

Title (en)  
METHOD FOR PRODUCING METAL SHAPES WITH A POLYGONAL CROSS-SECTION BY MEANS OF CONTINUOUS CASTING ON A DOUBLE-FLANGED WHEEL AND CONTINUOUS ROLLING

Title (de)  
VERFAHREN ZUR HERSTELLUNG VON METALLISCHEN PROFILEN MIT POLYGONALEM QUERSCHNITT DURCH KONTINUIERLICHES GIESSEN MIT HILFE EINES RILLENGIESSRADES UND KONTINUIERLICHES WALZEN

Title (fr)  
PROCEDE DE FABRICATION DE PROFILS METALLIQUES DE SECTION POLYGONALE PAR COULEE CONTINUE SUR ROUE A GORGE ET LAMINAGE CONTINU

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Application  
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Abstract (en)  
[origin: US6584669B1] The invention relates to a method for producing metal shapes with a partially or totally polygonal cross-section by means of continuous casting in a double-flanged wheel and continuous rolling using a series of at least 3 pairs of rollers with a peripheral flange, whereby said rollers are alternately horizontally and vertically disposed in a symmetrical position with respect to said shape. The inventive method is characterised in that the flanges of the first pairs of rollers are identical to those used to produce shapes with a circular cross-section; the last pair of rollers has flanges defining a section that corresponds substantially to that of the desired shape; the section formed by the grooves of the last pair of rollers has curve radiuses of between 1 and 5 mm at the highest points of the polygon; the sides of the polygon that are not parallel to the air gap pertaining to the last pair of rollers have a clearance angle of  $\frac{1}{2}$ -3° in comparison with the corresponding of the section of the final shape. The invention can be used to produce copper or aluminum alloy shapes for drawing or and/or subsequent redrawing.

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