

Title (en)
METHOD OF AND ARRANGEMENT FOR ROLLING STRESS-FREE STRIP

Publication
EP 0054172 B1 19850605 (DE)

Application
EP 81109338 A 19811030

Priority
DE 3046822 A 19801212

Abstract (en)
[origin: EP0054172A2] 1. Method for the rolling of stress-free rolled strip (1) through influencing the value of friction between the strip surfaces and the roll barrel shell surfaces in dependence on partial tension stresses ascertained in zones lying in transverse direction of the strip behind the last stand (2, 3, 4, 5), in which method on the one hand the shell surfaces of the roll barrel of the working rolls (2, 3) at the roll gap and on the other hand the surface of the rolled strip are acted on by two liquids of different lubricity, characterised thereby, that pure base oil of a rolling oil emulsion is introduced into the rolling operation temporally or spatially before this rolling oil emulsion and in that case applied exclusively and directly onto the surface of the rolled strip (1) in locally limited regions and in quantities determined by the ascertained partial tension stresses (6).

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IPC 8 full level
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CPC (source: EP)
B21B 37/32 (2013.01); **B21B 45/0251** (2013.01); **B21B 37/44** (2013.01); **B21B 45/002** (2013.01)

Cited by
US7210302B2; DE102005001806A1; CN102242009A; DE3835460A1; EP0367967A3; US5090225A; EP0226446A3; US4793401A; CN104785527A; EP3517228A1; WO2019145079A1

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