

Title (en)
METHOD AND DEVICE FOR THE ROLLING OF STRIPS, FREE OF STRESS

Publication
EP 0049425 B1 19860319 (DE)

Application
EP 81107609 A 19810924

Priority
DE 3037584 A 19801004

Abstract (en)
[origin: EP0049425A2] 1. Method for the rolling of stress-free rolled strip through thermal influencing of the diameter of the rolls by means of regulation of their axial temperature distribution through acting on the rolls with a cooling, lubricating and/or cleaning liquid, wherein quantity, pressure or temperature of the liquid is altered in dependence on partial tension stresses determined in zones lying in transverse direction of the strip behind the last stand in that two liquids of different temperatures, the partial quantities of which are regulable in dependence on the determined partial tension force, for each zone are conducted, preferably settable in their width of impingement, to at least the roll stand arranged upstream of the place of measurement of the partial tension stresses, characterised thereby, that a first liquid, which is kept at a first temperature, is conducted at settable constant quantity flow to the rolls and that the quantity flow of the second liquid, which displays a lower temperature and is conducted additionally to at least the working rolls (2, 3), is regulable zone by zone in dependence on the determined partial tension stress.

IPC 1-7
B21B 37/10; **B21B 45/02**

IPC 8 full level
B21B 45/02 (2006.01); **B21B 1/22** (2006.01); **B21B 1/26** (2006.01); **B21B 27/10** (2006.01); **B21B 37/32** (2006.01)

CPC (source: EP)
B21B 27/10 (2013.01); **B21B 37/32** (2013.01)

Cited by
EP0181785A1; DE3523483A1; DE3419261A1; GB2160136A; US4750343A

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DE FR GB IT

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EP 0049425 A2 19820414; **EP 0049425 A3 19830126**; **EP 0049425 B1 19860319**; DE 3037584 A1 19820519; DE 3174134 D1 19860424; JP H0355201 B2 19910822; JP S5791803 A 19820608

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