



## ROLLING SEQUENCE FOR SMOOTH WIRE

	First Pass		Second Pass		
ROD WIRE	OVAL REDUCING ROLLS	ROUND REDUCING ROLLS	OVAL REDUCING ROLLS	SIZING ROLLS	SMOOTH WIRE
					
4.0	RO 0	RT 0	RO 0	CA 3.0	3.0
4.5	RO 0	RT 0	RO 0	CA 3.5	3.5
5.5	RO 1	RT 1	RO 0	CA 4.0	4.0
5.5	RO 1	RT 1	RO 1	CA 4.5	4.5
6.0	RO 2	RT 2	RO 1	CA 5.0	5.0
7.0	RO 2	RT 2	RO 1	CA 5.5	5.5
7.5	RO 3	RT 3	RO 2	CA 6.0	6.0
8.0	RO 3	RT 3	RO 2	CA 6.5	6.5
8.5	RO 4	RT 4	RO 3	CA 7.0	7.0
9.0	RO 4	RT 4	RO 3	CA 7.5	7.5
10.0	RO 5	RT 5	RO 4	CA 8.0	8.0
11.0	RO 5	RT 5	RO 4	CA 8.5	8.5
11.0	RO 5	RT 5	RO 5	CA 9.0	9.0
12.0	RO 6	RT 6	RO 5	CA 9.5	9.5
12.0	RO 6	RT 6	RO 5	CA 10.0	10.0
13.0	RO 6	RT 6	RO 5	CA 10.5	10.5
15.0	RO 7	RT 7	RO 6	CA 12.0	12.0
14.0	RO 7	RT 7	RO 6	CA 11.0	11.0
14.0	RO 7	RT 7	RO 6	CA 11.5	11.5

## ROLLING SEQUENCE FOR REINFORCING WIRE

	First Pass		Second Pass		
ROD WIRE	OVAL REDUCING ROLLS	ROUND REDUCING ROLLS	FORMING ROLLS	PROFILING ROLLS	REINFORCING WIRE
					
4.0	RO 0	RT 0	FO 0	PR 3.0	3.0
4.5	RO 0	RT 0	FO 0	PR 3.5	3.5
5.5	RO 1	RT 1	FO 1	PR 4.0	4.0
5.5	RO 1	RT 1	FO 1	PR 4.5	4.5
6.0	RO 2	RT 2	FO 1	PR 5.0	5.0
7.0	RO 2	RT 2	FO 1	PR 5.5	5.5
7.5	RO 3	RT 3	FO 2	PR 6.0	6.0
8.0	RO 3	RT 3	FO 2	PR 6.5	6.5
8.5	RO 4	RT 4	FO 2	PR 7.0	7.0
9.0	RO 4	RT 4	FO 3	PR 7.5	7.5
10.0	RO 5	RT 5	FO 3	PR 8.0	8.0
11.0	RO 5	RT 5	FO 3	PR 8.5	8.5
11.0	RO 5	RT 5	FO 3	PR 9.0	9.0
12.0	RO 6	RT 6	FO 4	PR 9.5	9.5
12.0	RO 6	RT 6	FO 4	PR 10.0	10.0
13.0	RO 6	RT 6	FO 4	PR 10.5	10.5
15.0	RO7	RT 7	F04	PR 12.0	12.0
14.0	RO7	RT 7	F04	PR 11.0	11.0
14.0	RO7	RT 7	F04	PR 11.5	11.5