

Title (en)

AVOIDANCE OF WEARING EDGES WHEN ROLLING FLAT ROLLED PRODUCTS

Title (de)

VERMEIDUNG VON VERSCHLEISSKANTEN BEIM WALZEN VON FLACHEM WALZGUT

Title (fr)

PRÉVENTION DES BORDS D'USURE LORS DU LAMINAGE D'UN PRODUIT PLAT À LAMINER

Publication

EP 3536411 B1 20201118 (DE)

Application

EP 18160879 A 20180309

Priority

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Abstract (en)

[origin: WO2019170381A1] The invention relates to a roll stand (1) having at least one pair of rollers (4, 5) between which the flat rolled product (2) is located. The rollers (4, 5) can be moved axially in opposite directions. The roll stand (1) additionally has a bending system (6) for the rollers (4, 5). A controller (8) of the roll stand (1) uses the bending and the axial movement of the rollers (4, 5) in order to regulate the roll gap contour as an adjustment mechanism. Prior to rolling a respective rolled product (2), the controller determines a respective axial position (x) as the resulting axial position (x) and sets the axial position as the axial position (x) of the rollers (4, 5) for the roll stand (1) in order to roll the next flat rolled product (2). For this purpose, the controller (8) ascertains how far a specified target roll gap contour can be approximated for a plurality of axial positions (x) of the rollers (4, 5) by actuating the adjustment mechanism (6, 7) while taking into consideration technological boundary conditions and classifies the axial positions (x) at which a deviation of the resulting roll gap contour from the target roll gap contour lies below a specified limit as being permissible. The controller then removes the axial positions (x) excluded from the plurality of axial positions (x) classified as being permissible as long as at least one axial position (x) classified as being permissible still remains after the excluded axial positions (x) are removed. The controller (8) determines one of the remaining axial positions (x) as the resulting axial position (x).

IPC 8 full level

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Cited by

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