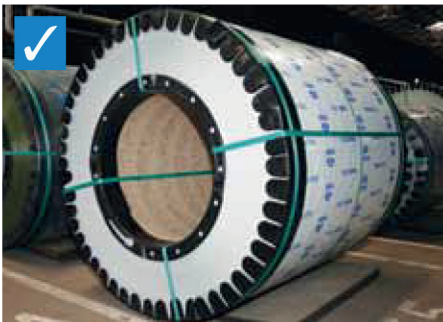


Colorcoat® Coil Storage Practices

The following coil storage recommendations have been developed, to ensure that Colorcoat® pre-finished steel coils are handled and stored in a safe manner to minimise the risk of handling and storage damage, and to maximise the yield and quality of each coil.

1. Coils should only be handled by competent and authorised personnel, following standard procedures and appropriate well maintained lifting equipment. Ideally all metal contact surfaces should be "soft coated" to avoid damage.
2. All material should be inspected for handling/transport damage on receipt.
3. Coils should be stored in a weather tight warehouse.
4. All material should be clearly identified and located.
5. Coils should be stored on dedicated coil stillages or on rubber matting, to minimise risk of damage to the outer laps.
6. Paint systems differ in their resistance to pressure. Plastisols, because of their coating density, thickness and thermoplastic nature are more susceptible to pressure marking. The majority of pressure marking is recoverable and is assisted by time and temperature. Severe application of pressure may result in permanent damage to the coating which may be transferred through several laps. This can be avoided by single stacking of coils, on rubber matting with coil weights restricted to a maximum of eight tonne.
7. Stillages and rubber mats must be regularly inspected to ensure they are free of debris and in good condition.
8. Coil stillages should be arranged in such a manner to ensure there is adequate clearance between coil rows and that the coil does not catch/rest on the coils in the adjacent stillage positions.
9. Coils which are packed on wooden cradles can be stored straight on a clean level floor. Strictly no double stacking of coils on top of cradle packed coils.
10. The coil outer laps must be adequately secured during all handling and storage operations. Beware of springback from metal strapping upon release.
11. Coils should not be double stacked as this significantly increases the amount of coil handling and associated handling damage risks and may cause



Rubber Matting.



Using original protecting packages.



Double-stacking.



Where these recommendations cannot be followed, the following points must be considered:

1. Where double stacking of coils is undertaken. A full assessment of the activity must be undertaken to identify and minimise the associated safety and quality risks. Rubber matting should be used to separate coils at contact points. Platisols should never be double-stacked.
2. Coils must never be stacked more than two high.
3. Where coils are stacked directly on a floor, this must be smooth and free from any debris or protruding parts. Adequate restraint to prevent coil movement must be provided.
4. Colorcoat® PE 15 is an internal product and must not be stored outdoors.
5. Only external application products should be considered for outdoor storage and only for short periods.
6. Changes in storage environment conditions should be minimised to reduce the risk of condensation. For example, when a cold coil is brought from outside into a warmer environment with a higher atmospheric humidity, or when there are rapid changes in ambient weather conditions, particularly in unheated storage bays.

A temporary cover should be arranged over the coils to prevent rain/water penetration but maintain good air circulation to minimise condensation risks. Capillary action will draw any moisture from condensation on the coil into the gaps between the coil laps. The corrosive reactions of water trapped between adjacent coil laps are far more aggressive than those encountered on normal exposed surfaces and could lead to premature failure of the coating.



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