

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

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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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