

Title (en)
CONTROL METHOD FOR MULTI-STRAND ROLLING MILL

Publication
EP 0061539 B1 19850206 (EN)

Application
EP 81301316 A 19810326

Priority
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Abstract (en)
[origin: EP0061539A1] 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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IPC 8 full level
B21B 37/16 (2006.01); **B21B 1/18** (2006.01); **B21B 13/00** (2006.01); **B21B 13/02** (2006.01)

CPC (source: EP)
B21B 37/165 (2013.01); **B21B 1/18** (2013.01); **B21B 13/02** (2013.01); **B21B 2013/006** (2013.01)

Cited by
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