



QASF Co. Ltd.

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Road No. 12,
Dong Xuyen Industrial Park,
Rach Dua ward,
Vung Tau City,
Vietnam.
Tel/Fax : +84 64 614299

Document Title **PLATE ROLLING**

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Included Forms **Formed shell dimensional check**

Department **Engineering**

Type **Procedure**

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Responsible person(s) **Engineering Manager**

APPROVAL

NAME: _____ POSITION: _____

SIGN: _____ DATE: _____



PLATE ROLLING

1 INTRODUCTION

- 1.1 This procedure describes the control methods for rolling steel plate.
- 1.2 The Workshop Foreman shall be overall responsible for the process.
- 1.3 The Team Leader or his authorised appointee shall perform the work.
- 1.4 The QC Inspector shall check the rolled plate.
- 1.5 The Engineering Manager is responsible for implementation of this procedure.

2 REVISIONS

Rev.	Date	Nature of Changes	Approved By
0	20.1.17	Issued for use	HQA
1	21.2.24	Form added	NHD
2	6.3.24	Customer comments added	NHD

3 PROCEDURE

- 3.1 The designated Rolling Machine Operator shall have at least one assistant.
- 3.2 The Team Leader shall check that the plate(s) to be formed are correct in accordance with the approved drawing.
- 3.3 The Operator shall check that all the machine controls and gauges are operating correctly.
- 3.4 The plate to be rolled shall be clean and free of surface protruding defecting. If there are cut edges then the edges should be ground flush where necessary.
- 3.5 Feed the plate into the rolling machine and align the plate straight edge with the upper roller.
- 3.6 Adjust the upper roller height and feed in the plate.
- 3.7 Continue upper roller adjustment whilst feeding the plate through the machine until the required arc, radius or diameter has been achieved.
- 3.8 Once the plate rolling is complete and the rolled plate has been removed, the Team Leader or Fitter shall check the plate roundness.



3.9 Out of roundness shall be limited to the following (ASME VIII Div 1, UG-80);

The difference between the maximum and minimum inside diameters at any cross section shall not exceed 1% of the nominal diameter at the cross section under consideration.

3.10 If there is any unacceptable out of roundness then the plate shall be reworked or discarded.

4 FORMS

[Dimensional Check Formed Head](#)