

Title (en)
METHOD OF CONTROLLING MILL PACING

Publication
EP 0159386 B1 19890329 (EN)

Application
EP 84104769 A 19840427

Priority
EP 84104769 A 19840427

Abstract (en)
[origin: EP0159386A1] According to the present invention, in a method of controlling a mill pacing in a rolling equipment wherein a plurality of serial rolling mills are provided downstream of a heating furnace in which a plurality of materials are rested on a furnace hearth integrally moving with the materials and can be successively extracted, respective rolling cycle times are sought from periods of time between the starts of rolling in respective rolling mills of a subsequent material to be extracted from the heating furnace and the readiness for rolling of the following material in the respective rolling mills, the maximum value of the above-described respective rolling cycle times is assumed as an extraction cycle time of the subsequent material to be extracted to thereby presuppose an extraction time of the subsequent material to be extracted from the heating furnace, allowable retard periods of time of the materials immediately before the respective rolling mills are predetermined, it is confirmed that the presupposed retard periods of time of the subsequent materials to be extracted immediately before the respective rolling mills are within the aforesaid allowable retard periods of time, and further, it is confirmed that a heating critical cycle time is secured which is sufficient for applying heat of a predetermined value to the subsequent material to be extracted through the latest material to be loaded, whereby the subsequent material is extracted at the aforesaid presupposed extraction time. In consequence, the operating condition of the rolling line as a whole are optimized, so that the productivity can be improved.

IPC 1-7
B21B 37/00

IPC 8 full level
B21B 37/78 (2006.01)

CPC (source: EP)
B21B 37/78 (2013.01)

Citation (examination)
JP S54127812 A 19791004 - SUMITOMO METAL IND

Cited by
CN112334242A

Designated contracting state (EPC)
DE FR

DOCDB simple family (publication)
EP 0159386 A1 19851030; EP 0159386 B1 19890329; DE 3477475 D1 19890503

DOCDB simple family (application)
EP 84104769 A 19840427; DE 3477475 T 19840427