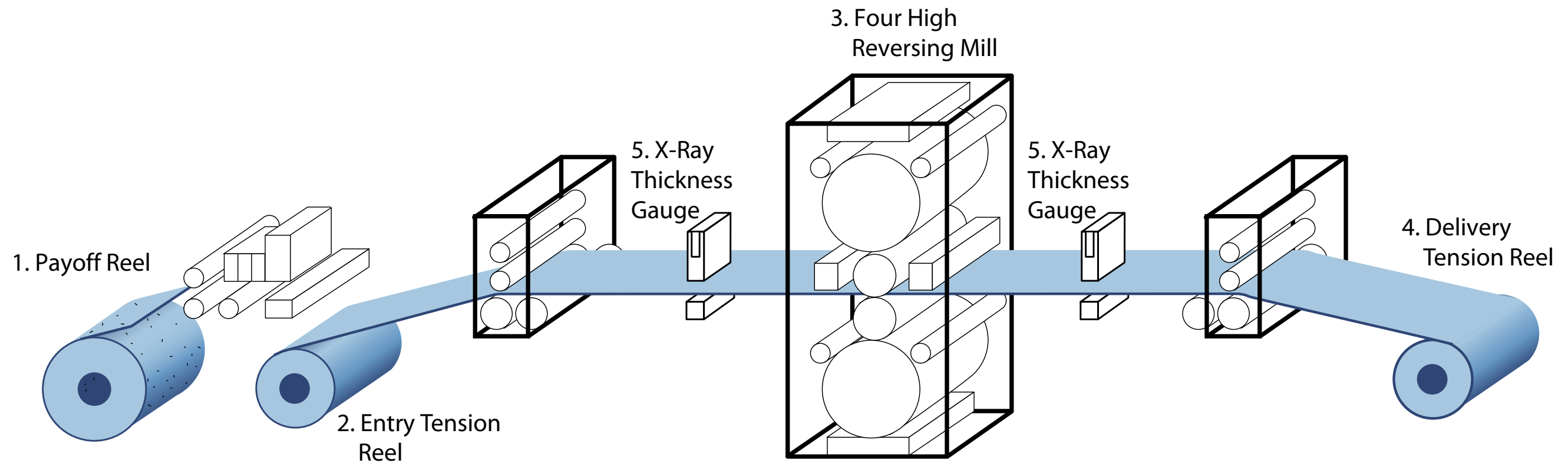


Reversing Cold Rolling Mill

Manufacturer of Cold Mill: Ishikawajima Heavy Industries



- 1) A coil fresh from the pickle line sits in waiting for the cold rolling process.
- 2) The coil being processed starts at the entry tension reel, where it is uncoiled and passed forward through the reversing mill.
- 3) A four-high set of rolls applies pressure to the steel in order to make it thinner, while maintaining its shape and width. The number of passes depends upon the customer's specification for coated-product thickness.
- 4) As it passes forward through the rolls, the steel is re-coiled onto the delivery tension reel. From there it goes back through the rolls in reverse, making it even thinner.
- 5) Thickness gauges measure the thickness of the steel with each pass through the rolls.
- 6) Once the proper thickness is achieved, the steel is again coiled onto one of the tension reels. From there it is ready to move to the coating line.