**SOP - Rolling Mill (B Building)**

ROLLING IS A TWO PERSON OPERATION

One person feeds the sample in.

One person guides the sample out.

1. Do not operate the machine unless there are two people present.
2. Wind the roll gap to the desired thickness.
3. Turn on power to the rolling mill at the power point on the wall.
4. To start rolling, press the green button.
5. Feed the sample into the rolls using a push rod - **NOT FINGERS**.
   - Never hold sample with hands on entry side (Unless sample is >50 cm in length)
   - Never wear gloves on the entry side
6. To stop the rolls press the red button.
7. Always turn off power to the rolling mill when finished.

NB: Rolls can be electrically driven up and down using the lever on the right hand side of the control panel. The key must be turned on for the electrical motor to operate. Always turn key off when finished. Driving the rolls to the maximum upper and minimum lower limits of the roll gap may cause the rolls to get stuck, so don’t use the motor when near either extreme.