Miscellaneous Data

3-Strand Rod Mill - Bethlehem, Johnstown

Air-Cooling at laying reels has produced the following economies at Johnstown:

Average amount of scale by weight after coiling.
Johnstown 0.33% by weight air cooling
Sparrows Pt. #1 Mill 1.67 by weight no air-cooling
Sparrows Pt. #2 Mill 1.86 " " " "
AS&W, Donora 2.00 by weight no air-cooling

Pickling time after air-cooling in reels, 25 minutes
" no air-cooling in reels, 45 minutes

Current mill yield 0.90% cobbles

Rod Temperatures

1750°F. out of #23 stand
1625°F. out of reel pipes
1250°F. to 1300°F. out of laying reels with 21 seconds blowing time.

Roll Changing Time

All rolls in 23 stands have been changed with housings in place, in a total time of six and a half hours.
Rolls are always changed with housings in place on all stands including finishing train.

Production

The mill is currently operating on a 20-turn per week basis with Monday day turn for maintenance.

March 1959 Produced 25,944 tons
April 1959 " 26,500 tons (38 hours delay)
May 1959 Expecting 29,000 tons

The best tonnage figures to date include:

477 tons per 8 hours
1190 tons per 24 hours (April 1959)
990 tons per 24 hours 7/16" dia. rod
458 tons per 8 hours 7/32" dia. rod
77 tons per hour 23/64" dia. rod
To date the largest diameter rod which has been handled on the laying reels is 33/64".

A New Coil Compacting Press was put into operation about 1 May.

Coils are removed from the lazy susan hook unloader by a ram truck and deposited in a Vee trough on the horizontal hydraulic press. Six 625 lb. rod coils are compressed to 40% of their free length and manually bound by two loops of steel strapping. They are very pleased with this operation and the compressed coil batches have materially reduced damage while permitting them to increase the gondola loadings from 40 to 60 tons. Joe Brown claims to be the author of this device.

### 4-Strand Rod Mill - AS&W - Cuyahoga Works

<table>
<thead>
<tr>
<th>Production</th>
<th>8-Hour Records</th>
</tr>
</thead>
<tbody>
<tr>
<td>Size</td>
<td>Tons/Turn</td>
</tr>
<tr>
<td>.230 Rd.</td>
<td>632.3</td>
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<tr>
<td>5 Rd.</td>
<td>647.4</td>
</tr>
<tr>
<td>4 Rd.</td>
<td>672.7</td>
</tr>
<tr>
<td>9/32</td>
<td>629.2</td>
</tr>
<tr>
<td>17/32</td>
<td>779.2</td>
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<td>13/32</td>
<td>698.4</td>
</tr>
<tr>
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<td>690.4</td>
</tr>
<tr>
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<td>660.5</td>
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<tr>
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<td>669.6</td>
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<tr>
<td>19/64</td>
<td>684.8</td>
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<tr>
<td>11/32</td>
<td>731.7</td>
</tr>
<tr>
<td>27/64</td>
<td>789.3</td>
</tr>
</tbody>
</table>

**Tons produced to date during 1959**

- 24 Hour Basis: 2105.3 Tons
- Weekly Basis:
  - Turns: 20
  - Tons: 11772.7
  - Ave. Tons/Turn: 588.6
- Monthly Basis:
  - Turns: 83
  - Tons: 45764.3
  - Ave. Tons/Turn: 551.3

**Tons Produced During 1958**

- Turns: 653.3
- Tons: 278922.1
- Ave. Tons/Turn: 426.9