

Title (en)

Method for rolling rails from preliminary sections

Title (de)

Verfahren zum Walzen von Schienen aus einem Vorprofil

Title (fr)

Procédé pour laminier des rails à partir d'ébauches de profilés

Publication

**EP 0818250 B1 20020227 (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).

IPC 1-7

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

IPC 8 full level

**B21B 1/32** (2006.01); **B21B 1/08** (2006.01); **B21B 1/085** (2006.01); **B21B 1/14** (2006.01); **B21B 1/46** (2006.01); **B21B 13/08** (2006.01); **B21B 27/02** (2006.01)

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)

Cited by

CN108067501A; CN114042754A; EP0846503B1

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**EP 0818250 A2 19980114; EP 0818250 A3 19990120; EP 0818250 B1 20020227**; AT E213669 T1 20020315; CN 1082404 C 20020410; CN 1172701 A 19980211; DE 19628369 A1 19980115; DE 59706476 D1 20020404; ES 2173354 T3 20021016; JP 4402749 B2 20100120; JP H1058001 A 19980303; KR 100475693 B1 20050712; KR 980008368 A 19980430; US 5904061 A 19990518

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