

Title (en)  
Method for rolling finished sections from preliminary sections

Title (de)  
Verfahren zum Walzen von Fertigprofilen aus einem Vorprofil

Title (fr)  
Procédé pour laminier des profilés finis à partir d'ébauches de profilés

Publication  
**EP 0818250 A3 19990120 (DE)**

Application  
**EP 97110607 A 19970628**

Priority  
DE 19628369 A 19960713

Abstract (en)  
[origin: EP0818250A2] A rolling process for finished sections, using a reversing mill train comprising a compact rolling group consisting of an ingoing universal stand (EUG), an outgoing second universal stand (AUG) and an intermediate upset stand (SZG), with a roughing group of two or more stands (VVG, VHG) parallel to the rolling line of the first group and a cross transfer (QE) between the two lines. At least one stand of the roughing group and/or the compact rolling group is equipped with selective roll grooves moved in and out of position by cross shift of the rolls or the stand or the rolling strand. The rectangular or preformed billet (VP) is rolled in the roughing stands (VVG, VHG) reversing in a number shaping and reducing passes using the selective roll grooves, followed by several reversing passes in the first universal stand (EUG) and intermediate upset stand (SZG) of the compact rolling group, again using selective roll grooves, and is finish rolled in the outgoing universal stand (AUG).

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**B21B 1/08; B21B 1/14**

IPC 8 full level  
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CPC (source: EP KR US)  
**B21B 1/085** (2013.01 - EP KR US); **B21B 1/10** (2013.01 - KR); **B21B 1/14** (2013.01 - EP KR US); **B21B 1/42** (2013.01 - KR)

Citation (search report)  
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