

Title (en)
METHOD FOR CONTROLLING AN AXIAL RADIAL ROLLING MILL FOR RINGS WITH VARIABLE COEFFICIENT CONTROLLERS AND AXIAL RADIAL ROLLING MILL FOR RINGS

Title (de)
VERFAHREN ZUR STEUERUNG EINES AXIAL-RADIAL-RINGWALZWERKS MIT VARIABLEN KOEFFIZIENTENREGLERN UND AXIAL-RADIAL-RINGWALZWERK

Title (fr)
PROCÉDÉ DE COMMANDE D'UN LAMINOIR CIRCULAIRE AXIAL RADIAL À L'AIDE DE RÉGULATEURS À COEFFICIENT VARIABLE ET LAMINOIR CIRCULAIRE AXIAL RADIAL

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Abstract (en)
A method for controlling an axial radial rolling mill (100) for rings (200), wherein the axial radial rolling mill (100) comprises: a main roller (105), a contrast roller (110), a pair of guide rollers (115), and a pair of tapered rollers (130, 135); wherein the control method provides for adjusting the rotational speed of each tapered roller (130, 135) by means of the steps of: establishing a reference value (v) of the rotational speed of the tapered roller (130, 135), applying a correction (d1, d2) to said reference value (v) to obtain a corrected value (v*, v**) of the rotational speed of the tapered roller (130, 135), actuating the tapered roller (130, 135) at a rotational speed having the corrected value (v*, v**); the correction (d1, d2) comprising at least one feedback contribution (r1, r2) provided by a controller (S120, S150) of the proportional-integrative or proportional-integrative-derivative type; the control method providing for varying at least the coefficients of the proportional part and of the integrative part of the controller (S120, S150) on the basis of the value of at least one physical parameter of the ring (200) being processed. The invention also relates to an axial radial rolling mill for rings.

IPC 8 full level
B21H 1/06 (2006.01)

CPC (source: EP)
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Citation (search report)

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