

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 B1 20200122 (DE)**

Application  
**EP 17723941 A 20170428**

Priority  
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• 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).

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Opponent : SMS group GmbH  
• JP 2001321809 A 20011120 - NIPPON KOKAN KK  
• JP H01218710 A 19890831 - NIPPON STEEL CORP  
• JP 2000280002 A 20001010 - KAWASAKI STEEL CO  
• JP 2006263800 A 20061005 - JFE STEEL KK  
• WO 2007025682 A1 20070308 - SMS DEMAG AG [DE], et al  
• DE 60030288 T2 20071031 - JFE STEEL CORP [JP]  
• WO 2005120739 A1 20051222 - SMS DEMAG AG [DE], et al

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