

Title (en)  
METHOD OF AND DEVICE FOR ROLLING HOT ROLLED BAR AND WIRE

Publication  
**EP 0509204 A3 19921216 (DE)**

Application  
**EP 92102242 A 19920211**

Priority  
DE 4112931 A 19910418

Abstract (en)  
[origin: EP0509204A2] 2.1. Rolling is carried out up to a delivery cross-section of 900 mm<2> < A < 15,700 mm<2> on ungrooved rolls and before the transition to the sectional grooves, depending on material quality and the number of flat passes in one or two slightly indented grooves, a notched groove being predetermined by the ratio of emerging rolling-stock height (h1) to twice the turned-down depth (2t) of the roll, and this ratio lying within the range  $2 \leq h1/2t \leq 10$ . In this arrangement, a 4-roller mounting is arranged on the entry side in the 1st roll stand during flattening and a double mounting is arranged in the subsequent roll stands, whereas on the exit side a stripper is provided. 2.2. The problem on which the invention is based is to simplify the division of the rolls and mountings and, by defined dimensioning of the first sectional groove, to eliminate the influence of the sharp edges from the last flat pass on the wear, and also to limit the diagonal distortion of the rolling stock. 2.3. The invention is applicable to continuous groups of stands, reversing two-high mills and three-high mills.

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CPC (source: EP)  
**B21B 1/18** (2013.01); **B21B 39/165** (2013.01)

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