

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 B2 19901219 (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).

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CPC (source: EP)

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Cited by

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

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