

Title (en)
WIDTH ADJUSTMENT IN A FINISHING TRAIN

Title (de)
BREITENEINSTELLUNG BEI EINER FERTIGSTRASSE

Title (fr)
RÉGLAGE DE LARGEUR D'UNE LIGNE DE FABRICATION

Publication
EP 3194087 A1 20170726 (DE)

Application
EP 15756619 A 20150826

Priority
• EP 14185055 A 20140917
• EP 2015069501 W 20150826

Abstract (en)
[origin: WO2016041746A1] Before the rolling of a metal strip (1) on a finishing train (3), the actual width (b0) and actual temperature (T0) of portions (9) of the metal strip (1) are respectively detected. Variables (bF, TF) derived from the detected variables (b0, T0) and the corresponding setpoint variables (b*, T*) are assigned to the portions (9). The portions (9) of the metal strip (1) are tracked while they run through the finishing train (3). The rolling stands (5) are respectively assigned a width controlling device (13). The width controlling devices (13) determine from various input variables the setpoint width (b*) and the actual width (b) after the rolling in the assigned rolling stand (5b). The width controlling devices (13) also determine a downstream additional setpoint value ($\delta Z2^*$), by which the desired tension ($Z2^*$) downstream of the assigned rolling stand (5b) is corrected in order to bring the actual width (b) closer to the setpoint width (b*). The downstream additional setpoint value ($\delta Z2^*$) is both taken into account in the determination of the actual width (b) and fed to a tension controller (21), which sets an actual tension ($Z2$), prevailing in the metal strip (1) downstream of the assigned rolling stand (5b), in accordance with the corrected setpoint tension ($Z2^*$). Used inter alia for the determination of the downstream additional setpoint value ($\delta Z2^*$) is the difference (δb) between the setpoint width (b*) and the actual width (b) of a portion (9) of the metal strip (1) that is located at a predetermined point downstream of the assigned rolling stand (5b).

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