

Title (en)  
PROCESS AND DEVICE FOR THE ROLLING OF METAL WITHOUT TENSION

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Application  
**EP 81400827 A 19810525**

Priority  
FR 8011796 A 19800528

Abstract (en)  
[origin: US4408470A] The invention involves a procedure having three key stages: In the first stage, just prior to the introduction of the metal into stand (n+1), the value of the rolling torque in stand (n) is determined and recorded. Then, in the second stage, when the metal is introduced into stand (n+1), the value of the rolling torque in stand (n) is held constant by controlling the speed regulator of stand (n) up to the time the metal is introduced into stand (n+2). Finally, in the third stage, which continues until the rolling operation in stand (n) has been completed, the voluminal flow of the metal is held constant at the line of each stand by applying a multiplier coefficient to the signal representing the ratio between the speeds of two successive stands.

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