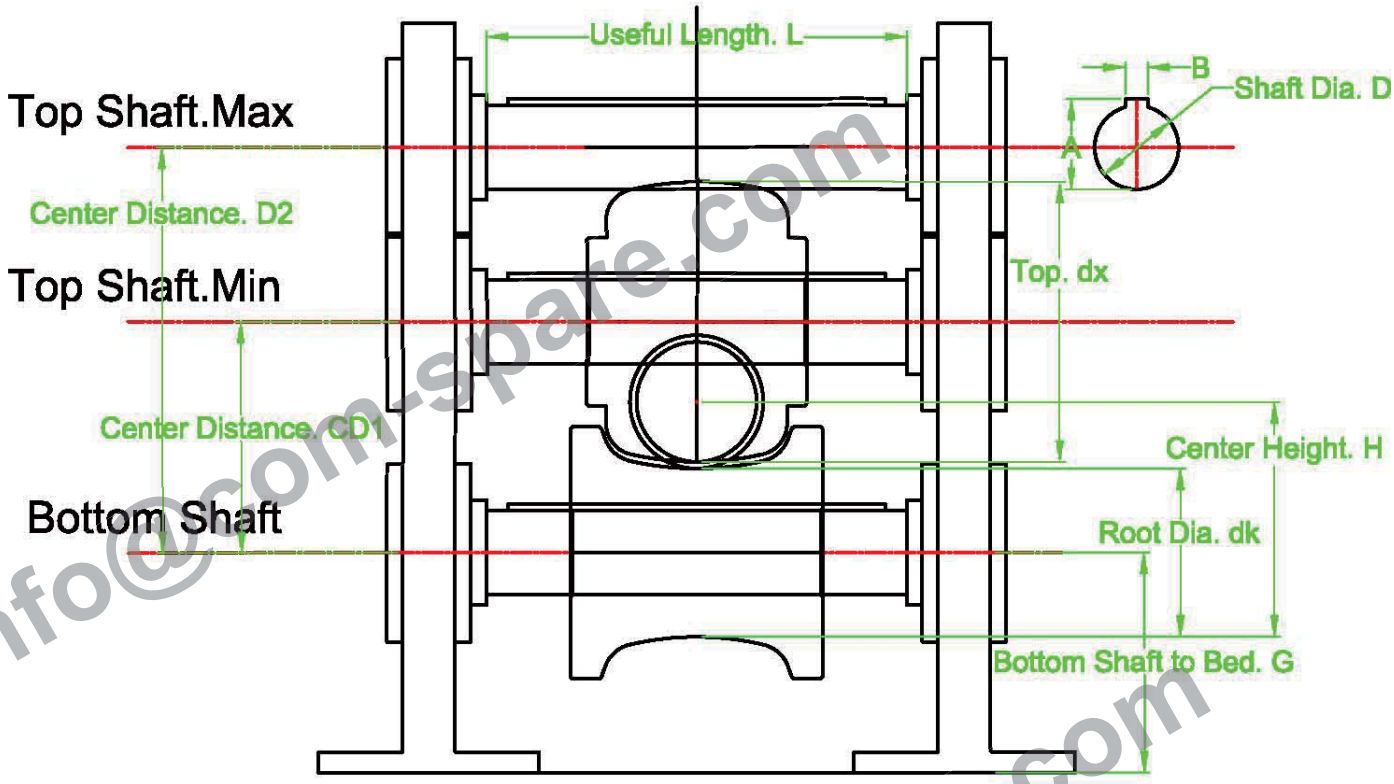
Part1:Horizontal Forming - Break Down



1, Horizontal Shaft Useful Legnth. L =_____

2, Bottom Shaft Center to Top Shaft Center distance movement range:

Position Min, CD1 = _____, Position Max, CD2 = _____

3, Shaft Diameter. D= _____, Keyway size: A=_____, B=_____

4, If know the pipe center height size, (not necessary) H=_____

5, The Top roller biggest OD, dx=_____, And, the shaft trans ratio, i=_____

6, The Root Diameter. dk, Increase of root diameter per stand:_____

Stand No. / Ratio	F1T/B, i1=____	F2T/B, i2=____	F3T/B, i3=____	F4T/B, i4=____
Check Roll Size.	dk1 =____	dk2 =____	dk3 =____	dk4 =____
Check Roll Size.	dx1 =____	dx2 =____	dx3 =____	dx4 =____
Note1, If F1T/B use the "W" design, then no need to check the F1T/B				
Note2, "dx, dk, i" for each stand, these 3 items, only need to know any 2 items, only				

7, The distance about the bottom shaft center to the mill bed line, G.=_____

If can be debugged, then, what is the debugging range? Range=_____

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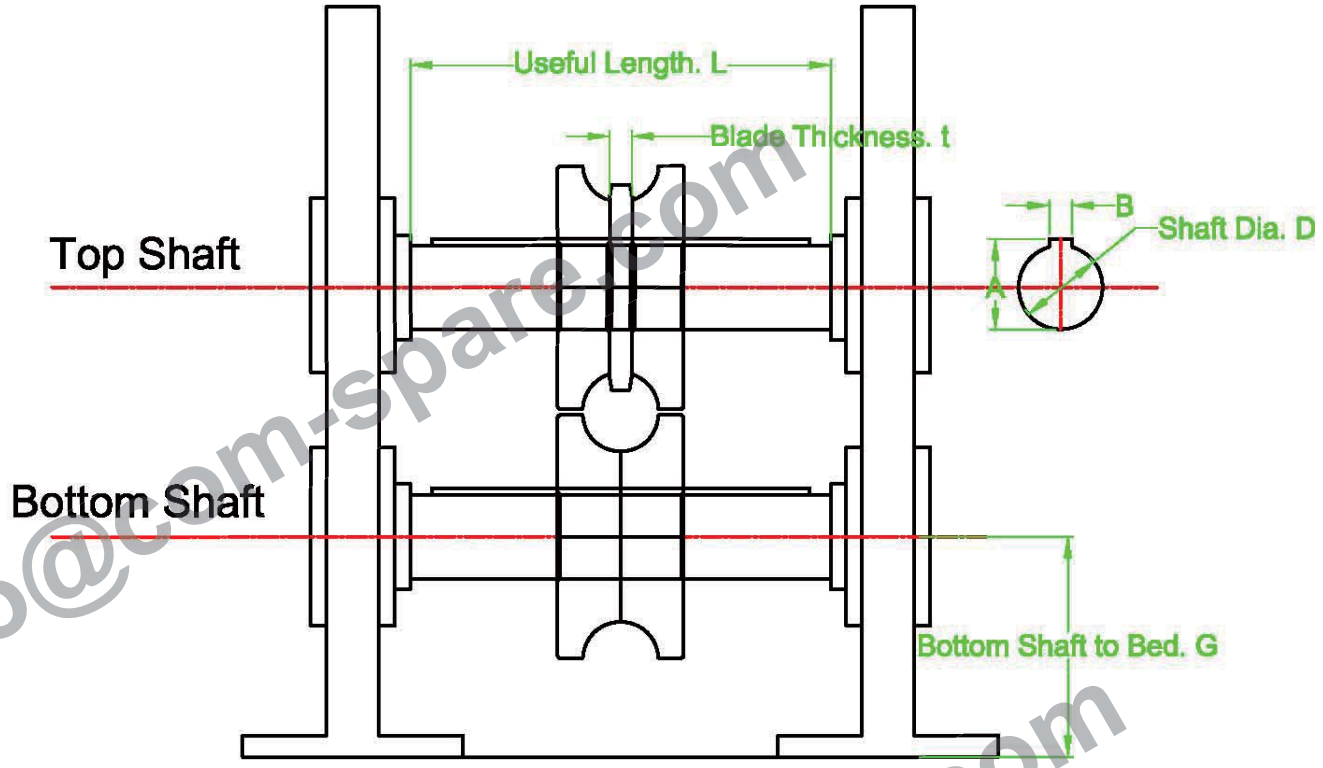
Part2:Horizontal Forming - Finpass



1, Horizontal Shaft Useful Legnth. L =_____

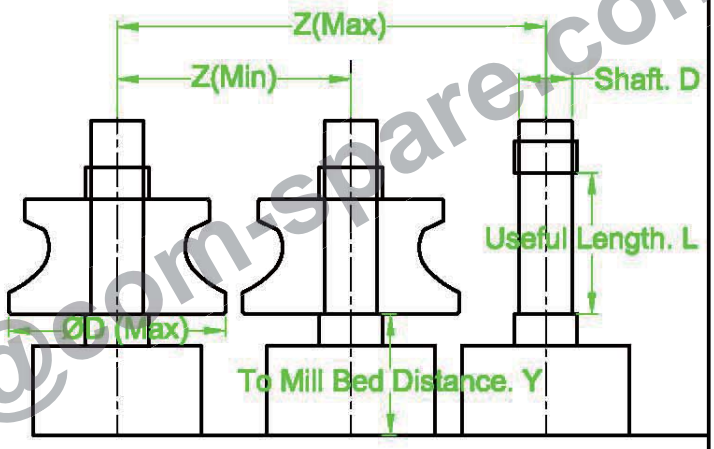
2, Shaft Diameter. D= _____, Keyway size: A=_____, B=_____

3, Fin pass blade named with, FP1T/B, FP2T/B, FP3T/B, etc...

Blade Thickness	FP1T2, t1=____	FP2T2, t2=____	FP3T2, t3=____	FP4T2, t4=____

4, The distance about the bottom shaft center to the mill bed line, G.=_____

Part3: Vertical Roll



1, Vertical Stand Center distance range. Z

a, Breakdown Rolls. Z(Min)=_____ Z(Max)=_____
b, Cluster Rolls. ----- Z(Min)=_____ Z(Max)=_____
c, Finpass Rolls. ---- Z(Min)=_____ Z(Max)=_____
d, Sizing Rolls. ------ Z(Min)=_____ Z(Max)=_____

2, Shaft Diameter. D= _____

3, Vertical Roll Shaft Useful Legnth. L

a, Breakdown Rolls. L=_____ b,Cluster Rolls. L=_____
c, Finpass Rolls. --- L=_____ d,Sizing Rolls. L=_____

4, Roller Under edge to Mill Bed Distance. Y

a, Breakdown Rolls. Y=_____ b,Cluster Rolls. Y=_____
c, Finpass Rolls. --- Y=_____ d,Sizing Rolls. Y=_____

5, NOTE. If any restricted, please specify ØD(Max)=_____

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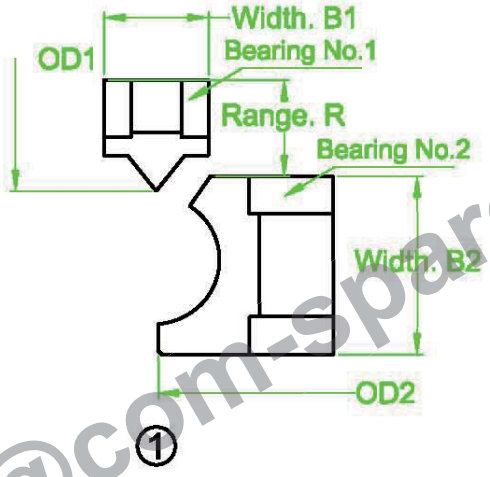
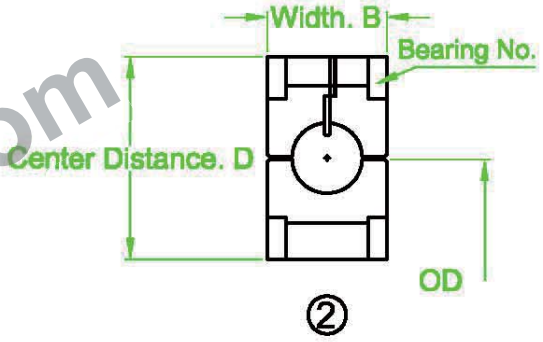
Part4:Seam Guide Roller

NOTE. Please,choose the Seam Guide type; If any specify,send the sketch drawing.



①

1,Width of the Top roller. B1=_____
2,BearingNo.1=_____
3,Roller Center distance. D1=_____
4,Roller out diameter. OD1(Max)=_____



②

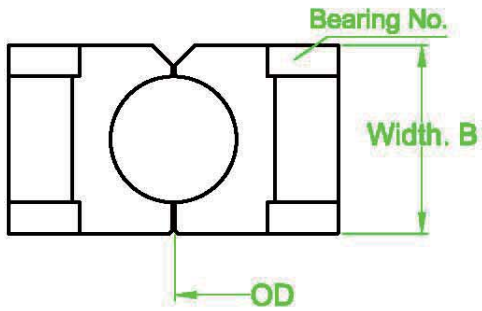
1,Width of the Top roller. B=_____
2,BearingNo.=_____
3,Roller Center distance. D=_____
4,Roller out diameter. OD(Max)=_____

5,Width of the Top roller. B2=_____ 6,BearingNo.2=_____
7,Roller Center distance. D2=_____ 8,Roller out diameter. OD2(Max)=_____
9,Top Roller center line to R/L roller upper edge distance range. R=_____

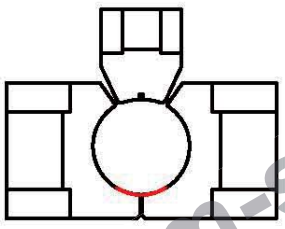
Part5:Squeezee Roller / Welding Roller

NOTE. Please,choose the SQ/Welding roll type; If any specify,send the sketch drawing.

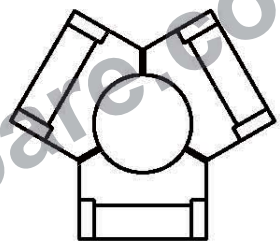
5.1 TWO ROLLER TYPE



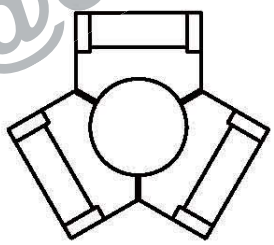
1,Width of the Top roller. B=_____
2,BearingNo.=_____
3,Roller out diameter. OD(Max)=_____



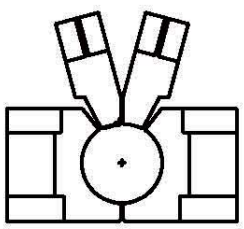
5.2 Three Roller type A



5.3 Three Roller type B



5.4 Three Roller type C



5.5 Four Roller type

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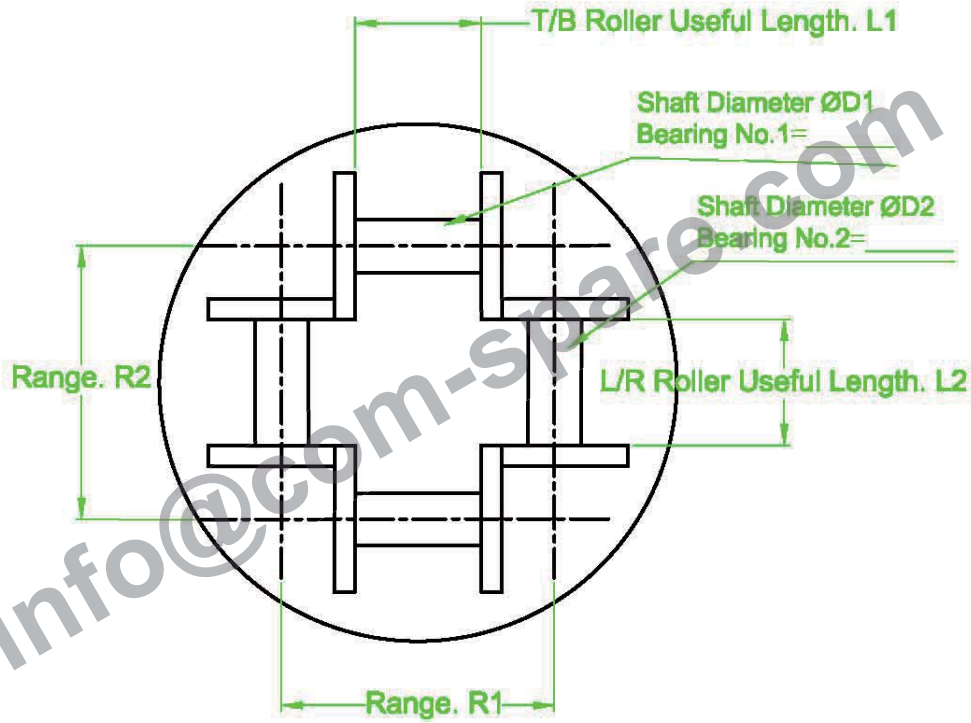
Part6:TH / Turkey Head Roller



Top/Bottom Roller
1, Useful Length. L1=____
2, ØD1=____
3, Bearing No.1=____
4, Movement Range,
R1=_____~_____

Left/Right Roller
1, Useful Length. L2=____
2, ØD2=____
3, Bearing No.2=____
4, Movement Range,
R2=_____~_____

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