

Title (en)
METHOD FOR ROLLING A ROLLING MATERIAL AND ROLLING MILL

Title (de)
VERFAHREN ZUM WALZEN EINES WALZGUTS UND WALZWERK

Title (fr)
PROCÉDÉ POUR LAMINER UNE MATIÈRE À LAMINER ET LAMINOIR

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Abstract (en)
[origin: WO2017064017A1] The invention relates to a method for rolling a rolling material (3) in a rolling mill (1) comprising at least one roll stand, wherein a gap height of a rolling gap arranged between working rolls (2) of the roll stand is set to be smaller than an in-feed thickness (h1) of the rolling material (3) before contact of the rolling material (3) with said working rolls (2), wherein at least one driven working roll (2) of the roll stand is driven at a desired rotational speed (v0) once the rolling material (3) has reached the rolling gap, and wherein the driven working roll (2) is operated at a feed-forward rotational speed (vV) deviating from the desired rotational speed (v0), until the rolling material (3) reaches the rolling gap. In order to reduce as much as possible the change in the tension in the rolling material (3) during entry of a leading edge of the rolling material (3) into the roll stand, the invention proposes that the feed-forward rotational speed (vV) is varied after contact of the rolling material (3) with the driven working roll (2) in such a way that the feed-forward rotational speed (vV) increases or decreases monotonically.

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Opponent : Primetals Technologies Germany GmbH,

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