

Title (en)

Method for rolling hollow blocks in an Assel rolling mill

Title (de)

Verfahren zum Walzen von Hohlblöcken auf einem Asselwalzwerk

Title (fr)

Procédé pour laminier des blocs creux dans un laminoir de type Assel

Publication

EP 0703014 B1 19971210 (DE)

Application

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Priority

DE 4431410 A 19940824

Abstract (en)

[origin: DE4431410C1] The method is for the reduction of the OD and the wall thickness by rolling a cylindrical hollow block, which with its front part is inserted in a roller mechanism. In the run-in direction, in front of the roller mechanism a device is provided for reduction of the dia. and/or the wall thickness of the rear end part of the hollow block positioned on a mandrel bar. The pre-reduction roller reduces the hollow block end and is adjustable against the hollow block and can be guided away from it. The pre-reduction roller is adjusted slowly and continuously against the hollow block and with such a positioning speed that the axial path (LNEL) for the effect of the pre-reduction roller measured from the contact point of the roller on the hollow block surface as far as the hollow block end amounts to:- $LNEL = 0.8 \dots 2.0 \text{ DH}$ and $LNEL = 1.0 \dots 1.25 \text{ DH}$ whereby DH is the OD of the hollow block before entry into the roller mechanism.

IPC 1-7

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IPC 8 full level

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CPC (source: EP KR US)

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