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Old fashioned tooling cripples tube, pipe and roll forming- Part II

Let's recap. In last month's article, we stated that grinding on any part of the roll will reduce the tool's ability to withstand frictional wearing forces

(Fig 1). We also explained that rolls have been manufactured in the same way since the beginning of roll tooling in 1930 - until now.

Thankfully, the new millennium has brought with it a zero tolerance for traditional tooling-related problems. End-users have increasingly demanded tighter tolerances, and the ability to run tooling longer than ever between re-working. As a result, those companies that produce roll tooling. Tube mills and roll formers have all been crying out for technical solutions to help them meet their customers' demands.

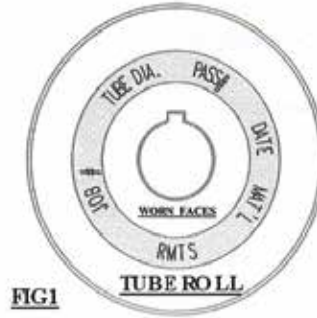
This article will focus on the new technology that is available to fulfill this requirement

- Have you ever had to have roll bores plated?
- Have you ever had to have faces welded due to face wear?
- Have you replaced tube mill shafts?

Well the good news is that you don't need to anymore. We're about to explain that you no longer need to invest in any of these costly processes - ever!

Please read on.

To make long lasting roll tooling there are many factors that need to work together to make the roll the best you can buy: a **"Super" Roll.**



Firstly, most rolls are made from D-2 grades, but this material varies in quality. Therefore, the smart initial step is to avoid the temptation to simply go for the lower price- a false economy - and instead select the highest quality D-2 from just one reliable supplier.

Specifying the right material

It must be pointed out at this stage that materials manufactured in many countries simply don't conform to the standards we have in the USA and in the West, generally. You can't make a silk purse from a sow's ear and if the material isn't right, then the roll won't be right. If you are unsure, don't be afraid to ask for quality specifications and quality sheets on the material purchased for your rolls - you are the customer. If your supplier gives you a hard time, you can draw your own conclusions and move onto someone who'll cooperate and not hide the truth. A roll is no longer a roll. It may not be popular to say this, but most roll manufactures are purchasing their material from the cheapest source, instead of specifying quality first. Ask for material certifications every time you buy rolls. Also, make sure your roll supplier is consistent on where they get their material from and ask why they are buying there.