

Title (en)

Control method for multi-strand rolling mill.

Title (de)

Verfahren der Regelung für ein mehradriges Walzwerk.

Title (fr)

Procédé de réglage d'un laminoir à plusieurs lignes.

Publication

EP 0061539 A1 19821006 (EN)

Application

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Priority

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Abstract (en)

When two workpiece strands (14, 16) pass through a roll gap between two grooved working rolls (10, 12) on a roll stand to be rolled, the trailing end of one of them may leave the rolls to change the roll gap. At that time screw-down devices (20, 22) on each side of the roll stand are controlled to adjust the roll gap at least at the position of the remaining workpiece. Also in a multi-strand tandem rolling mill, rolling speeds on roll stands upstream of a roll stand from which one of the strands has departed are changed by a speed ratio of $(1-b_2)/(1-b_1)$ where b_1 and b_2 designate the rates of backward slips in the presence of the two strands and in the absence of one of the strands on the last-mentioned roll stand. Alternatively roll speeds on roll stands downstream of that roll stand may be changed by a speed ratio of $(1+f_2)/(1+f_1)$ where f_1 and f_2 designate the rates of forward slip which correspond to the b_1 and b_2 respectively.

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CPC (source: EP)

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Citation (search report)

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