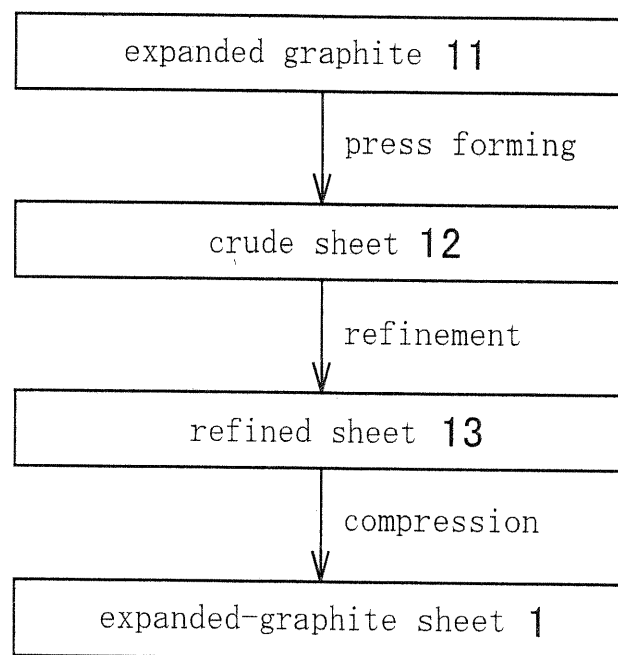
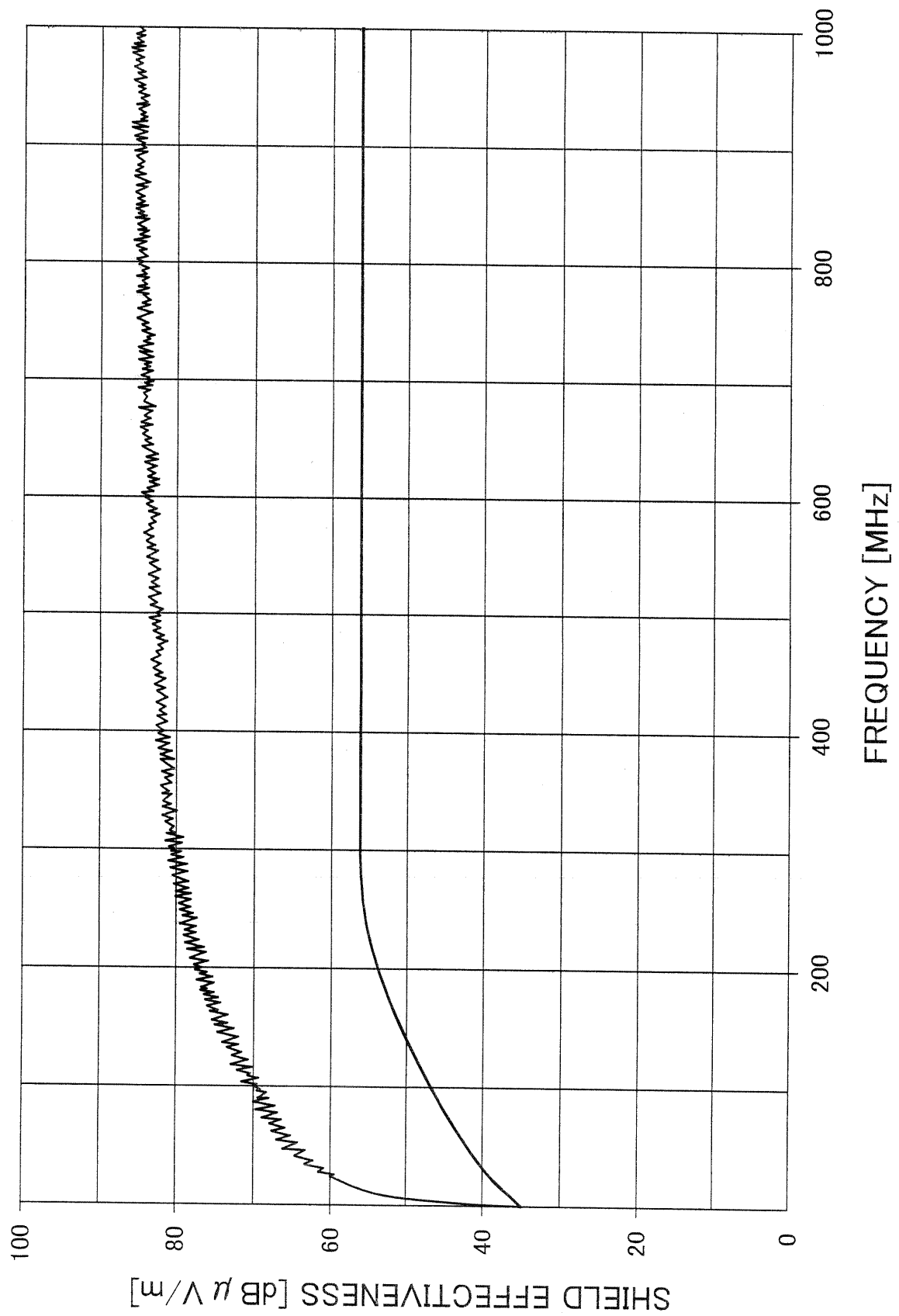


1/3  
F I G. 1



2/3  
F I G . 2



3/3  
F I G. 3

|                                                                  | rolling speed (m/min) |            |         |         |         |         |  |
|------------------------------------------------------------------|-----------------------|------------|---------|---------|---------|---------|--|
|                                                                  | 1                     | 2          | 4       | 6       | 8       | 10      |  |
| creases                                                          | no creases            | no creases | creases | creases | creases | creases |  |
| surface roughness<br>center line average height<br>Ra ( $\mu$ m) | 2                     | 3          | 5       | 6       | 6       | 6       |  |
| $\frac{\text{Max-Min}}{\text{Ave}} \times 100$ (%)               | 5                     | 8          | 14      | 14      | 22      | 30      |  |