

Title (en)  
METAL STRIP OR SHEET-ROLLING METHOD AND INSTALLATION

Publication  
**EP 0286533 B1 19920520 (FR)**

Application  
**EP 88400821 A 19880405**

Priority  
FR 8705031 A 19870409

Abstract (en)  
[origin: EP0286533A1] A method and installation for rolling a metal product (5) more especially in a "four-high" type of rolling mill, comprising two work rolls (1) and (2) interposed between two back-up rolls (3)(4), at least one of which is of the type with variable convexity, comprising a cylindrical casing (33) slipped over a central shaft (31), and means for adjusting the profile of the casing (33). <??>The rolling mill is equipped with a single back-up roll (3) with variable convexity, the other back-up roll (4) being a simple solid counter-roll which deforms freely through the action of the tightening force, forming a support line (47) which is concave towards the rolling space (50). Deformation of the casing (33) of the back-up roll (3) with variable convexity is controlled so as to form a support line (37) which is convex towards the rolling space (50) and substantially parallel to the support line (47) of the counter-roll (4) and the bulging of the work roll (1) is adjusted so as to keep the thickness of the rolling space constant over the entire width of the product (5), the latter having, at the exit of the rolling mill, a curved cross-sectional profile which is capable of being corrected subsequently by known means. <IMAGE>

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**B21B 29/00**; **B21B 37/00**

IPC 8 full level  
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Cited by  
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