

Title (en)

METHOD FOR ROLLING A U-SHAPED STEEL BAR OR SIMILAR AND BEAM-MAKING UNIVERSAL MILL TRAIN FOR IMPLEMENTING SUCH METHOD

Publication

EP 0065533 B1 19850410 (DE)

Application

EP 81903112 A 19811026

Priority

DE 3040325 A 19801025

Abstract (en)

[origin: WO8201484A1] The U-shaped steel bar or similar is produced on a beam-making universal mill train from a U-shaped blank bar (7). It is bevelled in a transitional zone between the external sides of the base and the side branches. Bosses (8a) are formed on the said bevels at each rolling pass with the horizontal rollers (11, 12) and with the vertical rollers (13). These bosses are constantly laminated during the compressing passes effected with horizontal compressing profiled rollers (15, 16) and even during the reconstitution of the bevels (17) and until, in a universal compressing rolling pass of the bevels, the said bosses disappear by the bringing near of the vertical rollers. The intermediate sharp-edged bar made thereby in the transitional zone is further rolled until the final profile is obtained with the universal gauge. The universal frame for rolling the blank bar and the intermediate sharp-edged bars is provided with vertical rollers (13) with shoulders (14), so that the vertical rollers may overlap through continuous engagement with their cylinder table arranged under the horizontal roller (11).

IPC 1-7

B21B 1/10

IPC 8 full level

B21B 1/10 (2006.01); **B21B 1/08** (2006.01)

CPC (source: EP)

B21B 1/095 (2013.01)

Citation (examination)

DE 2420408 A1 19750313 - NIPPON STEEL CORP

Designated contracting state (EPC)

AT FR GB LU SE

DOCDB simple family (publication)

WO 8201484 A1 19820513; DE 3040325 A1 19820603; EP 0065533 A1 19821201; EP 0065533 B1 19850410; JP S57501994 A 19821111; NO 153642 B 19860120; NO 153642 C 19860430; NO 822094 L 19820622

DOCDB simple family (application)

DE 8100180 W 19811026; DE 3040325 A 19801025; EP 81903112 A 19811026; JP 50354681 A 19811026; NO 822094 A 19820622