

Title (en)
OPERATIONAL METHOD FOR A REVERSE ROLLING MILL

Title (de)
BETRIEBSVERFAHREN FÜR EIN REVERSIERWALZWERK

Title (fr)
PROCEDE POUR FAIRE FONCTIONNER UN LAMINOIR RÉVERSIBLE

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Application
EP 07726284 A 20070202

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Abstract (en)
[origin: WO2007104609A1] The invention relates to a reverse rolling mill comprising at least one reversing stand (1) for rolling a rolled material (5), two roller tables (2, 3) which are used for transporting the rolled material (5) and which are arranged on both sides of the reversing stand (1), and a control device (4) for controlling the reverse rolling mill. The roller tables (2,3) comprise several roller table areas (6) and each area comprises at least one conveyor roller (7). The conveyor rollers (7) of each roller table area (6) can be controlled independently from the conveyor rollers (7) of the other roller table areas (6). The rolled material (5) is conveyed in such a way that the front of the rolled material is displaced at an intake speed (vE) and the end of the rolled material is displaced at a delivery speed (vA). The control device (4) individually calculates an earliest intake time point (TE), in relation to the reversing stand (1), at least for each roller table area (6) located on the delivery side with respect to the respective conveyor step, at which the rolled material is taken into the respective roller table area (6) and controls the conveyor rollers of said area (7) in such a way that the peripheral speed is matched to the intake speed (vE), at the latest, at the intake time point (TE).

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