

Title (en)  
METHOD FOR CALIBRATING VERTICAL ROLLS OF A VERTICAL ROLL STAND, AND CALIBRATING ASSEMBLY FOR CARRYING OUT THE METHOD

Title (de)  
VERFAHREN ZUR KALIBRIERUNG VON VERTIKALROLLEN EINES VERTIKALWALZGERÜSTS SOWIE KALIBRIERANORDNUNG ZUR DURCHFÜHRUNG DES VERFAHRENS

Title (fr)  
PROCÉDÉ D'ÉTALONNAGE DE ROULEAUX VERTICAUX D'UNE CAGE DE LAMINOIR VERTICAL ET ENSEMBLE D'ÉTALONNAGE POUR LA MISE EN OEUVRE DU PROCÉDÉ

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Abstract (en)  
[origin: WO2021156424A1] The invention relates to a method for automatically calibrating vertical rollers (7) of a vertical roller frame (1), each of which rollers are mounted in a vertical roller unit (3) which is adjustable in relation to a specified center line (2) of a plurality of components arranged in a roller train. The method comprises the method steps of: a) adjusting the vertical roller units (3) to a calibration position crosswise to the center line (2) against at least one stationary stop of the vertical roller frame (1), which has a specific known position in relation to the center line (2), b) calculating a calibrated starting distance  $A_{kal}$  between an outside edge (13) of a vertical roller, which outside edge points toward a rolled material or to the center line (2), and the center line (2) in the calibration position, and c) engaging the vertical roller units (3) in a defined operating position. The invention further relates to a calibration arrangement on a vertical roller frame (1) for carrying out the method.

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