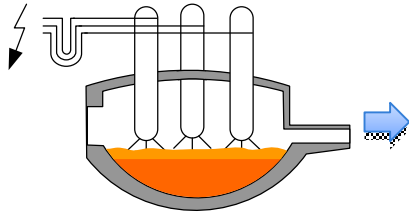


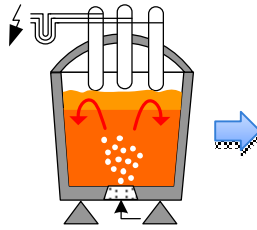


Surface Hardened Rolls Production Flowchart

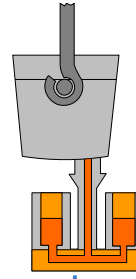
UHP / EAF 40 t



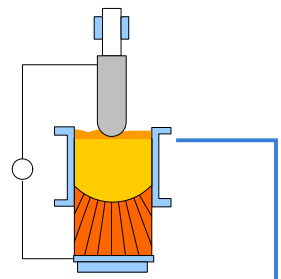
VAD



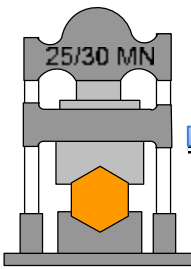
INGOT / ESR -
ELECTRODE CASTING



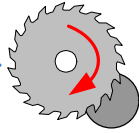
ESR



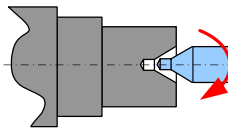
FP



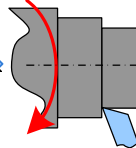
CUTTING



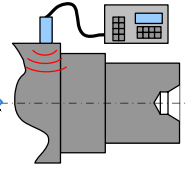
CENTER
BORING



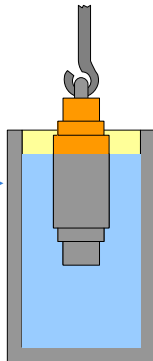
ROUGH
TURNING



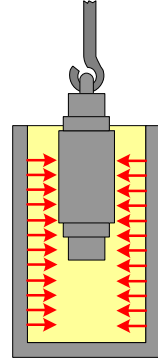
ULTRASONIC AND
MAGNETIC CONTROL



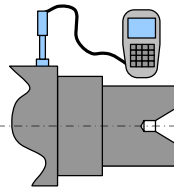
HARDENING



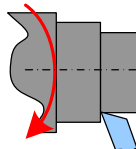
TEMPERING



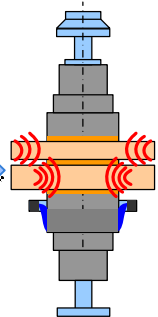
HARDNESS
CONTROL



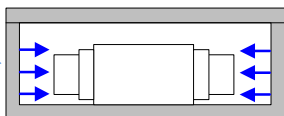
TURNING



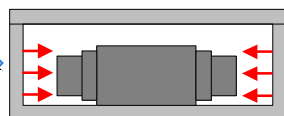
SURFACE
HARDENING



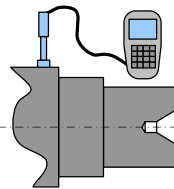
BELLOW ZERO
TREATMENT



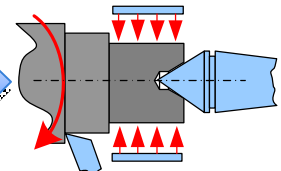
TEMPERING



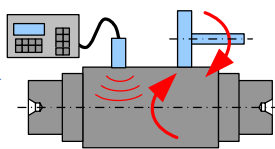
HARDNESS
CONTROL



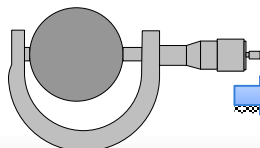
FINAL TURNING AND
NECK HARDENING



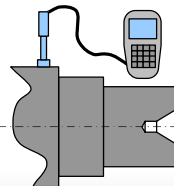
GRINDING AND MT (EDDY
CURRENT CONTROL)



DIMENSION
CONTROL



HARDNESS
CONTROL



PACKAGING OR
OVERSEAS PACKAGING

