

ROLLING MILL SPECIFICATIONS

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PROCESS CAPABILITIES

Grades	Ultra low carbon, low carbon, high carbon, alloys, HSLA, stainless and titanium
Condition	HRP&O, CR, Galvanized
Width	24" – 60"
Weight	72,000 lbs. maximum
ID	24"
OD	36" – 74"
Shape	Positive roll bend to 10 I units
Surface	Ra 15 max to 90 max with 20Ra spread, As Ground, EDT, Matte

MILL DATA

Mill Size	16-1/2 & 56 x 66 4 High
Mill Speed	350 / 700 FPM
Separating Force	6,480,000 lbs. maximum
Stall Force	8,100,000 lbs. maximum
Tension	30,000 lbs. maximum
Post Size	31 x 35 (1085 sq. in.)
Work Roll Diameter	15.25" minimum, 17.50" maximum
Back Up Roll Diameter	52" minimum, 56" maximum
Strip Drying	High pressure air and vacuum roll
Strip Guiding	North American center guide and 8 roll guidebox
Roll Coolant	2 – 4% water soluble synthetic
Coating Oil	Paraffin base oil with rust preventative

GAGE CONTROL (feed forward, feed back, mass flow)

Finish Thickness	Tolerance/Steady State Rolling	Tolerance/Non Steady State Rolling
0.015 TO 0.050 inch	+/- 1% of exit target	+/- 2% of exit target
0.050 TO 0.100 inch	+/- 0.00050 inch	+/- 0.00100 inch
Greater than 0.100 inch to .250 inch	+/- 0.5% of exit target for two pass operation	+/- 1% of exit target
Length of coil within Tolerance	98% of the coil length while in AGC operation	
Conditions	No tension changes No speed changes AGC "On" AGC permissive met No operator intervention	Tension changes Speed changes AGC "On" AGC permissive met No operator intervention

Gauge control and classification will occur every 4 inches (101.6mm)

ELONGATION CONTROL (feed forward, feed back, mass flow)

Finish Thickness	Tolerance/Steady State Rolling	Tolerance/Non Steady State Rolling
Products range 0.015 to 0.250	+/- 0.1%	+/- 0.2%
Length of coil within Tolerance	98% of the coil length while in AEC operation	
Conditions	No tension changes No speed changes AEC "On" AEC permissive met No operator intervention	Tension changes Speed changes AEC "On" AEC permissive met No operator intervention

Elongation control and classification will occur every 6.5 inches (165 mm)

A Ferragon Company



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