

Title (en)

PROCESS AND DEVICE FOR ROLLING OUT THE ENDS OF A COILED STRIP IN A REVERSING MILL

Title (de)

VERFAHREN UND VORRICHTUNG ZUM AUSWALZEN DER ENDEN EINES AUFGEWICKELTEN BANDES IN EINEM REVERSIERWALZWERK

Title (fr)

PROCEDE DE DISPOSITIF POUR LE LAMINAGE DES EXTREMITES D'UNE BANDE ENROULEE DANS UN LAMINOIR REVERSIBLE

Publication

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Application

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Abstract (en)

[origin: WO9625251A1] The invention relates to a process and device for rolling out the ends of a coiled strip (B) in a reversing mill (1, 2) with coilers (3, 4) arranged on both sides. In order to reduce the un-run-out lost lengths at the strip ends with the least possible technical complication, at each reduction stage the start (A) of the strip is fed into the nip (S) of the rollers without front tension and rolling force and only then is the rolling force gradually increased to the rated force, and the rear tension is applied once the start (A) of the strip is attached to the coiler (4). At the end of every reduction stage the front tension is reduced to 0, so that the end (E) of the strip runs completely through the nip without tension and thus its thickness is reduced.

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