

Title (en)  
SIMPLE ADVANCE CONTROL OF A WEDGE POSITION OF AN ADVANCE FRAME

Title (de)  
EINFACHE VORSTEUERUNG EINER KEILANSTELLUNG EINES VORGERÜSTS

Title (fr)  
PRÉCOMMANDE SIMPLE DU PAS DE FILETAGE D'UN ÉBAUCHEUR

Publication  
**EP 3107666 B1 20180606 (DE)**

Application  
**EP 15702668 A 20150121**

Priority  
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• EP 2015051118 W 20150121

Abstract (en)  
[origin: WO2015124363A1] A number of flat metal items to be rolled (3) are fed to a number of rolling stands (1, 2) of a rolling installation one after the other over a feed path (4). The flat items to be rolled (3) are rolled by means of the number of rolling stands (1, 2). In the number of rolling stands (1, 2), the respective flat item to be rolled (3) is first rough-rolled in at least one roughing pass with a wedge-type roll gap adjustment (ds) and then finish-rolled in finishing passes. After the finish-rolling of the respective flat item to be rolled (3), a thickness taper (dd) that is present in the respective finish-rolled flat item to be rolled (3) is recorded by measuring instruments. The thickness taper (dd) is compared with a target taper (dZ). On the basis of a deviation of the thickness taper (dd) present in the respective finish-rolled flat item to be rolled (3) from the target taper (dZ) and the wedge-type roll gap adjustment (ds), a new wedge-type roll gap adjustment (ds) is determined for the at least one roughing pass. The wedge-type roll gap adjustment (ds) in the case of the at least one roughing pass for the flat item to be rolled (3) that is to be rolled next is set in a way corresponding to the newly determined value of the wedge-type roll gap adjustment (ds), so that the flat item to be rolled (3) that is to be rolled next is rough-rolled in the at least one roughing pass with the newly determined value of the wedge-type roll gap adjustment (ds).

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