

Title (en)  
Control of section rolling mill trains.

Title (de)  
Regelung für Profilstrassen.

Title (fr)  
Commande pour trains de laminoirs à profilés.

Publication  
**EP 0348777 B1 19940824 (DE)**

Application  
**EP 89111074 A 19890619**

Priority  
DE 3821990 A 19880630

Abstract (en)  
[origin: EP0348777A2] When rolling sections in universal stands of continuously operating section rolling mill trains, it has been found that changes in the speed ratios between the horizontal rolls and the vertical rolls lead to undesired material flow changes. As a result of the horizontal roll speed, the deformation in the section parts, the resulting transverse flow and the external forces at the roll gap, a certain speed is produced in the vertical rolls in proportion to the horizontal roll speed. Any change of the edge conditions of the rolling process leads to a change of the speed ratios between horizontal and vertical rolls. In order to eliminate these disadvantages, it is proposed to control the speed of the vertical rolls of the universal stands to influence optimally the horizontal roll speed and the vertical roll speed via a control device and to obtain a minimal pull between stands via a further control.

IPC 1-7  
**B21B 37/00**

IPC 8 full level  
**B21B 37/00** (2006.01); **B21B 37/46** (2006.01); **B21B 37/48** (2006.01); **B21B 37/52** (2006.01); **B21B 37/78** (2006.01); **B21B 1/08** (2006.01)

CPC (source: EP US)  
**B21B 37/46** (2013.01 - EP US); **B21B 37/52** (2013.01 - EP US); **B21B 1/088** (2013.01 - EP US)

Cited by  
EP0439663A1; DE4229323A1

Designated contracting state (EPC)  
AT DE ES FR GB IT LU SE

DOCDB simple family (publication)  
**EP 0348777 A2 19900103; EP 0348777 A3 19901227; EP 0348777 B1 19940824**; AT E110308 T1 19940915; DE 3821990 A1 19900111; DE 58908225 D1 19940929; JP 2628520 B2 19970709; JP H0246906 A 19900216; US 5085065 A 19920204

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