



EHSS REFERENCE PERFORMANCE

M 1	STAND	ROLL DIMENSION	ROLLED PRODUCT	PASS TYPE	GRADE	TON / GROOVE	MM / DRESSING
	FINISHER	352 X 650	REBAR Ø10	DOG	CC EHSS	3000	3MM
	FINISHER	352 X 650	REBAR Ø10	SLIT	CC EHSS	2700	3MM
	FINISHER	352 X 650	REBAR Ø10	LEADER	CC EHSS	2700	3MM
	FINISHER	352 X 650	REBAR Ø10	NOTCH	CC EHSS	1000	3MM
M 2	STAND	ROLL DIMENSION	ROLLED PRODUCT	PASS TYPE	GRADE	TON / GROOVE	MM / DRESSING
	FINISHER 11	500 X 850	REBAR Ø10	OVAL	CC EHSS	2000	3MM
	FINISHER 11	400 X 800	REBAR Ø16	SLIT	CC EHSS	4500	3MM
M 3	STAND	ROLL DIMENSION	ROLLED PRODUCT	PASS TYPE	GRADE	TON / GROOVE	MM / DRESSING
	FINISHER 15	340 X 500	4 STRAND	DOG	CC EHSS	1800 - 1820	2MM
	FINISHER 15	340 X 500	4 STRAND	SLIT	CC EHSS	1800 - 1820	2MM
	FINISHER 15	340 X 500	FLAT PASS	LEADER	CC EHSS	2000 - 2100	2MM
	FINISHER 18	340 X 500	REBAR	NOTCH	CC EHSS	1200 - 1220	2MM
M 4	STAND	ROLL DIMENSION	ROLLED PRODUCT	PASS TYPE	GRADE	TON / GROOVE	MM / DRESSING
	FINISHER	330 X 500		DOG	COMPOSITE EHSS	2400	2MM
	FINISHER	330 X 500		SLIT	COMPOSITE EHSS	2400	2MM
	FINISHER	330 X 500		LEADER	COMPOSITE EHSS	2800	2MM
	FINISHER	330 X 500		NOTCH	COMPOSITE EHSS	1500	2MM

** THIS IS REFERENCE FIGURE RECORDED UNDER DIFFERENT ROLLING CONDITONS AND DOESN'T GUARANTEE SAME PERFORMANCE WILL BE ACHIEVED **



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PRE-REQUISITES IN ACHIEVING ABOVE PERFORMANCE: (WATER COOLING)

- WATER VOLUME SPLIT - TOP TO BOTTOM: 40:60 %
- PRESSURE SHOULD BE - 2 TO 5 BAR
- HEADERS SHOULD BE AS CLOSE AS POSSIBLE TO ROLL BITE ON THE DELIVERY SIDE
- NOZZLES SHOULD BE KEPT CLEAN
- COOLING IS MORE EFFICIENT WITH LARGER WATER DROPLET SIZE
- A FINELY ATOMISED WATER SPRAY PRODUCES LOWER EFFICIENCY SO A LAMINAR FLOW IS PREFERRED, USING LARGE WATER DROPLETS
- THE LONGER THE WATER DROPLETS ARE IN CONTACT WITH THE ROLL THE BETTER THE RATE OF HEAT TRANSFER
- NOZZLES SPRAYING AT THE NORMAL TO THE ROLL SURFACE SHOULD BE AVOIDED
- THE POINT OF IMPACT OF WATER ON THE ROLL SHOULD TEND TOWARDS THE 'TANGENTIAL'
- THE WATER SHOULD STRIKE THE ROLL WITH AN ANGLE OF BETWEEN 20'D AND 30'D

PRE-REQUISITES IN ACHIEVING ABOVE PERFORMANCE: (PASS CHANGES)

- WHEN ROLLING, IT IS VERY IMPORTANT TO CHECK THE PASSES FOR WEAR AND CHANGE ACCORDINGLY
- PASSES MUST BE CHANGED AT REGULAR INTERVALS
- DO NOT OVER ROLL THE PASS (CAUSES FIRECRACKS, ABNORMAL WEARING AND SPALLING)
- COOL THE PASS DOWN WITH AIR FIRST AND CHANGE TO THE NEXT AVAILABLE PASS