

Title (en)
METHOD FOR AUTOMATICALLY ZEROIZING A UNIVERSAL EDGER STAND

Title (de)
VERFAHREN ZUR AUTOMATISCHEN NULLPUNKTFESTLEGUNG EINES UNIVERSALWALZWERKES

Title (fr)
PROCEDE DE MISE A ZERO AUTOMATIQUE D'UNE CAGE DE LAMINAGE UNIVERSELLE

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Application
EP 06777886 A 20060721

Priority
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• LU 91185 A 20050721

Abstract (en)
[origin: WO2007010033A1] A method for automatically zeroizing a universal edger stand for rolling an H-section product comprises: spacing apart the vertical rolls horizontally so as not to impede a vertical movement of the horizontal rolls; vertically adjusting the lower horizontal roll in a predefined zero position; achieving a first roll kissing by bringing the upper horizontal roll in contact with the lower horizontal roll and pressing it with rolling pressure against the latter; registering the positions of the lower horizontal roll and the upper horizontal roll during the first roll kissing as zero values for the horizontal rolls; spacing apart the lower horizontal roll and the upper horizontal roll symmetrically about the pass line of the stand so as to define a gap of a predetermined magnitude Y between the two horizontal rolls, wherein the predetermined magnitude Y is chosen so that the vertical rolls can contact the conical flanks of the horizontal rolls; achieving a second roll kissing by pressing the vertical rolls with rolling pressure against the conical flanks of the horizontal rolls; registering the positions of the vertical rolls during the second roll kissing as auxiliary zero values X0' for the vertical rolls; and computing real zero values X0 for the vertical rolls in function of the auxiliary vertical zero values X0', the predetermined magnitude Y and the angle between a generatrix of the cylindrical rolling surface and a generatrix of the conical rolling flanks of a horizontal roll.

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