## Roll Chart for Rotary Formers

| Roll Style | 2" Centers | | | | | 3" Centers | | | |
|---|---|---|---|---|---|---|---|---|---|
| | Roll Description | Roll Cat. Number | | Gauge Req'd Series 544 | Gauge Req'd Series 622 | Roll Cat. Number | | Gauge Req'd 0617 | Spacing Collar 0617 |
| A | Turning | 1/8" | 350000001<br>350000002 | 259700028 | 259700032 | 3/16" | 350000086<br>350000087 | 259700035 | 381700092 |
| | | | | | | 1/4" | 350000088<br>350000089 | 259700035 | 381700092 |
| B | | 3/16" | 350000049<br>350000050 | 259700028 | 259700032 | 5/16" | 350000090<br>350000091 | 259700035 | 381700092 |
| C | Burring | | 350000003<br>350000004 | 259700028 | 259700032 | | 350000092<br>350000093 | 259700035 | 381700092 |
| D | Wiring | | 350000005<br>350000006 | 259700028 | 259700032 | | 350000094<br>350000095 | 259700035 | 381700092 |
| No. 1 | Elbow Edging | | 350000051<br>350000052 | 259700028<br>or<br>259700046 | 259700032 | | 350000122<br>350000123 | 259700035 | 381700092 |
| L | Flange | | 350000053<br>350000054 | 259700029 | 259700045 | | 350000137<br>350000138 | 259700037 | 381700092 |
| M | Flattening | | 350000055<br>350000056 | NONE | NONE | | 350000139<br>350000140 | NONE | 381700092 |
| E | Crimping | | 350000007<br>350000008 | N/A | 259700060 | 1/4" | 350000098<br>350000099 | 259700034 | 381700092 |
| | | | | | | 5/16" | 350000096<br>350000097 | | |
| F | Ogee Bead | 3/4" | 350000009<br>350000010 | N/A | 259700093 | 9/16" | 350000100<br>350000101 | 259700035 | Not Req'd |
| | | | | | | 1" | 350000011<br>350000012 | | 381700092 |
| G | Single Bead | 1/4" | 350000029<br>350000030 | N/A | 259700093 | 5/8" | 350000124<br>350000125 | 259700035 | Not Req'd |
| | | | | | | 3/8" | 350000013<br>350000014 | | 381700092 |
| H | Slitting Cutters | | 350700068<br>350700069 | N/A | 259700032 | Carbon<br>High speed | 350700070<br>(2 req'd)<br>350700067<br>(2 req'd) | 259700035 | 381700085 |
| N | Furnace Collar Edging | | 350000067<br>350000068<br>350000069<br>(2 req'd) | N/A | 259700060 | | 350000070<br>350000071<br>350000072<br>350000073 | 259700034 | 381700092 |
| P | Offset | | 350000076<br>350000077 | N/A | 259700060 | | 350000074<br>350000075 | 259700034 | 381700092 |