

Title (en)
METHOD FOR CONTROLLING THE THICKNESS OF TUBEWALL

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EP 0272204 A3 19881109 (DE)

Application
EP 87730165 A 19871215

Priority
DE 3643659 A 19861218

Abstract (en)
[origin: EP0272204A2] The method is used for controlling the tube wall thickness in a multi-stand continuous stretch-reducing mill having apparatus for measuring the tube wall thickness before forming and the run-in speed of the tube, a computer unit for processing the measured values and an apparatus for controlling the speed of the drive motors. In order to provide the possibility of evening out tube wall thicknesses which vary in short length portions of rolling stock, specifically in such a way that each cross-section of the rolling stock is formed with the maximum stretch or wall thickness reduction but not greater than that required for achieving a desired finished tube wall thickness, it is proposed that the ratios of the roll speeds are set continuously from roll stand to roll stand in accordance with a control law (e.g. wall thickness change to change in speed ratios) in dependence on the minimum value of the wall thickness values which are measured before forming and assigned to the portion of the rolling stock which is situated at the respective point in time in the region of the mill provided for influencing the wall thickness.

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CPC (source: EP)
B21B 17/14 (2013.01)

Citation (search report)
• [X] DE 2947233 A1 19810527 - KOCKS TECHNIK [DE]
• [Y] DE 1427922 B2 19730809
• [Y] US 3496745 A 19700224 - KOCKS FRIEDRICH
• [A] GB 1158754 A 19690716 - KOCKS WERMELSKIRCHEN GMBH [DE], et al

Designated contracting state (EPC)
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EP 0272204 A2 19880622; EP 0272204 A3 19881109; EP 0272204 B1 19920715; DE 3643659 A1 19880707; DE 3643659 C2 19900517;
DE 3780429 D1 19920820

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