

Title (en)

Method of regulating a rolling mill with variable roll gap.

Title (de)

Verfahren zur Regelung eines Walzwerks mit betriebsmässig veränderlichem Walzspalt.

Title (fr)

Procédé pour le réglage d'un laminoir à calibre plat variable.

Publication

EP 0522184 B1 19931215 (DE)

Application

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Priority

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Abstract (en)

[origin: EP0522184A1] Method for regulating a rolling mill, in particular a multi-stand cold or hot rolling mill, in which rolls driven by electric motors and mounted in roll stands exert the rolling forces necessary during the rolling pass on the material by means of a roll gap, the size (setting) of which is subject to fluctuations in operation and in which a lever arm (a) obtained from the distance of the centre of gravity of the vertical projection of the material/roll contact surface from the line connecting the centres of the rolls is calculated, and in which the engine torque (M) applied and the rolling force (FW) applied are measuring during the rolling pass, the roll gap changes (A) during operation being continuously determined and, using constants determined and stored during the initial passes, continuous calculation of the current lever arm (a) is performed and this is used as the actual value for regulation. <IMAGE>

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CPC (source: EP)

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