

Title (en)  
Method for rolling thick plates

Title (de)  
Verfahren zum Walzen von Grobblechen

Title (fr)  
Procédé pour laminier des tôles fortes

Publication  
**EP 0839587 A1 19980506 (DE)**

Application  
**EP 97118206 A 19971021**

Priority  
DE 19645497 A 19961105

Abstract (en)  
The method concerns rolling of thick sheet metal from a preliminary material in several successive stages, with different numbers of passes (n) according to a particular desired end product, in one or several roll stands, but preferably in a single hot reversing stand. The method is characterised by the fact that from a pass (n-k) onwards to a pass (n-1), where k lies in the range from 1 to n-1, the pass reductions produced at the beginning of the strip are greater than those produced at the end of the strip.

Abstract (de)  
Beim Walzen von Grobblechen aus einem Vormaterial in mehreren hintereinander geschalteten Walzstichen ergeben sich bei relativ kleinen Enddicken - besonders in den letzten Stichen - große Walzkraftunterschiede zwischen Bandkopf und Bandende aufgrund der Abkühlung des Walzgutes, und der am Bandende dann kälteren Temperatur des Walzgutes. Um diesem Mangel abzuhelpfen, schlägt die Erfindung vor, ab einem bestimmten Walzstich am Bandkopf eine höhere Stichabnahme zu walzen als am Bandende. <IMAGE>

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IPC 8 full level  
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**EP 97118206 A 19971021**; AT 97118206 T 19971021; CA 2220412 A 19971103; DE 19645497 A 19961105; DE 59705654 T 19971021; ES 97118206 T 19971021; ID 973598 A 19971104; JP 30082097 A 19971031; KR 19970058117 A 19971105; MX 9708512 A 19971105; MY PI9705188 A 19971103; RU 97118327 A 19971104; TW 86115214 A 19971016; US 96370397 A 19971104