rolling direction. The clearance d3 is the distance in the perpendicular direction of the third section 713 between the upper end of the section corresponding to the flange of the web guide 82 (section extending at an angle with respect to the right and left direction as viewed from the rolling direction of the upper end) and the lower end of the roll gap (upper end of the lower roll 62) of the third section 713 of the K2 groove 71. It is preferable that the clearance d1 has a distance of 40% or more and 120% or less of the distance of the roll gap in the first section 711 of the K2 groove 71 and that the clearance d3 has a distance of 60% or more and 180% or less of the distance of the roll gap in the third section 713. The roll gaps in the first section 711 and the third sections 713 of the K2 groove 71 are equivalent to the sheet thicknesses of the web 11 and the flanges 12, respectively, of the product of the hat-shaped steel sheet pile 1A to be rolled. By setting the clearances d1, d3 in the ranges above, the same effects as those in the clearance d2 are obtained.

[0022]

The upper rest bar 83 is a member supporting the pair of roller guides 81 and provided to extend in the right and left direction. The upper rest bar 83 is provided to be fixed to a housing or a chock of the rolling mill in which the guide 8 is provided. The upper rest bar 83 is provided above the K2 groove 71 as viewed from the rolling