

Title (en)

PROCESS FOR THE AUTOMATIC CONTROL OF THE STARTING OPERATION OF A CONTINUOUS METAL CASTING MACHINE

Publication

EP 0200981 A3 19881005 (DE)

Application

EP 86105504 A 19860421

Priority

LU 85878 A 19850507

Abstract (en)

[origin: US4774999A] At the latest before response of the measuring mechanism which senses the filling state of the melt tundish the opening rate of the outlet of the tundish is brought to near its standard opening rate and, after obtaining a clear signal from the filling state measuring mechanism or reaching a first predetermined filling height, the withdrawal mechanism is switched on and the withdrawal speed delayed for determination of the opening rate of the outlet. Advantageously the speed of the discharge rollers is measured by a tachometer which transmits a normalized signal which is then multiplied by a signal determined by the standard opening rate. The resultant signal controls the opening rate of the outlet. After the running stage of the withdrawal mechanism or after attaining a second predetermined filling height which is higher than the first filling height, only an I-governing branch of the control circuit controls the opening rate of the outlet and, after reaching a third predetermined filling height, which corresponds approximately with the standard desired filling height, control is transferred to an I-P regulation.

IPC 1-7

B22D 11/16; **B22D 11/20**

IPC 8 full level

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CPC (source: EP US)

B22D 11/161 (2013.01 - EP US); **B22D 11/181** (2013.01 - EP US); **B22D 11/206** (2013.01 - EP US)

Citation (search report)

- [XP] DE 3421344 A1 19851212 - KRUPP STAHL AG [DE]
- [E] GB 2172532 A 19860924 - METACON AG
- [A] LU 54473 A1 19671114
- [X] PATENT ABSTRACTS OF JAPAN, Band 7, Nr. 85 (M-206)[1230], 9. April 1983; & JP-A-58 009 757 (SHIN NIPPON SEITETSU K.K.) 20-01-1983
- [A] REGELUNGSTECHNISCHE PRAXIS UND PROZESS-RECHENTECHNIK, Band 14, Nr. 3, Juni 1972, Seiten 77-86, Verlag R. Oldenbourg, M{nchen, DE; W. BRJDERLE et al.: "Dynamische Probleme bei der Giessspiegelregelung einer Stranggiessanlage"

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