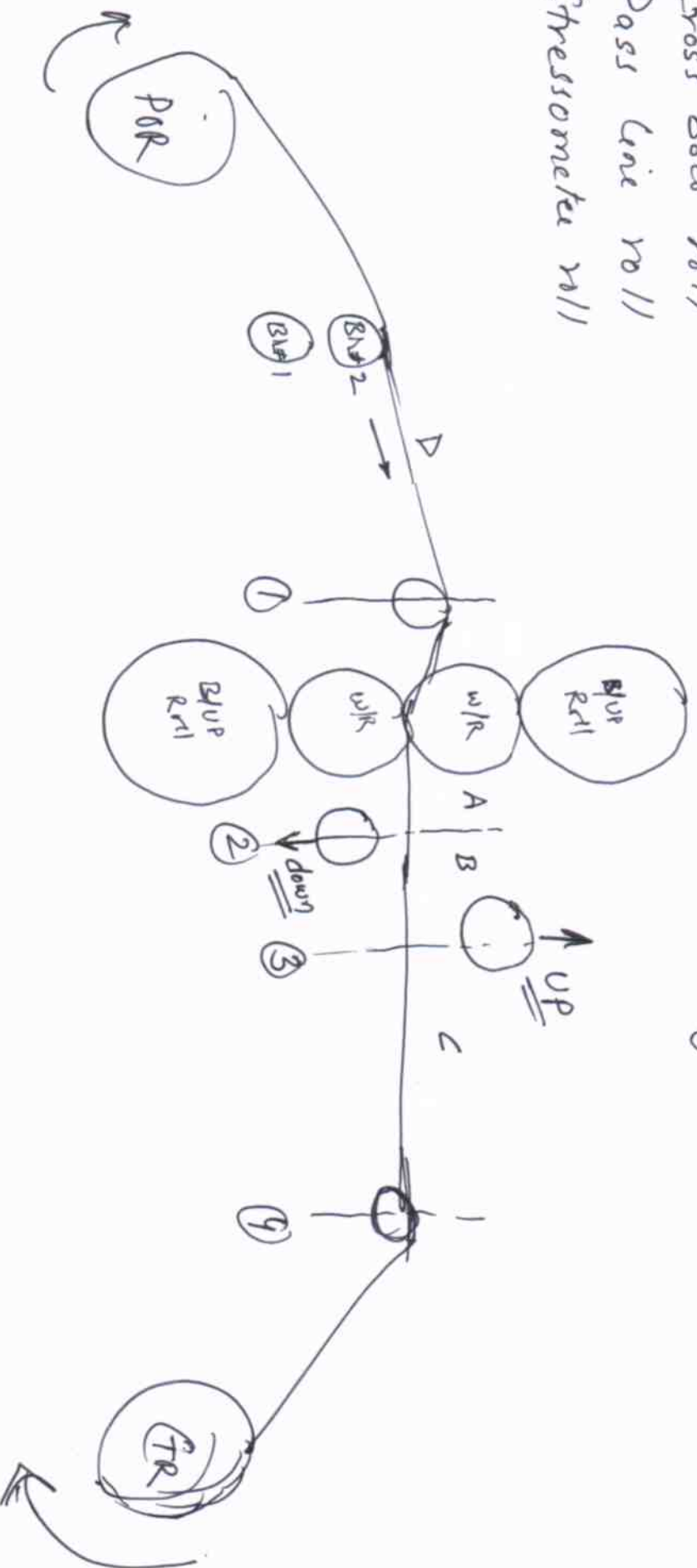


Trials with different arrangements

S.No.	Application	A (In between Mill bite and crossbow)	B (In between Cross bow and Pass line roll)	C (In between Pass line roll and Stressometer roll)	D (In between Bridle roll and crimping roll)
1	Case III: Pass line roll UP and Cross bow Down	NOT OK CHATTER MARKS	NOT OK CHATTER MARKS	NOT OK CHATTER MARKS	OK NO CHATTER MARKS

- ① Anticrimping roll
- ② Cross bow roll
- ③ Pass line roll
- ④ Stressometer roll

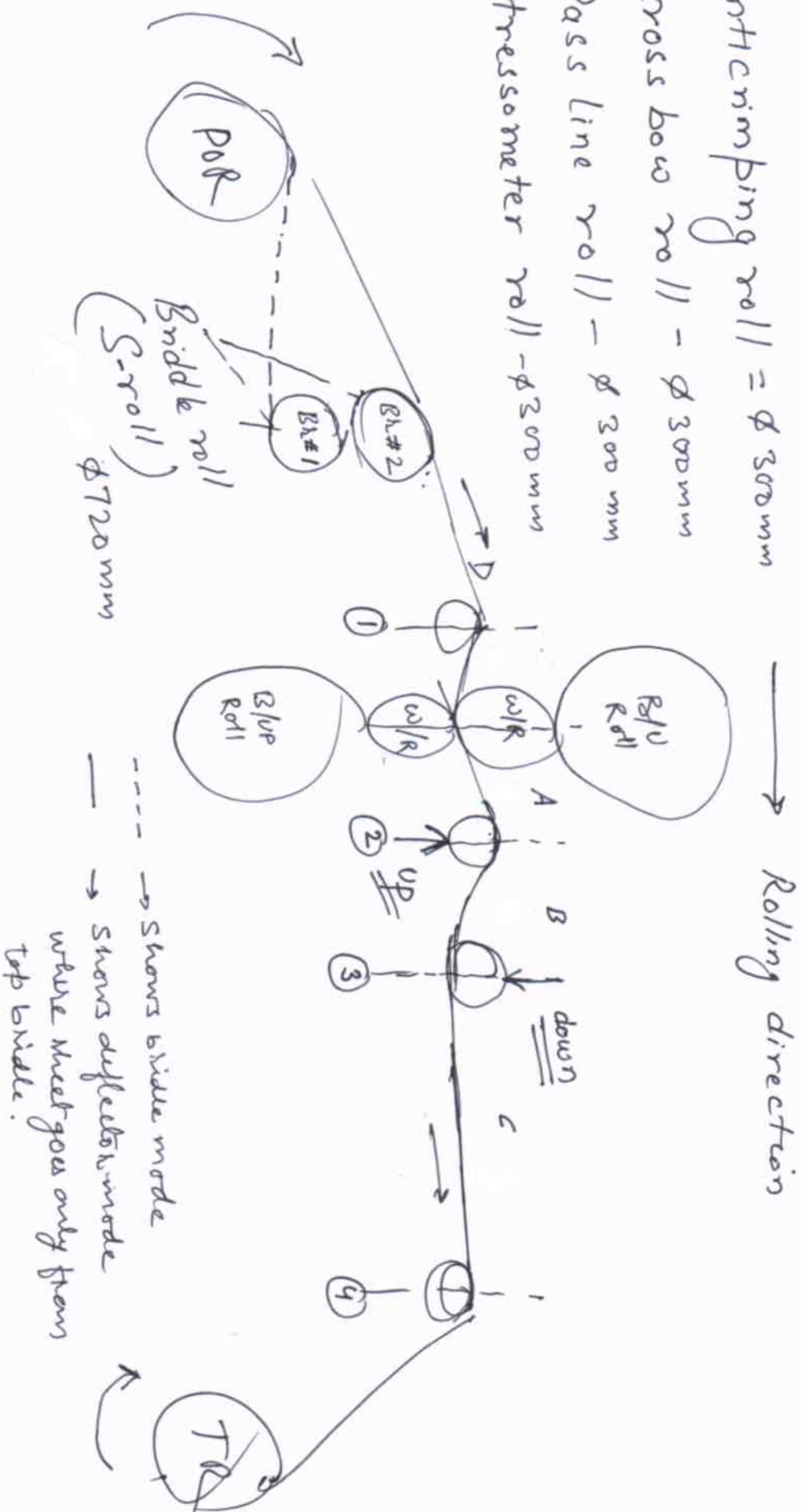
→ Rolling direction



Trials with different arrangements

S.No.	Application	A (In between Mill bite and crossbow)	B (In between Cross bow and Pass line roll)	C (In between Pass line roll and Stressometer roll)	D (In between Bridle roll and crimping roll)
1	Case 1 :Pass line roll Down and Cross bow UP	OK NO CHATTER MARKS	OK NO CHATTER MARKS	NOT OK CHATTER MARKS	OK NO CHATTER MARKS

- ① Anticrimping roll = $\phi 300 \text{ mm}$
- ② Cross bow roll - $\phi 300 \text{ mm}$
- ③ Pass line roll - $\phi 300 \text{ mm}$
- ④ Stressometer roll - $\phi 300 \text{ mm}$



Trials with different arrangements

S.No.	Application	A (In between Mill bite and crossbow)		B (In between Cross bow and Pass line roll)	C (In between Pass line roll and Stressometer roll)	D (In between Bridle roll and crimping roll)
1	Case II : Pass line roll UP and Cross bow UP	NO CHATTER ^{OK}		CHATTER MARKS ^{NOT OK}	CHATTER MARKS ^{NOT OK}	NO CHATTER MARKS ^{OK}

- ① Anticrimping roll
- ② Cross bow roll
- ③ Pass line roll
- ④ Stressometer roll

