Title (en)

METHOD FOR ROLLING A PRODUCT TO BE ROLLED

Title (de)

VERFAHREN ZUM WALZEN EINES WALZGUTES

Title (fr)

PROCEDE DE LAMINAGE D'UN PRODUIT DE LAMINAGE

Publication

EP 3238843 A1 20171101 (DE)

Application

EP 16167662 A 20160429

Priority

EP 16167662 A 20160429

Abstract (en)

[origin: WO2017186910A1] The invention relates to a method for rolling a product to be rolled (3), wherein the product to be rolled (3) is fed through a rolling gap (11) between two working rollers (9, 10) of a roll stand (1) and a cooling lubricant is introduced into a contact zone (15, 16), in which a contact surface (17, 18) of the product to be rolled (3) lies against a working roller (9, 10), in order to lubricate the contact zone (15, 16). Furthermore, a lubrication demand of the contact zone (15, 16) is determined in accordance with at least one process parameter of the rolling process and an additional lubricant is applied to the contact surface (17, 18) of the product to be rolled (3) before the rolling gap (11) at a specified application distance (D) if a cooling lubricant amount (C) presently introduced into the contact zone (15, 16) does not cover the lubrication demand. The application distance (D) is sized in such a way that adhesion of the additional lubricant to the contact surface (17, 18) is increased and the lubricating effect in the contact zone (15, 16) is improved in comparison with application immediately before the rolling gap (11). In addition, the lubricant amount (C) introduced into the contact zone (15, 16) is reduced if additional lubricant is applied to the contact surface (17, 18).

Abstract (de)

Die Erfindung betrifft ein Verfahren zum Walzen eines Walzgutes (3), wobei das Walzgut (3) durch einen Walzspalt (11) zwischen zwei Arbeitswalzen (9, 10) eines Walzgerüstes (1) geführt wird und in eine Kontaktzone (15, 16), in der eine Kontaktoberfläche (17, 18) des Walzgutes (3) an einer Arbeitswalze (9, 10) anliegt, ein Kühlschmiermittel zur Schmierung der Kontaktzone (15, 16) eingebracht wird. Ferner wird ein Schmierungsbedarf der Kontaktzone (15, 16) in Abhängigkeit von wenigstens einem Prozessparameter des Walzprozesses bestimmt und vor dem Walzspalt (11) in einem vorgegebenen Aufbringabstand (D) wird ein Zusatzschmiermittel auf die Kontaktoberfläche (17, 18) des Walzgutes (3) aufgebracht, wenn eine momentan in die Kontaktzone (15, 16) eingebrachte Kühlschmiermittelmenge (C) den Schmierungsbedarf nicht deckt.

IPC 8 full level

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CPC (source: EP RU US)

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Citation (applicant)

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- WO 2013029886 A1 20130307 - SIEMENS VAI METALS TECH GMBH [AT], et al
- WO 0064605 A1 20001102 - SCHLOEMANN SIEMAG AG [DE], et al
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