

The invention relates to a Sexto-type roll stand with x^3 grinding, in which a large difference in diameter between the intermediate rolls (20, 21) causes increased wear and rough surfaces on the support rolls (30, 31) during operation, the damage pattern on the support rolls (30, 31) corresponding to the shape of the CVC grinding following an extended operating time. In Quarto-type roll stands, the grinding amplitude is initially also significantly greater than is required for rolled programs, thus resulting in the unfavorable wear pattern as well on the support rolls. The aim of the invention is to minimize said flaws. Said aim is achieved by the fact that the surface length (L) of each intermediate roll (20, 21) in a Sexto-type roll stand or each working roll in a Quarto-type roll stand is composed of a cylindrical section (Z) and a convexly curved section (R(x)). The transition point (A) from the cylindrical to the curved section of the surface length of the rolls can be selected within the range $L/2 \leq x < L$ while the curved contour which extends in opposite directions across some of the width of the rolled material in the direction of the end of the roll barrel on both rolls (20, 21) is described by a mathematical polynomial $R(x) = a_0 + \dots + a_n x^n$, wherein $n=5$.