

Title (en)
Presetting for a cold mill reversing stand

Title (de)
Voreinstellung für Kaltwalzreversiergerüst

Title (fr)
Préréglage pour laminoir réversible à froid

Publication
EP 0811435 B1 20010905 (DE)

Application
EP 97108853 A 19970603

Priority
DE 19622825 A 19960607

Abstract (en)
[origin: EP0811435A2] The method concerns presetting of the control element positions in a reversing cold-rolling stand or section for the first pass of a strip from a new coil. Proceeding from strip planarity considerations, the control element positions are set according to the corresponding data of the first pass of a reference coil which is chosen from 'n' previously rolled strip coils and whose reference data best agrees with the target data of the new coil. The new positions of individual control elements include alterations depending on differences between the reference and target data. The control element positions in a reversing rolling stand, or in a rolling section after a stoppage, are based on the corresponding data referring to the situation immediately before the stoppage. They include alterations depending on differences between the reference and target data. Alteration of the control element positions is carried out on the basis of rolling gap model or a process parameter system. This includes consideration of certain influences of the planarity and rolling force data. The strip thickness is predetermined by specification of a rolling force or roll setting adapted to the reference data (which covers a certain time interval) concerning the rolling stand or section. This data includes the rolling force, gap setting, entry thickness, exit thickness and/or strip tension.

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Cited by
CN102688896A; DE19851554A1; DE19851554C2; US6691540B2; WO02064276A1

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