Title (en)

OPERATING METHOD FOR A MULTI-STAND ROLLING MILL TRAIN COMPRISING A STRIP THICKNESS DETECTION MEANS THAT UTILIZES THE CONTINUITY EQUATION

Title (de)

BETRIEBSVERFAHREN FÜR EINE MEHRGERÜSTIGE WALZSTRASSE MIT BANDDICKENERMITTLUNG ANHAND DER KONTINUITÄTSGLEICHUNG

Title (fr)

PROCÉDÉ D'EXPLOITATION POUR UN TRAIN DE LAMINAGE MULTI-CAGES AVEC DÉTERMINATION D'ÉPAISSEUR DE BANDE À L'AIDE D'UNE ÉQUATION DE CONTINUITÉ

Publication

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Application

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Priority

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Abstract (en)

[origin: WO2009106422A1] A strip (6) is fed to one of (2 - 5) the rolling stands (1 - 5) (rolling stand in question) of a multi-stand rolling mill with a known inlet thickness (d1 - d4) and exits the rolling stand in question (2 - 5) with a strip thickness (d2 - d5). Measurement parameters (vR, vW) are determined that are characteristic of the inlet-side velocity (v1 - v4) of the strip (6) and the outlet side velocity (v2 - v5) of the strip (6) with respect to the rolling stand in question (2 - 5). By means of the measurement parameters (vR, vW), the inlet-side velocity (v1 - v4) of the strip (6) and the outlet side velocity (v2 - v5) of the strip (6) are determined with respect to the rolling stand in question (2 - 5). By means of the inlet thickness (d1 - d4), the inlet-side velocity (v1 - v4) of the strip (6) and the outlet side velocity (v2 - v5) of the strip (6), the strip thickness (d2 - d5) is determined with respect to the rolling stand in question (2 - 5). Taking into account the determined strip thickness (d2 - d5), further measures are taken. The measurement parameter (vW) for the inlet-side velocity (v1 - v4) of the strip (6) is the roller peripheral velocity (vW) of the rolling stand (1 - 4) directly prior to the rolling stand in question (2 - 5). Alternatively or in addition, the measurement parameter (vW) for the outlet-side velocity (v2 - v5) of the strip (6) is the roller peripheral velocity (vW) rolling stand in question (2 - 5). The peripheral precession of the strip (6) in the respective rolling stand (2 - 5) is modeled. The respective velocity (v1 - v5) of the strip (6) is determined using the respective roller peripheral velocity (vR) and the peripheral precession of the strip (6) in the respective rolling stand (1 - 5).

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