



317 East 11th Street, Chicago Heights, IL 60411
 Telephone: (800) 441-0307 Fax: (309) 697-7487 Email: foreaker@keystonesteel.com OR
 Telephone: (877) 388-0169 Option 1 Fax: 708-753-1201 Email: brookspt@keystonesteel.com

REVISED - February - July 2012 Rolling Schedule
 Subject to change based on accumulation of orders for a given size

FRACTIONS	Seq No.	Shape	Width	Thickness	Exceptions	Cycle 2	Cycle 3	Cycle 4	Cycle 5
	1	Special Sections	4-1/4	1/4 - 5/16		6-Feb	19-Mar	30-Apr	11-Jun
	2	FLATS, REOA and SPECIAL SECTIONS	3 - 4	1/4 - 15/16	Excludes 3 - 3-1/4 by 1/4 - 3/8	6-Feb	26-Mar	14-May	2-Jul
	3		2 - 3	1/4 - 15/16	Excludes 2 by 1/4 to 3/8	13-Feb	26-Mar	7-May	18-Jun
					Includes 3 to 3-1/4 by 1/4 - 3/8	13-Feb	26-Mar	7-May	18-Jun
	4		1-1/2 - 2	1/4 - 1"	Includes 2 by 1/4 to 3/8	20-Feb	2-Apr	14-May	25-Jun
					Excludes 1-1/2 - 1-5/8 by 1/4 - 5/16	20-Feb	2-Apr	14-May	25-Jun
	5		15/16 - 1-7/16	1/4 - 5/8	Includes 1-1/2 - 1-5/8 by 1/4 - 5/16	27-Feb	9-Apr	21-May	2-Jul
		3/4 - 7/8	5/16 - 13/16		27-Feb	9-Apr	21-May	2-Jul	
	6	Near Squares See Footnotes	3/4 to 1-13/32	21/32 to 1-1/16		5-Mar	16-Apr	28-May	9-Jul
	7		7/8	5/16 to 5/8		5-Mar	16-Apr	28-May	9-Jul
	8		3/4 to 13/16	5/8		5-Mar	16-Apr	28-May	9-Jul
	9	Squares	45 Ton / Size Min	1 - 1-9/16		5-Mar	16-Apr	28-May	9-Jul
10	Rounds	45 Ton / Size Min	1 - 1 3/4		5-Mar	16-Apr	28-May	9-Jul	
11	Squares	45 Ton / Size Min	3/4 - 7/8		12-Mar	23-Apr	4-Jun	16-Jul	
12	Rounds	45 Ton / Size Min	3/4 - 15/16		12-Mar	23-Apr	4-Jun	16-Jul	
13	Diamonds	90 Ton / size Min				23-Apr			

DECIMALS	Seq No.	Shape	Width	Thickness	Exceptions	Cycle 2	Cycle 3	Cycle 4	Cycle 5
	1	Special Sections	4.125	0.25 - 0.313		6-Feb	19-Mar	30-Apr	11-Jun
	2	FLATS, REOA and SPECIAL SECTIONS	3 - 4	0.25 - 0.938	Excludes 3 - 3.25 by 0.25 -0.375	6-Feb	26-Mar	14-May	2-Jul
	3		2 - 3	0.25 - 0.938	Excludes 2 by 0.25 - 0.375	13-Feb	26-Mar	7-May	18-Jun
					Includes 3 - 3.25 by 0.25 -0.375	13-Feb	26-Mar	7-May	18-Jun
	4		1.5 - 2	0.25 - 1"	Includes 2 by 0.25 - 0.375	20-Feb	2-Apr	14-May	25-Jun
					Excludes 1.5 - 1.625 by 0.25 -0.313	20-Feb	2-Apr	14-May	25-Jun
	5		0.938 -1.438	0.25 -0.625	Includes 1.5 - 1.625 by 0.25 -0.313	27-Feb	9-Apr	21-May	2-Jul
		0.75 - 0.875	0.313 - 0.813		27-Feb	9-Apr	21-May	2-Jul	
	6	Near Squares See Footnotes	0.75 - 0.406	0.656 - 1.016		5-Mar	16-Apr	28-May	9-Jul
	7		0.875	0.313 - 0.625		5-Mar	16-Apr	28-May	9-Jul
	8		0.75 - 0.813	0.625		5-Mar	16-Apr	28-May	9-Jul
	9	Squares	45 Ton / Size Min	1 - 1.563		5-Mar	16-Apr	28-May	9-Jul
10	Rounds	45 Ton / Size Min	1 - 1.75		5-Mar	16-Apr	28-May	9-Jul	
11	Squares	45 Ton / Size Min	0.75 -0.875		12-Mar	23-Apr	4-Jun	16-Jul	
12	Rounds	45 Ton / Size Min	0.75 - 0.938		12-Mar	23-Apr	4-Jun	16-Jul	
13	Diamonds	90 Ton / size Min				23-Apr			

Keystone - Calumet, Inc. also provides in-house annealing, descaling/oil, saw cutting and special straightening

Closed Rolling Subject to Min Accumulation for the Family of Sizes Rolling Closed to New Sizes

Footnotes: Near Squares, Squares and Rounds require 45 ton minimum accumulation. Near Squares with an accumulation of 40 tons will roll every cycle. Near Squares with smaller Accumulations will roll on even-numbered cycles.