

Title (en)  
Method for rolling of a strip

Title (de)  
Verfahren zum Walzen eines Walzbandes

Title (fr)  
Procédé pour laminier d'un feuillard

Publication  
**EP 0618020 B1 19970611 (DE)**

Application  
**EP 94104542 A 19940323**

Priority  
DE 4309986 A 19930329

Abstract (en)  
[origin: EP0618020A1] A method for rolling the strip (3;4) in a hot-strip mill (6) having at least two rolling stands (6,7) with horizontally adjustable upper and lower work rolls (10,11) each of which is supported directly or by way of an intermediate roll on a back-up roll (9), or in a reversing stand on which at least two passes are performed, in which the strip is subjected to state control, for which purpose profile-and flatness-determining final control elements act on the strip, makes it possible to meet the requirements relating to the profile accuracy and flatness of the strip despite flexible rolling programs if a target contour for the profile of the strip (3;4) is specified, for the achievement of which two groups of final control elements act successively on the strip, the final control elements (12,13) of the first group being brought into action when the thickness of the strip is above the critical thickness and primarily influencing the contour of the strip in its central area relative to the centre of the strip, while the final control elements (12,13) of the second group are brought into action when the thickness of the strip in the region of the edge is below the critical thickness. <IMAGE>

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**B21B 37/00**

IPC 8 full level  
**B21B 27/06** (2006.01); **B21B 31/18** (2006.01); **B21B 37/00** (2006.01); **B21B 37/28** (2006.01); **B21B 37/32** (2006.01); **B21B 37/38** (2006.01); **B21B 13/02** (2006.01); **B21B 28/04** (2006.01); **B21B 37/44** (2006.01); **B21B 45/00** (2006.01); **B21B 45/02** (2006.01)

CPC (source: EP KR US)  
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