

O.M.O. Manual Rolling-Mills

Some technical information...

- Our rollers are made in chromium steel. Material: K100 – Hardness: 65 Rockw
- To all the moving parts (screws and gears of the reducer) we made an anti-seizing-up treatment.
- 1 : 4 reduction gear
- 1 turn = 1 mm
- Capacity of rolling: from mm 0.10 to mm 4.50 in the mm 100 model; from mm 0.10 to mm 5.00 in the mm 120 model.
- Weights: Model 480/100 → Kg. 40 * Model 480/R100 → Kg. 45 * Model 480/R120 → Kg. 60

Instructions for rolling ...

- Anneal the piece of sheet or ingot.
- Put the metal in position, but before passing it through the rollers, lower the rollers until You reach a snug fit.
- If the metal becomes too hard to roll, it must be annealed again.
- Repeat the operation, until You achieve the desired thickness.

Wire rolling ...

- Reduce the wire, by rolling 2 or 3 times in each groove, rotating the wire of 90 degrees on each pass. The rollers should be closed before moving to the next groove.
- You must anneal the material as often as necessary, in order to avoid excessive force when rolling.
- Indications of excess hardness are: frayed edges, surface cracking, wrinkling of surface or excessive force needed to turn the rollers.

Rolling mill care...

- Always bolt down your rolling mill to a secure bench or a secure stand.
- When you are not using Your rolling mill, please apply a thin coating of oil to the rollers and lubricate all the indicated parts. Spread the oil evenly across the surface. It is very important that the rollers are always protected, especially in wet/hot conditions or when temperatures are changing. Once your rollers are marked, rusty or corroded, they will be like this for ever, until you change them. This can be avoided, if You take care of them.
- Keep the rollers clean, but do not touch them with Your hands. Oils and acids from Your body may damage them, leaving marks or rust.
- If possible, try to use the centre of the rollers. This will give them a longer life, because it will ensure an even pressure.
- Do not roll material, such as iron or steel.
- After finishing your job, always release pressure on the rollers.
- Never lift the rolling mill from the hand wheel.