

Title (en)  
Multi-roll cluster rolling apparatus.

Title (de)  
Vielwalzengerüst.

Title (fr)  
Cage de laminoir à rouleaux multiples.

Publication  
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Application  
**EP 90110360 A 19900531**

Priority  

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- JP 14105989 A 19890605
- JP 14795889 A 19890609
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Abstract (en)  
A multi-roll cluster rolling apparatus has a pair of work rolls (2), and a plurality of first intermediate rolls (3), a plurality of second intermediate rolls (4) and a plurality of backup rolls (5) arranged successively in the mentioned order behind each the work roll. A roll crown presented by unidirectinally tapering one end of a roll is imparted to at least a pair of rolls. e.g., the work rolls, selected from a roll group consisting of the work rolls, first intermediate rolls and the second intermediate rolls. A roll crown approximated by at least one-pitch portion of a waveform is imparted to at least one other pair of rolls, e.g., pairs of the first intermediate rolls. A roll crown approximated by at least two-pitch portion of a waveform is imparted to at least one of the remainder pairs of rolls, e.g., selected pairs of the second intermediate rolls. The rolls of each pair having the same roll crown arranged in opposite axial directions and are axially shiftably (6) mounted on a mill housing.

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Citation (search report)  

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