensions. Microexamination.	344
Chemical property tests. Tin coating weight; volumetric methods, referee method, Bendix method, weight-loss method, Kunze and Willey method, Francis test, physical methods. Assessment of oxide and passivation films. Oil-film weight; gravimetric method, hydrophil balance, metal box method, ellipsometric method, chromatographic and fluorescence methods.	360
Physical tests. Soldering tests: joint strength, solderability, spreading tests, rate of wetting test. Lacquerability tests. Surface finish. Tin crystal size.	375

	Chapter 12
The Commerce of Tinplate	382
Area units.	383
The steel base; Mechanical properties, grain direction, thickness, length and width, rectilinearity. Coils	383
The tin coating: thickness, differential tinplate, tin yield, coke plates, charcoal plates, tin coating tolerances, type and finish of coating, marking of differential plate, surface finish, passivation treatments.	390
The price of tinplate. Qualities. Packing	397
	Appendix
Production Statistics	401
World production of tinplate. Production of electrolytic and hot-dipped tinplate.	401
Name Index	404
Subject Index	410