

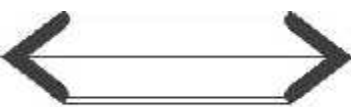









Ring Rolling Guideline

Critical Dimension	Description	Typical Uses
	Angle – Leg Out	Reinforcing flanges on the outside of cylinders
	Angle – Leg In	Reinforcing flanges on the inside of cylinders
	Angle – 'V' Roll	Reinforcing for Plough Blades
	Channel – Flanges Out	Stiffeners
	Channel – Flanges In	Stiffeners
	Channel – 'Hard' Way (or one Flange in and one out)	Stiffeners
	Beam – 'Easy' Way	Mono Rail Tracks
	Beam – 'Hard' Way	Tunnel Arches
	Flat – 'Easy' Way	Backing Plates
	Flat – 'Hard' Way	Large Flanges

NOTE: The length to be rolled should be equal to the arc length required plus sufficient overage to accommodate roll feeding practices.