

Title (en)
METHOD FOR DYNAMIC ROLLING GAP CONTROL DURING FLEXIBLE ROLLING OF METAL STRIPS

Title (de)
VERFAHREN ZUR DYNAMISCHEN WALZSPALTREGELUNG BEIM FLEXIBLEN WALZEN VON METALLBÄNDERN

Title (fr)
PROCÉDÉ DE RÉGLAGE DYNAMIQUE D'ÉCARTEMENT ENTRE CYLINDRES LORS DU LAMINAGE FLEXIBLE DE BANDES MÉTALLIQUES

Publication
EP 3566790 B1 20210106 (DE)

Application
EP 18171365 A 20180508

Priority
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Abstract (en)
[origin: WO2019215045A1] The invention relates to a method for dynamic nip control during flexible rolling of metallic strip material, having the following steps: specifying (V10) a target thickness profile (1) having defined target corner points (E) and profile sections (2', 2'', 3', 3'') therebetween, each pair of profile sections which adjoin at a target corner point having different average gradients; flexibly rolling (V40) the strip material (11) according to the target thickness profile (1); measuring (V50) an actual thickness profile (14) of the flexibly rolled strip material (11'); determining (V60) actual corner points (E') corresponding to the target corner points (E) and actual intermediate points (S') corresponding to the target intermediate points (S); determining (V70) corner point comparative values (ΔD , ΔL) from the target corner points (E) and the corresponding actual corner points (E') and intermediate point comparative values ($\Delta D'$, $\Delta L'$) from the target intermediate points (S) and the corresponding actual intermediate points (S'); controlling (V80) a nip (12) in accordance with the corner point comparative values (ΔD , ΔL) and the intermediate point comparative values ($\Delta D'$, $\Delta L'$).

IPC 8 full level
B21B 37/26 (2006.01)

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Citation (opposition)
Opponent : Herr Tito von Westemhagen

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