

Title (en)

Method and apparatus for twin roll continuous casting.

Title (de)

Verfahren und Vorrichtung zum Stranggiessen mit Doppelrollen.

Title (fr)

Procédé et dispositif de coulée continue entre cylindres.

Publication

EP 0677345 A1 19951018 (FR)

Application

EP 95400446 A 19950302

Priority

FR 9403164 A 19940315

Abstract (en)

A method is claimed for the continuous casing of thin metal products between rolls, according to which the molten metal is cast in a casting space (3) defined by the cylindrical walls of two rolls (1,2) with parallel axes. These rolls are counter rotated and internally cooled. Two fixed lateral closing walls (4) are placed against the front end surfaces of the rolls. A lubricant is spread on these front surfaces (5) to lubricate the interfaces between the rolls and the walls and the solidified product is extracted in a direction (F) essentially perpendicular to a plane containing the axes of the rolls. A system (18, 19) is provided to measure one or more parameters representing the rubbing or sealing conditions of the roll-wall interfaces and the quantity of lubricant is regulated as a function of the values of these measured parameters in order to remove the lubricant and thus provoke a temporary more rapid erosion of the closing walls. The device used to put this method into service is also claimed. <IMAGE>

Abstract (fr)

Pour gérer l'usure des parois (4) d'obturation latérales, le dispositif comporte des moyens (8) pour déposer un lubrifiant sur les surfaces frontales (5) des cylindres (1, 2), des moyens (18, 19) de mesure d'un ou plusieurs paramètres représentatifs des conditions de frottement ou d'étanchéité à l'interface cylindre-paroi d'obturation, et des moyens de réglage de la quantité de lubrifiant amené au dit interface en fonction de la valeur de ce ou ces paramètres, tels que des racleurs (13) ou des brosses (14), pour enlever du lubrifiant déposé, et provoquer ainsi temporairement une érosion plus rapide des parois d'obturation. L'invention s'applique en particulier à la coulée continue entre deux cylindres de produits minces en acier. <IMAGE>

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B22D 11/06

IPC 8 full level

B22D 11/06 (2006.01)

CPC (source: EP)

B22D 11/0668 (2013.01)

Citation (search report)

- [A] FR 2642345 A1 19900803 - HITACHI SHIPBUILDING ENG CO [JP]
- [X] PATENT ABSTRACTS OF JAPAN vol. 18, no. 217 (M - 1594) 19 April 1994 (1994-04-19)
- [A] PATENT ABSTRACTS OF JAPAN vol. 13, no. 41 (M - 791) 30 January 1989 (1989-01-30)
- [A] PATENT ABSTRACTS OF JAPAN vol. 16, no. 299 (M - 1274) 2 July 1992 (1992-07-02)
- [A] PATENT ABSTRACTS OF JAPAN vol. 12, no. 229 (M - 714)<3076> 29 June 1988 (1988-06-29)

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DOCDB simple family (publication)

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