

Title (en)

METHOD FOR CALIBRATING TWO INTERACTING WORKING ROLLERS IN A ROLLING STAND

Title (de)

VERFAHREN ZUM KALIBRIEREN ZWEIER ZUSAMMENWIRKENDER ARBEITSWALZEN IN EINEM WALZGERÜST

Title (fr)

PROCÉDÉ D'ÉTALONNAGE DE DEUX CYLINDRES DE TRAVAIL COOPÉRANT ENTRE EUX DANS UNE CAGE DE LAMINOIR

Publication

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Application

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Abstract (en)

[origin: WO2010069575A2] The invention relates to a method for calibrating a rolling stand (3), wherein in order to determine the relative pivot position of the roller set for setting a symmetrical roll gap and/or for determining the extension of the rolling stand (3) before the actual rolling process, the roller set is pressed against each other under a radial preset force and the resulting deformation of the rolling stand is preferably measured on the piston-cylinder unit (6, 7). The pivot position of the roller set and/or the frame module (M) determined based thereon are mathematically used during the subsequent rolling of a rolling stock between the working rollers (1, 2) for adjusting the roller set. In order to attain a higher accuracy during rolling, the invention provides for the working rollers (1, 2) to be axially adjustable relative to each other starting from a zero position that is not axially displaced, wherein the determination of the pivot position for setting a symmetrical roll gap and/or the determination of the frame module (M) are carried out in a relative displacement position of the working rollers (1, 2) that is not equal to the zero position (calibration position), wherein the determined pivot position and/or the value for the frame module (M) are stored and mathematically used for further calculating the pivot position and/or the adjustment of the roller set during rolling of the rolling stock.

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