

Title (en)

OPERATIONAL METHOD FOR A COILING ARRANGEMENT FOR COILING A STRIP AND CORRESPONDING OBJECTS

Title (de)

BETRIEBSVERFAHREN FÜR EINE HASPELANORDNUNG ZUM AUFHASPELN EINES BANDES UND HIERMIT KORRESPONDIERENDE GEGENSTÄNDE

Title (fr)

PROCEDE POUR FAIRE FONCTIONNER UN SYSTEME DE TREUIL DESTINE A ENTRAINER UNE COURROIE, ET OBJET CORRESPONDANT ENTRAINES GRACE A CELUI-CI

Publication

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Application

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Abstract (en)

[origin: WO2007045636A1] The invention relates to a coiling arrangement (1), for coiling a strip (3), comprising at least one coiler (4), a drive roller (5), arranged before the coiler (4) and a controller (6) for the coiler (4) and the drive roller (5). The drive roller (5) takes up the strip (3) at a roller take-up time (RFZP) and then supplies the same to the coiler (4). The strip (3) reaches the coiler (4) at a coiler arrival time (HEZP). The controller (6) provides the coiler (4) with a coiler set speed (nH\*) and a coiler torque limit (mH) acting in the strip running direction such that the controller (6) operates the coiler (4) with speed and torque control. The controller also provides the drive roller (5) with a roller set speed (nR\*) and roller torque limit (mR), acting in the strip running direction, such that the controller (6) also operates the drive roller (5) with speed and torque control. The controller (6) steadily increases the coiler torque limit (mH) after the coiler arrival time (HEZP) from a coiler initial torque (mH1), such that the coiler torque limit (mH) reaches a coiler final torque (mH2) at a coiler take-up time (HFZP). The roller torque limit (mR) is simultaneously steadily reduced from a roller initial torque (mR1) such that the roller torque limit (mR) reaches a roller final torque (mR2) at the coiler take-up time (HFZP).

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