

Title (en)

METHOD OF EXECUTING THE SKIN PASS AT A REGULATED RATE IN THE ROLLING OF STEEL STRIPS ANNEALED IN A FURNACE

Publication

EP 0046423 B1 19841010 (FR)

Application

EP 81401230 A 19810730

Priority

FR 8018054 A 19800818

Abstract (en)

[origin: EP0046423A1] 1. A temper rolling process for producing mild steel strips intended for the manufacture of packaging, in which coiled metal sheets are brought substantially to the strip thickness by a first cold rolling, annealing to eliminate structural anisotropies generated by the first rolling, an then tempering by a second rolling with only slight elongation so as to bring the strip metal to a selected hardness, characterised in that for imparting to the strips which have been box-annealed a hardness comparable to that of strips which have been subjected to continuous annealing and tempered by dry rolling with an elongation of less than 2%, the steel strips, which were of normal quality for continuous annealing, but which have been box-annealed, are conveyed to two successive stands (11, 12), so that the resulting elongation is regulated to a selected value between 4 and 20% and produced for the most part by the first stand (11), the strip is lubricated at the entrance of the first stand by projection (6) of an oil-in-water emulsion, the strip is washed with water (7) at a temperature above the ambient temperature between the stands (11, 12), and the strip is dried by air-blasting (8) at the exit from the second stand (12).

IPC 1-7

B21B 1/28; **B21B 37/00**

IPC 8 full level

B21B 1/28 (2006.01); **B21B 37/56** (2006.01); **B21B 45/02** (2006.01); **B21B 27/00** (2006.01)

CPC (source: EP)

B21B 1/28 (2013.01); **B21B 37/56** (2013.01); **B21B 45/0251** (2013.01); **B21B 45/0278** (2013.01); **B21B 27/005** (2013.01)

Cited by

CN117753782A; ES2043530A1; EP0723824A1; EP0679451A1; NL9400674A; US5693287A; EP0436762A1; EP0391658A1; EP1013351A3

Designated contracting state (EPC)

BE DE GB IT NL

DOCDB simple family (publication)

EP 0046423 A1 19820224; **EP 0046423 B1 19841010**; **EP 0046423 B2 19901219**; DE 3166614 D1 19841115; DE 46423 T1 19830317; ES 504786 A0 19820616; ES 8205589 A1 19820616; FR 2488532 A1 19820219; FR 2488532 B1 19821105; GR 75311 B 19840713; NO 152676 B 19850729; NO 152676 C 19851106; NO 812771 L 19820219; PT 73532 A 19810901; PT 73532 B 19830824

DOCDB simple family (application)

EP 81401230 A 19810730; DE 3166614 T 19810730; DE 81401230 T 19810730; ES 504786 A 19810817; FR 8018054 A 19800818; GR 810165790 A 19810813; NO 812771 A 19810817; PT 7353281 A 19810817