Title (en)

METHOD TO CONTROL THE AXIAL FORCES GENERATED BETWEEN THE ROLLING ROLLS

Title (de)

VERFAHREN ZUR REGELUNG DER ZWISCHEN DEN WALZWERKSWALZEN ERZEUGTEN AXIALKRÄFTE

Title (fr)

PROCEDE DE COMMANDE DES FORCES AXIALES PRODUITES ENTRE LES CYLINDRES DE LAMINAGE

Publication

EP 1322435 B1 20060607 (EN)

Application

EP 01970051 A 20010924

Priority

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• IT UD20000176 A 20000925

Abstract (en)

[origin: WO0224363A1] Method to control the axial forces generated between the rolls in a rolling stand (10) for plane products (12) having at least a pair of working rolls (11a, 11b), a corresponding pair of back-up rolls (13a, 13b) and at least an intermediate roll (15a) located between one of the working rolls (11a) and a corresponding back-up roll (13b), axial translation means (16) associated with the working rolls (11a) to translate them axially (WR shifting), crossing means (19) associated with the intermediate roll (15a) to arrange it with its longitudinal axis (25a) inclined (IR crossing), that is, rotated on a horizontal plane by a set angle (alpha) with respect to the longitudinal axes (21a, 21b, 23a, 23b) of the working rolls (11a, 11b) and of the back-up rolls (13a, 13b); according to this method the WR shifting and the IR crossing are controlled by control means (30) so as to reduce to a minimum the axial forces generated in the working rolls (11a, 11b), and consequently the axial load on the corresponding thrust bearings (28).

IPC 8 full level

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