

QRC8

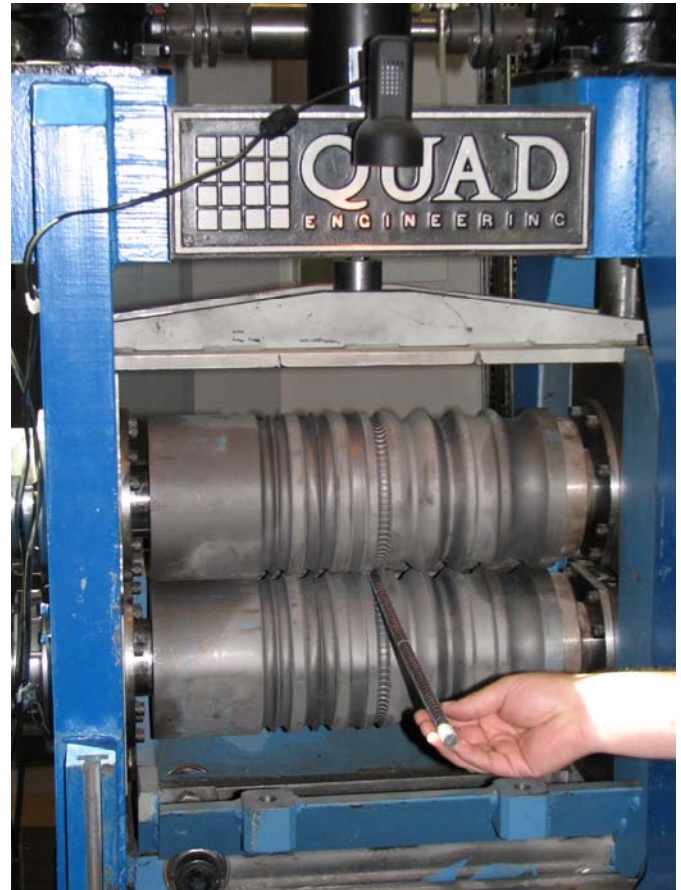
Hands-on Rolling of Slit Rebar

Quad has been presenting and continuously improving specialized Hands-on Operator/Roller training since 1985. The Hands-on Rebar of slit Rebar course uses the math and science involved in rolling slit rebar explained in real terms that can be understood and used by Mill Operators. Actual rolling on Quad's Training Mill reinforces theory with reality to help participants improve productivity at your mill.



Training Affects Your Bottom Line

Operator training is an important component to helping your operators get the most out of each shift. The hands-on approach ensures that concepts are understood and reinforced in the familiar mill environment. All aspects of rolling, from pass design and setup sheets through to mill setup and bar measurements are covered. The bar is studied after each pass. The Operators get to experiment and “see for themselves”. Defects encountered are discussed and solutions are implemented to ensure complete understanding. A comprehensive textbook is included, for use as a reference back at the plant.



What Participants have said about our Training Program:

- *The “hands-on” aspect of the class was excellent (Roller, Gerdau Ameristeel)*
- *I liked seeing the effect of our predictions (Roller, Nucor Steel)*



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Hands-on Rolling of Slit Rebar

Over 75% of North American Mini Mills have used Quad for Training

Course Objectives & Benefits:

Hands-on rolling experience, allowing participants to “see for themselves”. Improved productivity due to a more in depth understanding of the fundamental principals of rolling slit rebar. Address various slitting design methods from an operator’s point of view to develop an understanding of how to set and adjust passes to make a quality product. Cost effective production decisions due to improved problem solving skills.

Course Outline:

Rolling Process:

Review of rolling process from pass design & setup through to operation & feedback.

Rebar Slitting Pass Design & Setup Sheet:

Rebar slitting pass design sequences and applications for double strand and triple strand slitting include, oval-square, slab & edge, dogbone-slitter, and flat oval-rebar. The finished rebar and leader oval passes used in the mill are designed from first principles. A rolling schedule is developed for feeding the dogbone pass with a square, fluted square and rectangle shaped bar. The operating differences of these various slitting methods are demonstrated and discussed. All aspects of a product setup sheet including gap settings and adjusting for mill spring are used.

Rebar Rolling:

The various pass sequences developed in the classroom are applied on Quad’s 8” lab mill using lead billets. The participants set the mill & guides and roll the bar. The bar is analyzed and measured after each pass and compared to the setup sheet plan. Any corrective action is applied to the next pass. Defects created are discussed and corrective action applied. Multiple billets are rolled so lessons learned can be applied and the results observed. The behavior and location of the slit seam is observed. The sensitivity of the specialized slitting sequence passes is demonstrated on the mill. The finishing pass design and how it affects the bar shape and the capability of rolling light are discussed and demonstrated.

Who Should Attend:

Mill Managers, Shift Supervisors, Rollers, Assistant Rollers, Pulpit Operators, Engineers, Pass Designers, Roll and Setup Shop Supervisors, Quality Control.



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