

Title (en)
METHOD AND NOZZLE ARRANGEMENT FOR A VARIABLE-WIDTH LUBRICATION OF THE ROLLING NIP OF A ROLLING STAND

Title (de)
VERFAHREN UND DÜSENANORDNUNG ZUR BREITENVARIABLEN WALZSPALTSCHMIERUNG EINES WALZGERÜSTES

Title (fr)
PROCEDE ET DISPOSITIF DE TUYERES DESTINES A LA LUBRIFICATION VARIABLE EN LARGEUR DE L'EMPRISE D'UNE STRUCTURE DE LAMINAGE

Publication
EP 1399276 B1 20050209 (DE)

Application
EP 02747367 A 20020611

Priority
• DE 10130445 A 20010623
• EP 0206353 W 20020611

Abstract (en)
[origin: US7266984B2] The invention relates to a method for lubricating rolls, in particular for lubricating a rolling nip in rolling stands for rolled strips. According to the invention, said lubrication takes place using an oil-in-water dispersion whilst maintaining both a predetermined blend characteristic and a volumetric flow of the dispersion. The dispersion is prepared in the form of a homogeneous blend in a mixer (1) using adjustable quantities of water and oil. The dispersion is supplied to various spray zones (Zi) for a distribution (Bi) that is variable in width. Said method for roll lubrication can be improved by the allocation of at least one row of nozzles (Di) to each spray zone (Zi), which has a corresponding spray range width (Bi), each nozzle being controlled by at least one relay valve (Si).

IPC 1-7
B21B 27/10; **B21B 45/02**

IPC 8 full level
B21B 27/10 (2006.01); **B21B 45/02** (2006.01)

CPC (source: EP KR US)
B21B 27/10 (2013.01 - EP KR US); **B21B 45/0251** (2013.01 - EP US)

Cited by
CN102078884A; DE102009040876A1; DE102007042898A1; WO2013120750A1; US9566623B2

Designated contracting state (EPC)
AT BE CH CY DE DK ES FI FR GB GR IE IT LI LU MC NL PT SE TR

DOCDB simple family (publication)
US 2004232258 A1 20041125; **US 7266984 B2 20070911**; AT E288796 T1 20050215; AU 2002317793 B2 20070628; BR 0210554 A 20040622; BR 0210554 B1 20100810; CA 2451292 A1 20030103; CA 2451292 C 20091201; CN 1235694 C 20060111; CN 1518483 A 20040804; CZ 20033433 A3 20041215; CZ 298355 B6 20070905; DE 10130445 A1 20030102; DE 50202229 D1 20050317; EP 1399276 A1 20040324; EP 1399276 B1 20050209; ES 2236538 T3 20050716; JP 2004530562 A 20041007; JP 4311544 B2 20090812; KR 100849118 B1 20080730; KR 20040007746 A 20040124; MX PA03011764 A 20040701; RU 2004101766 A 20050610; RU 2287385 C2 20061120; UA 79432 C2 20070625; WO 03000437 A1 20030103; ZA 200309397 B 20040302

DOCDB simple family (application)
US 48192904 A 20040603; AT 02747367 T 20020611; AU 2002317793 A 20020611; BR 0210554 A 20020611; CA 2451292 A 20020611; CN 02812588 A 20020611; CZ 20033433 A 20020611; DE 10130445 A 20010623; DE 50202229 T 20020611; EP 0206353 W 20020611; EP 02747367 A 20020611; ES 02747367 T 20020611; JP 2003506669 A 20020611; KR 20037016730 A 20031222; MX PA03011764 A 20020611; RU 2004101766 A 20020611; UA 2004010501 A 20020611; ZA 200309397 A 20031203