

Title (en)  
Method of producing sections

Title (de)  
Verfahren zur Herstellung von Formstahl

Title (fr)  
Procédé de fabrication de profils

Publication  
**EP 0256409 B2 19960918 (DE)**

Application  
**EP 87111183 A 19870803**

Priority  
DE 3627729 A 19860816

Abstract (en)  
[origin: US4791799A] The structural steel rolling mill comprises a reversing two high rough rolling mill, at least one universal working rolling mill and at least one flanging edging rolling mill included in a reversing tandem rolling mill group, and a universal finishing rolling mill at the outlet end of the structural steel rolling mill. The reversing tandem group following the rough rolling mill has a universal working rolling mill, a flanging edging rolling mill and the universal finishing rolling mill. By including the universal finishing rolling mill in the reversing tandem rolling mill group the universal finishing rolling mill also participates in the reversing action and because of that is more effective in shaping than the standard finishing rolling mill so that in practice the special universal finishing rolling mill following the reversing tandem group is omitted as well as the edging rolling mill commonly provided with it and the roller bed located between them. The dimensional accuracy and the surface properties of the rolled product as well as the service life of the rolls of the universal finishing rolling mill are not impaired when the reduction of the universal finishing rolling mill is set smaller than that of the universal working rolling mill.

IPC 1-7  
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