

Title (en)

CALIBRATION FOR THE ROLLS OF ROLL STANDS WITH THREE OR MORE ROLLS

Publication

EP 0342403 A3 19900613 (DE)

Application

EP 89107593 A 19890427

Priority

DE 3816840 A 19880518

Abstract (en)

[origin: EP0342403A2] For rolling complete cross-sections, e.g. bar stock and wire, the rolls (16, 17) of roll stands, which have three or more rolls, are fitted with clover-leaf grooves (18) which have projections (18a) corresponding to the number of rolls and indentations situated between them. The boundary surfaces (19) of the projections extend symmetrically to the planes (B) of division of the rolls and extend at a distance from the groove centre (M) which is equal to or slightly larger than the circumferential surfaces (20a) of the inlet cross-section (20) or of the blooming pass. By a substantial decrease in height taking place with a corresponding increase in length due to the geometry of the clover-leaf groove in the region of its indentations, an increase in length takes place in the projections of the clover-leaf groove practically by drawing along the cross-sectional parts not being under direct pressure, i.e. in the region of the projections (18a) the groove can remain underfilled. As a result, a spread-free rolling is made possible in order to implement the advantages of the single-pass oblique rolling process in a multi-pass forming and profiling of rolled stock. The row of grooves can also comprise circular grooves. <IMAGE>

IPC 1-7

B21B 1/16

IPC 8 full level

B21B 1/16 (2006.01); **B21B 27/02** (2006.01)

CPC (source: EP)

B21B 1/16 (2013.01)

Citation (search report)

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- [AD] DE 2035482 A1 19720127
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EP0850701A1; US2017246669A1; US10766060B2; US6128939A; EP0368049A3; EP0865836A3; WO2017147430A1; WO03082659A1

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