



# Diameter deviation



## ROLL DATA

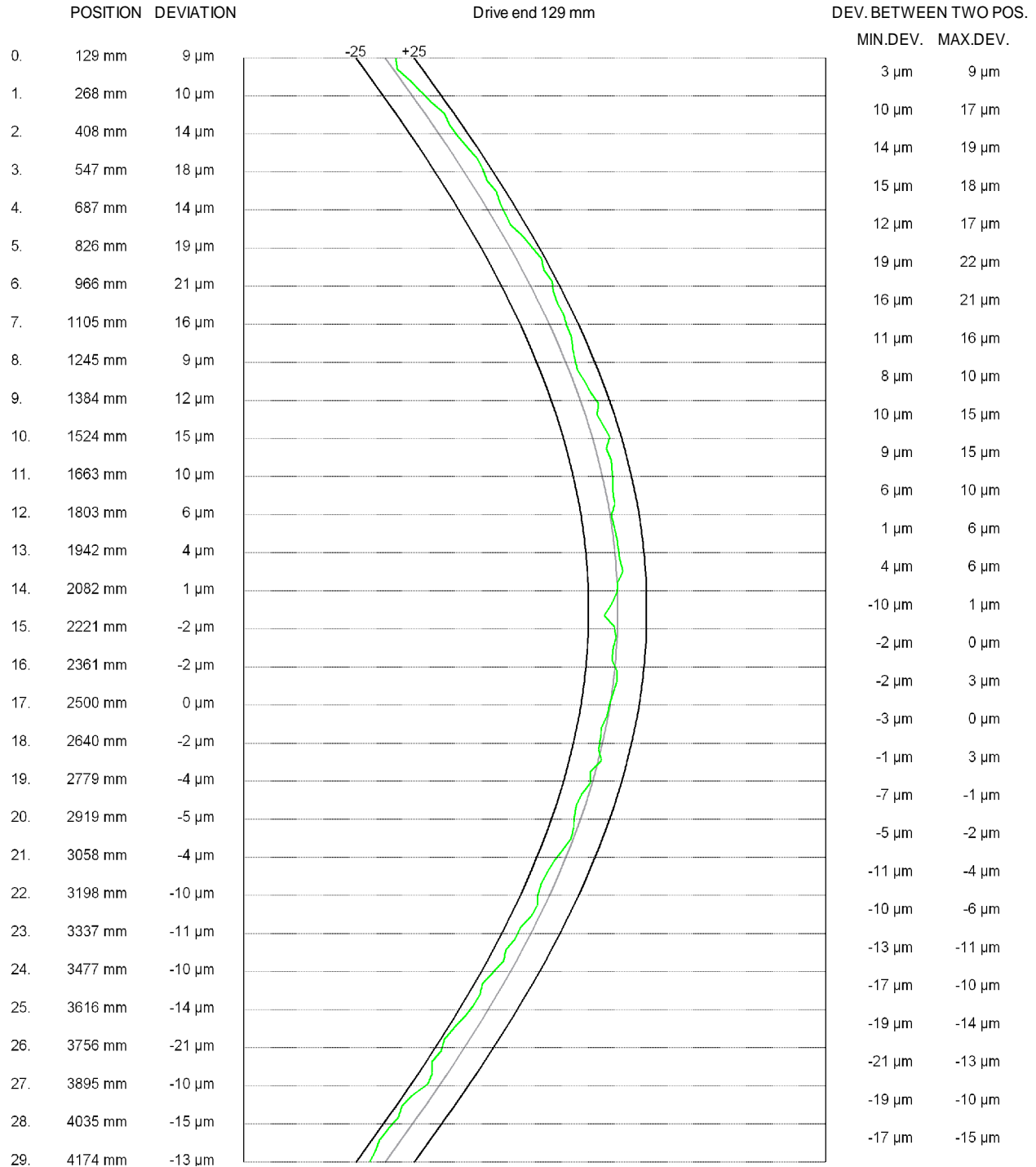
Shell/Roll No  
Additional ID  
Customer  
Drawing number  
Type  
Length  
Diameter  
Mass  
Crown 1/2  
Crown length 1/2  
Crown angle 1/2  
Crown length 3

HR005  
CHH Tasman  
PD2 Heavy Duty Press  
4303 mm  
1206.0 mm  
13000 kg  
0.80/0.00 mm  
4045.0/0.0 mm  
70/0 °  
0.0 mm

## MEASUREMENT DATA

Measurement unit  
Date of measurement  
Operator  
Measuring stage  
Rotation speed  
Measuring length  
Measured diameter  
Ra  
Tolerance area  
Scale  
Work number

2010-07-13 09:00:19  
ADONIS  
After grinding  
8.0 rpm  
4045 mm  
1208.1 mm  
0.9  
0.050 mm  
500 µm  
RP10042



TOTAL DEVIATION  
Max oversize  
Max undersize

43 µm  
21.5 µm 865 mm  
-21.5 µm 3725 mm

TOTAL CROWNING  
Taper

794 / 794 µm  
-26 µm



# Out of roundness



## ROLL DATA

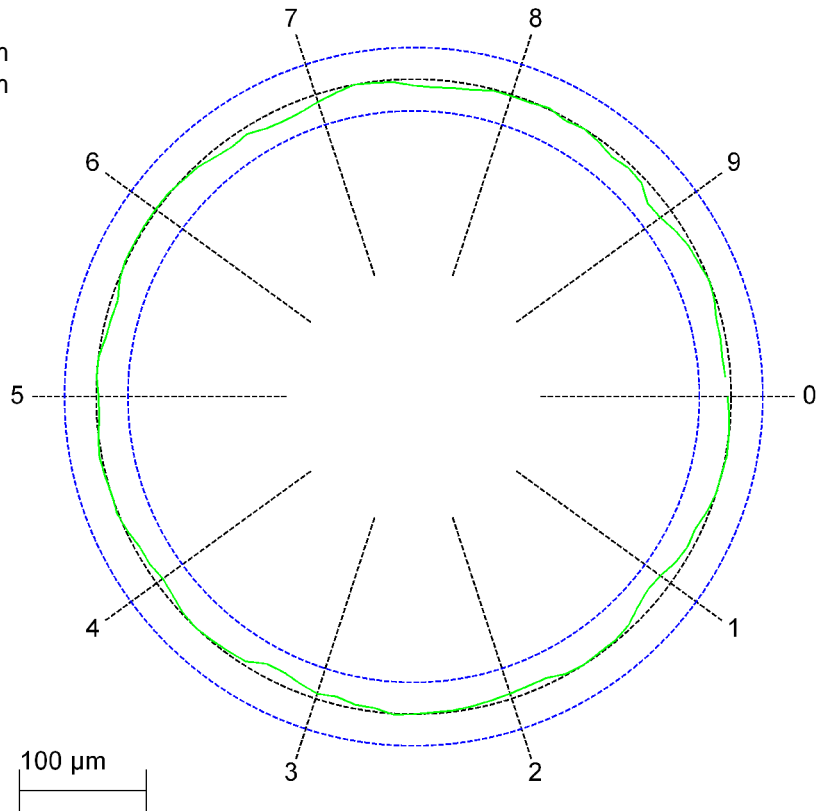
Shell/Roll No HR005  
 Additional ID  
 Customer CHH Tasman  
 Drawing number  
 Type PD2 Heavy Duty Press  
 Length 4303 mm  
 Diameter 1206.0 mm  
 Mass 13000 kg  
 Crown 1/2 0.80/0.00 mm  
 Crown length 1/2 4045.0/0.0 mm  
 Crown angle 1/2 70/0 °  
 Crown length 3 0.0 mm

## MEASUREMENT DATA

Measurement unit  
 Date of measurement 2010-07-13 09:01:22  
 Operator ADONIS  
 Measuring stage After grinding  
 Rotation speed 8.0 rpm  
 Measuring length 4045 mm  
 Measured diameter 1208.1 mm  
 Ra 0.9  
 Tolerance area 0.050 mm  
 Scale 100 µm  
 Work number RP10042

	POSITION	DEVIATION	
0.	0°	7 µm	7.5 µm
1.	36°	11 µm	11.5 µm
2.	72°	7 µm	7.5 µm
3.	108°	10 µm	10.5 µm
4.	144°	8 µm	8.5 µm
5.	180°	6 µm	6.5 µm
6.	216°	11 µm	11.5 µm
7.	252°	6 µm	6.5 µm
8.	288°	12 µm	12.5 µm
9.	324°	10 µm	10.5 µm

MEASUREMENT POSITION 129 mm (DE)



TOTAL DEVIATION 13 µm  
 Max oversize 2 µm 171°  
 Max undersize -11 µm 40°



# Out of roundness



## ROLL DATA

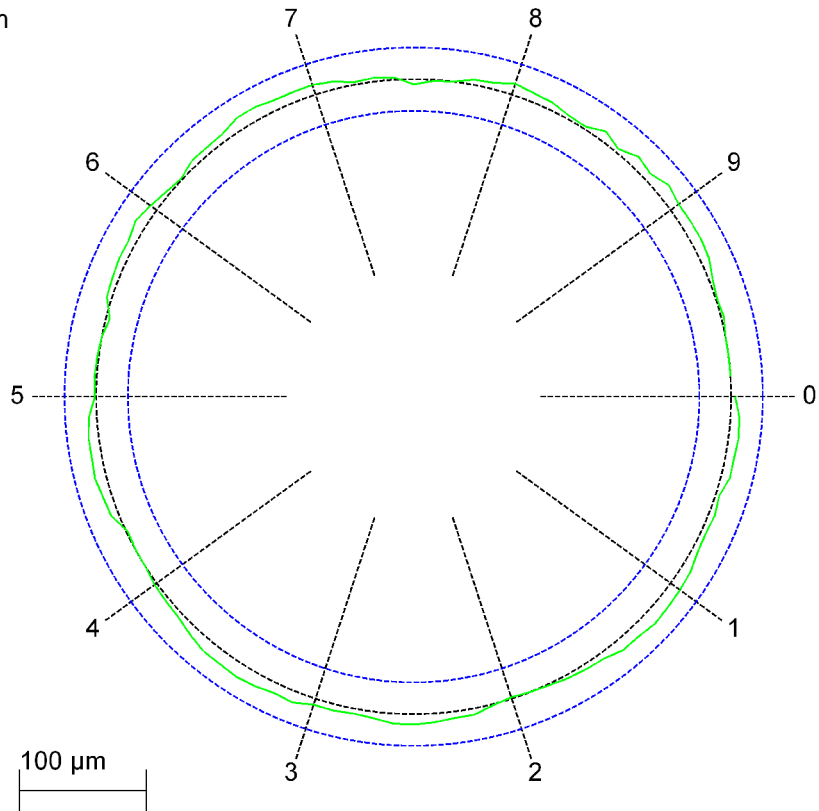
Shell/Roll No HR005  
 Additional ID  
 Customer CHH Tasman  
 Drawing number  
 Type PD2 Heavy Duty Press  
 Length 4303 mm  
 Diameter 1206.0 mm  
 Mass 13000 kg  
 Crown 1/2 0.80/0.00 mm  
 Crown length 1/2 4045.0/0.0 mm  
 Crown angle 1/2 70/0 °  
 Crown length 3 0.0 mm

## MEASUREMENT DATA

Measurement unit  
 Date of measurement 2010-07-13 09:02:08  
 Operator ADONIS  
 Measuring stage After grinding  
 Rotation speed 8.0 rpm  
 Measuring length 4045 mm  
 Measured diameter 1208.1 mm  
 Ra 0.9  
 Tolerance area 0.050 mm  
 Scale 100 µm  
 Work number RP10042

	POSITION	DEVIATION	
0.	0°	5 µm	5.5 µm
1.	36°	11 µm	11.5 µm
2.	72°	9 µm	9.5 µm
3.	108°	8 µm	8.5 µm
4.	144°	10 µm	10.5 µm
5.	180°	12 µm	12.5 µm
6.	216°	9 µm	9.5 µm
7.	252°	12 µm	12.5 µm
8.	288°	9 µm	9.5 µm
9.	324°	8 µm	8.5 µm

MEASUREMENT POSITION 2151.5 mm (Center)



TOTAL DEVIATION 15 µm  
 Max oversize 11 µm 44°  
 Max undersize -4 µm 273°



# Out of roundness



## ROLL DATA

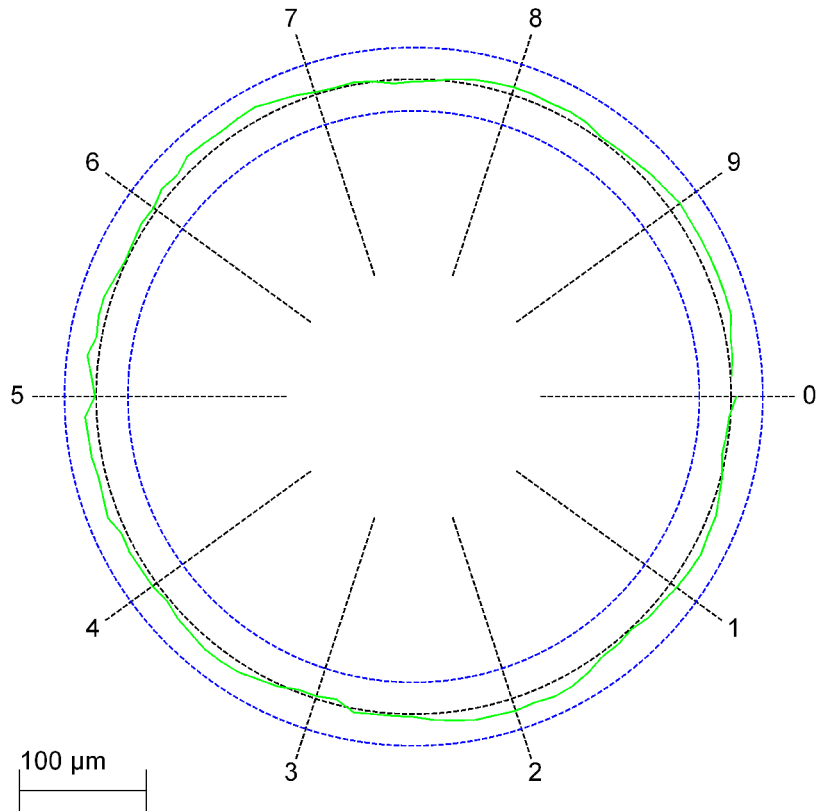
Shell/Roll No HR005  
 Additional ID  
 Customer CHH Tasman  
 Drawing number  
 Type PD2 Heavy Duty Press  
 Length 4303 mm  
 Diameter 1206.0 mm  
 Mass 13000 kg  
 Crown 1/2 0.80/0.00 mm  
 Crown length 1/2 4045.0/0.0 mm  
 Crown angle 1/2 70/0 °  
 Crown length 3 0.0 mm

## MEASUREMENT DATA

Measurement unit  
 Date of measurement 2010-07-13 09:03:15  
 Operator ADONIS  
 Measuring stage After grinding  
 Rotation speed 8.0 rpm  
 Measuring length 4045 mm  
 Measured diameter 1208.1 mm  
 Ra 0.9  
 Tolerance area 0.050 mm  
 Scale 100 µm  
 Work number RP10042

	POSITION	DEVIATION	
0.	0°	11 µm	11.5 µm
1.	36°	10 µm	10.5 µm
2.	72°	14 µm	14.5 µm
3.	108°	10 µm	10.5 µm
4.	144°	5 µm	5.5 µm
5.	180°	8 µm	8.5 µm
6.	216°	7 µm	7.5 µm
7.	252°	8 µm	8.5 µm
8.	288°	5 µm	5.5 µm
9.	324°	8 µm	8.5 µm

MEASUREMENT POSITION 4174 mm (TE)



TOTAL DEVIATION 15 µm  
 Max oversize 11 µm 66°  
 Max undersize -4 µm 106°



# Run out



## ROLL DATA

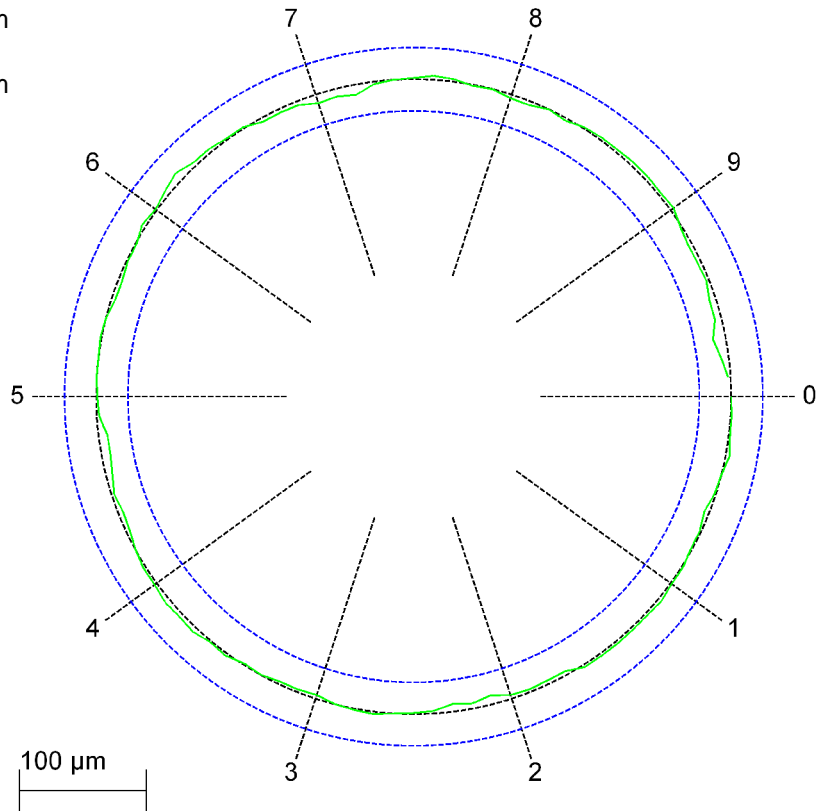
Shell/Roll No HR005  
 Additional ID  
 Customer CHH Tasman  
 Drawing number  
 Type PD2 Heavy Duty Press  
 Length 4303 mm  
 Diameter 1206.0 mm  
 Mass 13000 kg  
 Crown 1/2 0.80/0.00 mm  
 Crown length 1/2 4045.0/0.0 mm  
 Crown angle 1/2 70/0 °  
 Crown length 3 0.0 mm

## MEASUREMENT DATA

Measurement unit  
 Date of measurement 2010-07-13 09:04:00  
 Operator ADONIS  
 Measuring stage After grinding  
 Rotation speed 8.0 rpm  
 Measuring length 4045 mm  
 Measured diameter 1208.1 mm  
 Ra 0.9  
 Tolerance area 0.050 mm  
 Scale 100 µm  
 Work number RP10042

	POSITION	DEVIATION	
0.	0°	7 µm	7.5 µm
1.	36°	6 µm	6.5 µm
2.	72°	9 µm	9.5 µm
3.	108°	7 µm	7.5 µm
4.	144°	9 µm	9.5 µm
5.	180°	6 µm	6.5 µm
6.	216°	10 µm	10.5 µm
7.	252°	11 µm	11.5 µm
8.	288°	6 µm	6.5 µm
9.	324°	13 µm	13.5 µm

MEASUREMENT POSITION 4174 mm (TE)



TOTAL DEVIATION 17 µm  
 Max oversize 7 µm 226°  
 Max undersize -10 µm 353°



# Run out



## ROLL DATA

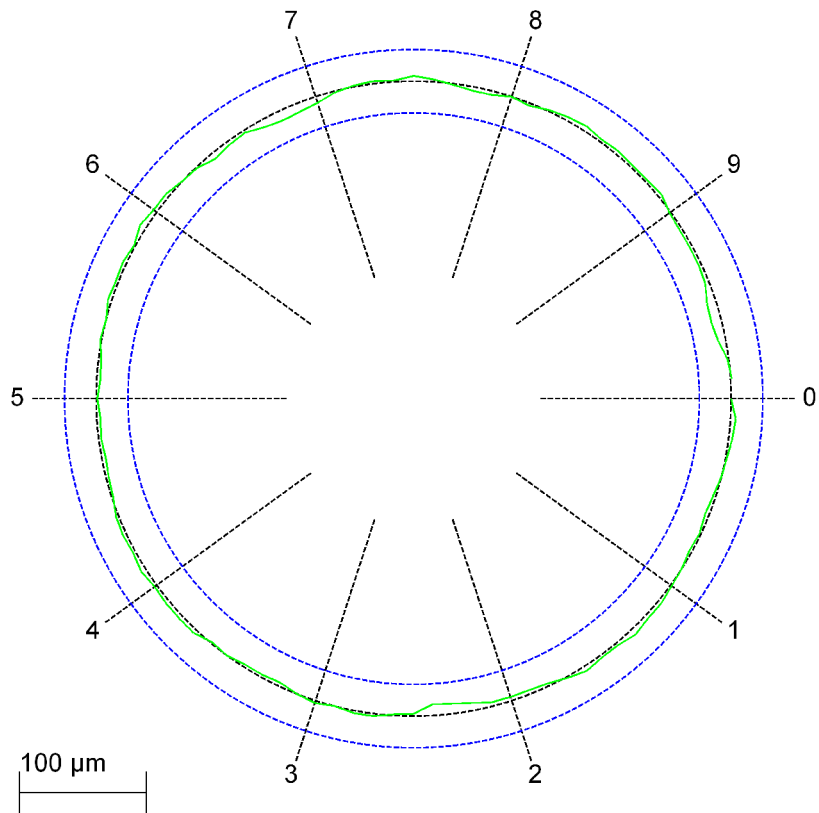
Shell/Roll No HR005  
 Additional ID  
 Customer CHH Tasman  
 Drawing number  
 Type PD2 Heavy Duty Press  
 Length 4303 mm  
 Diameter 1206.0 mm  
 Mass 13000 kg  
 Crown 1/2 0.80/0.00 mm  
 Crown length 1/2 4045.0/0.0 mm  
 Crown angle 1/2 70/0 °  
 Crown length 3 0.0 mm

## MEASUREMENT DATA

Measurement unit  
 Date of measurement 2010-07-13 09:04:41  
 Operator ADONIS  
 Measuring stage After grinding  
 Rotation speed 8.0 rpm  
 Measuring length 4045 mm  
 Measured diameter 1208.1 mm  
 Ra 0.9  
 Tolerance area 0.050 mm  
 Scale 100 µm  
 Work number RP10042

	POSITION	DEVIATION	
0.	0°	7 µm	7.5 µm
1.	36°	8 µm	8.5 µm
2.	72°	11 µm	11.5 µm
3.	108°	6 µm	6.5 µm
4.	144°	7 µm	7.5 µm
5.	180°	8 µm	8.5 µm
6.	216°	11 µm	11.5 µm
7.	252°	9 µm	9.5 µm
8.	288°	6 µm	6.5 µm
9.	324°	9 µm	9.5 µm

MEASUREMENT POSITION 2151.5 mm (Center)



TOTAL DEVIATION 14 µm  
 Max oversize 5 µm 47°  
 Max undersize -9 µm 87°



# Run out



## ROLL DATA

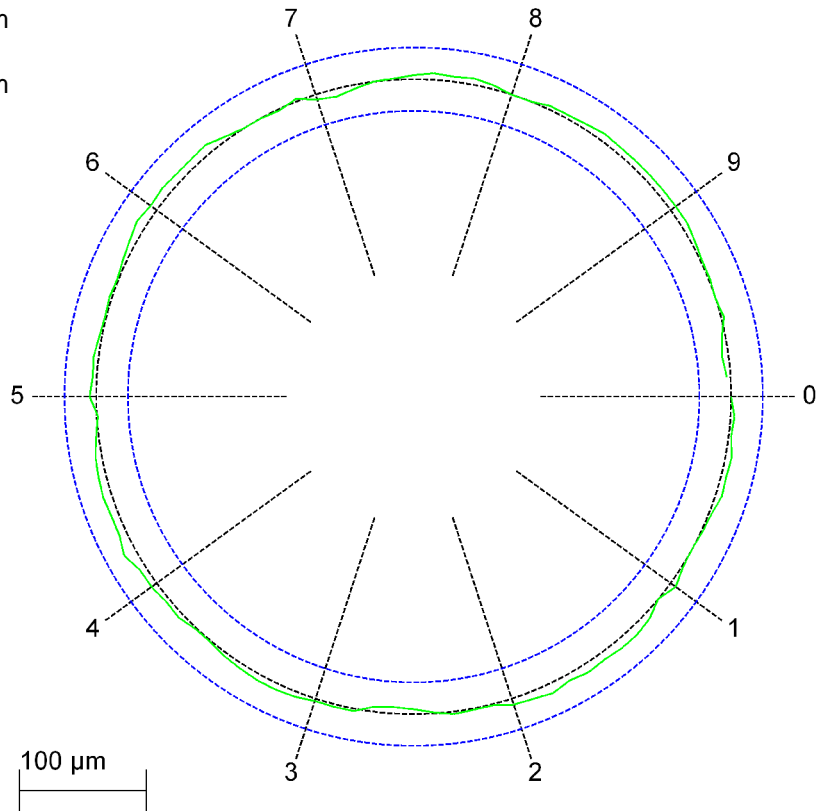
Shell/Roll No HR005  
 Additional ID  
 Customer CHH Tasman  
 Drawing number  
 Type PD2 Heavy Duty Press  
 Length 4303 mm  
 Diameter 1206.0 mm  
 Mass 13000 kg  
 Crown 1/2 0.80/0.00 mm  
 Crown length 1/2 4045.0/0.0 mm  
 Crown angle 1/2 70/0 °  
 Crown length 3 0.0 mm

## MEASUREMENT DATA

Measurement unit  
 Date of measurement 2010-07-13 09:05:16  
 Operator ADONIS  
 Measuring stage After grinding  
 Rotation speed 8.0 rpm  
 Measuring length 4045 mm  
 Measured diameter 1208.1 mm  
 Ra 0.9  
 Tolerance area 0.050 mm  
 Scale 100 µm  
 Work number RP10042

	POSITION	DEVIATION	
0.	0°	5 µm	5.5 µm
1.	36°	8 µm	8.5 µm
2.	72°	10 µm	10.5 µm
3.	108°	4 µm	4.5 µm
4.	144°	11 µm	11.5 µm
5.	180°	7 µm	7.5 µm
6.	216°	8 µm	8.5 µm
7.	252°	11 µm	11.5 µm
8.	288°	6 µm	6.5 µm
9.	324°	10 µm	10.5 µm

MEASUREMENT POSITION 129 mm (DE)



TOTAL DEVIATION 16 µm  
 Max oversize 10 µm 153°  
 Max undersize -6 µm 258°