

Title (en)
METHOD FOR OPERATING A ROLL STAND FOR STEPPED ROLLING

Title (de)
VERFAHREN ZUM BETREIBEN EINES WALZGERÜSTES ZUM STUFENWALZEN

Title (fr)
PROCÉDÉ SERVANT À FAIRE FONCTIONNER UNE CAGE DE LAMINOIR DE LAMINAGE À GRADINS

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Application
EP 19816591 A 20191202

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Abstract (en)
[origin: WO2020114976A1] The invention relates to a method for operating a roll stand for stepped rolling of a metal strip (200). According to the method the metal strip (200) is firstly introduced on the infeed side into a roll stand (100) and there undergoes stepped rolling. An upstream and a downstream portion (220, 210) of the metal strip are thus created and have a different thickness from one another. The difference in thickness is Δh . After the roll stand, the stepped-rolled metal strip passes firstly through an outfeed-side strip store before it is wound into a coil with the aid of a winding reel. The outfeed-side reel is regulated to a constant strip tension. In order to be able to keep the outfeed-side strip tension sufficiently constant even in the event of rapid changes to the size of the rolling gap and resultant rapid changes in thickness in the rolled metal strip, according to the invention, the regulation of the strip tension with the aid of the winding reel is complemented by position regulation for a roller unit in the outfeed-side strip store.

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