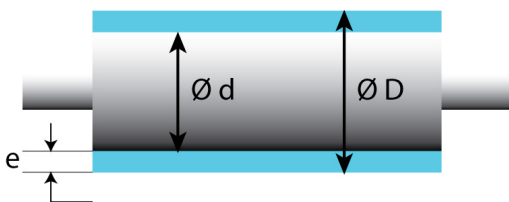


ROLL FINISHING

THE PRODUCTION PROCESS AT HANNECARD

Hannecard offers a wide range of finishing types for rolls. In this paper we discuss the most common types. Your Hannecard contact person will be happy to assist you in determining the covering that is most suitable for your application.

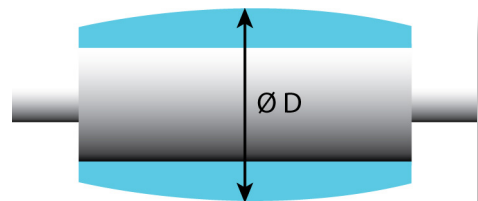
1. Cilindrical finishing



- Core diameter $\varnothing d$
- Covered diameter $\varnothing D$
- Thickness of covering e

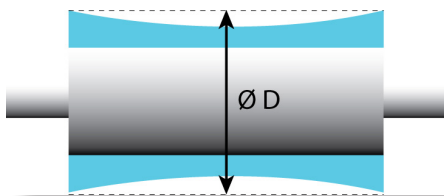
$$\varnothing D = \varnothing d + (2 \times e)$$

2. Parabolic crowning (or convex crowning)



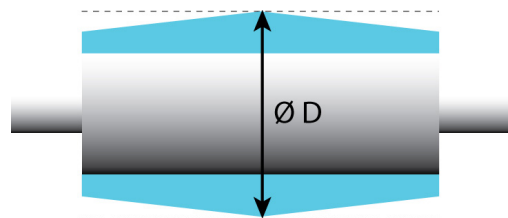
- The crown is expressed relative to $\varnothing D$
- eg : Parabolic crown 0,8mm/D

3. Hyperbolic crowning (or concave crowning)



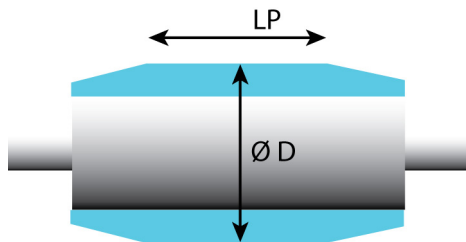
- The deflection is expressed relative to $\varnothing D$
- fe.: Hyperbolic bombage 1 mm/D

4. Tapered finishing



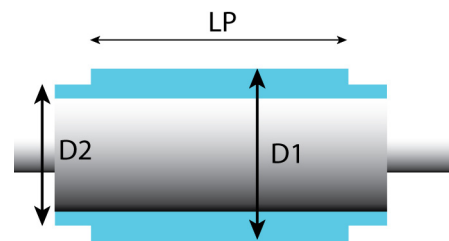
- The taper is expressed relative to $\varnothing D$
- fe.: Taper 2mm/D

5. Flat + Tapered finishing



- The length LP defines the flat area.
- The taper is expressed relative to $\varnothing D$

6. Grinding with collar



- $\varnothing D1$ defines the diameter of the covering
- $\varnothing D2$ defines the diameter of the collar
- The length LP defines the flat area.

7. Grooving

a/ Longitudinal or horizontal grooving



To be specified :

- The number of grooves
- The profile and dimensions of the grooves

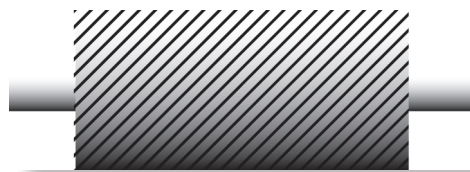
b/ Transversal or vertical grooving



Specify :

- The number of grooves
- The profile and dimensions of the grooves

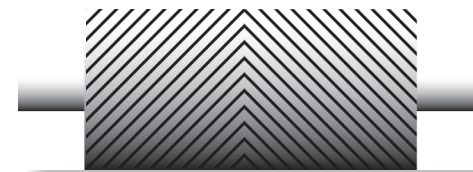
c/ Helical or spiral grooving



To be specified :

- The number of entries
- The pitch
- The direction
- The profile and dimensions of the grooves

d/ Spread grooving



To be specified :

- The number of entries
- The pitch
- The direction
- The profile and dimensions of the grooves

e/ Diamond grooving



To be specified :

- The number of entries
- The pitch
- The profile and dimensions of the grooves

8. Chamfered edges



To be specified :

- Or height x width eg.: Chamfer 2 x2
- Or width x angle eg.: Chamfer 5 x 45°

MORE INFORMATION?

For more information, please contact your local Hannecard partner or visit our website at : www.hannecard.com

RELATED DOCUMENTS

- Technical info - 'Hardness specifications'
- Technical info - 'Geometrical & Dimensional tolerances'
- Technical info - 'Mechanical services'
- Technical info - 'Roll covering process'
- Technical info - 'Selection guide'
- Technical info - 'Surface characteristics'
- Technical info - 'Transport & Packaging'