

Title (en)

Continuous cooling method for thick sheets during rolling, and apparatus for carrying it out.

Title (de)

Verfahren zum Durchlaufkühlen dicker Bleche während des Walzens und Einrichtung zur Durchführung des Verfahrens.

Title (fr)

Procédé de refroidissement d'ébauches de tôles fortes en défilement, en cours de laminage et machine pour sa mise en oeuvre.

Publication

**EP 0069618 A1 19830112 (FR)**

Application

**EP 82401102 A 19820617**

Priority

FR 8112133 A 19810619

Abstract (en)

1. A method for cooling blanks of thick metal sheets moving during rolling, in which there are selectively cooled certain zones of the blank by projection of a cooling fluid by means of ramps placed parallel to the surface of the blank and perpendicular to the direction of movement of the latter, characterized in that there is only cooled the central part of the surface of the blank, and not the peripheral portions, the projection of the cooling fluid being constituted by water sprayed by pressurised gas which is started for each ramp after the passage of the forward end of the blank and stopped prior to the passage of the rear end of the blank in its direction of movement, and with the useful length of the projection of each ramp being set to be less than the dimension of the blank in a direction perpendicular to the movement.

Abstract (fr)

La présente invention est relative à un procédé de refroidissement d'ébauches de tôles fortes en défilement, en cours de laminage, caractérisé en ce qu'il consiste à ne refroidir que la partie centrale de la surface de l'ébauche, à l'exclusion des parties périphériques. Ce procédé est mis en oeuvre à l'aide d'une machine comprenant des moyens (13) de support et de guidage de l'ébauche et des moyens de refroidissement occultables (14, 15) commandés en fonction du passage de l'ébauche de façon à ne refroidir l'ébauche que sur une partie centrale de sa surface, à l'exclusion des parties périphériques.

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**B21B 45/0233** (2013.01); **C21D 9/46** (2013.01); **C21D 9/573** (2013.01)

Citation (search report)

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