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1) The arc of contact  
between the rolls and  
the metal is a part of a

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circle. 2) The coefficient of friction,  $\mu$ , is constant in theory, but in reality  $\mu$  varies along the arc of contact. 3) The metal is considered to deform plastically during rolling.

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In cold-rolling of steel, fluid lubricants having low viscosity are used, paraffin is suitable for

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non-ferrous materials like aluminum, copper and its alloys to avoid staining during subsequent heat treatment process, while, hot rolling is often carried out without lubricants but with a flood of water to generate steam and break up the scales formed, are used.

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processes, width  
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