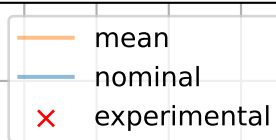


Workpiece Temperature in K

1500  
1400  
1300  
1200  
1100



R1 R2 R3 R4 R5 R6 R7 R8 R9 R10 F1 F2 F3 F4

Roll Pass

