

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 3448592 A1 20190306 (DE)

Application
EP 17723941 A 20170428

Priority
• EP 16167662 A 20160429
• EP 2017060193 W 20170428

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).

IPC 8 full level
B21B 37/44 (2006.01); **B21B 45/02** (2006.01)

CPC (source: EP RU US)
B21B 27/10 (2013.01 - EP US); **B21B 37/32** (2013.01 - EP US); **B21B 37/44** (2013.01 - EP US); **B21B 45/02** (2013.01 - RU); **B21B 45/0251** (2013.01 - EP US)

Citation (search report)
See references of WO 2017186910A1

Designated contracting state (EPC)
AL AT BE BG CH CY CZ DE DK EE ES FI FR GB GR HR HU IE IS IT LI LT LU LV MC MK MT NL NO PL PT RO RS SE SI SK SM TR

Designated extension state (EPC)
BA ME

DOCDB simple family (publication)
EP 3238843 A1 20171101; CN 109070162 A 20181221; CN 109070162 B 20201208; EP 3448592 A1 20190306; EP 3448592 B1 20200122; JP 2019514693 A 20190606; JP 6820349 B2 20210127; MX 2018012916 A 20190522; RU 2701916 C1 20191002; US 11161161 B2 20211102; US 2019151919 A1 20190523; WO 2017186910 A1 20171102

DOCDB simple family (application)
EP 16167662 A 20160429; CN 201780026643 A 20170428; EP 17723941 A 20170428; EP 2017060193 W 20170428; JP 2018556441 A 20170428; MX 2018012916 A 20170428; RU 2018133704 A 20170428; US 201716094911 A 20170428