**C.R.M 3 ( Frohling Cold Rolling Mill )**

Material being rolled - C 75 grade Steel

Number of passes - 3

Initial Thickness - 1.5 mm

Final Thickness - 0.9 mm

Mill screw down - 450 metric tonne

|  |  |  |  |  |
| --- | --- | --- | --- | --- |
| Pass Number | 0 | 1 | 2 | 3 |
| Thickness | 1.5 mm | 1.3 mm | 1.1 mm | 0.9 mm |
| Tension in | 12000 N | 45000 N | 40000 N | 32000 N |
| Tension out | 45800 N | 40000 N | 35000 N | 30000 N |
| R.P.M | 140 | 280 | 280 | 280 |

**C.R.M 2 ( older mill )**

Mateial being rolled - C 75 Steel

Number of passes - 2

Initial Thickness - 2 mm

Final Thickness - 1.5 mm

Mill Screw Down - 225 metric tonne

|  |  |  |  |
| --- | --- | --- | --- |
| Pass Number | 0 | 1 | 2 |
| Thickness | 2 mm | 1.75 mm | 1.5 mm |
| Tension in | 10000 N | 30000 N | 30000 N |
| Tension out | 30000 N | 30000 N | 30000 N |
| R.P.M | 150 | 150 | 150 |