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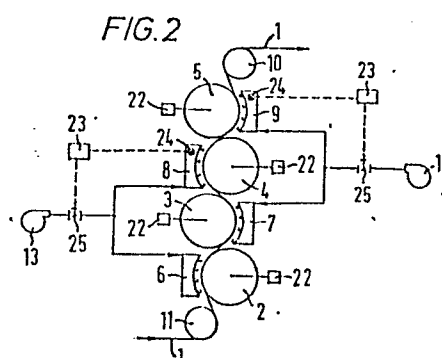
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54 Method of controlling the temperature of steel strip in the cooling zone of a continuous annealing furnace.

57 The invention relates to a method of controlling the temperature of a steel strip (1) in the cooling zone of a continuous annealing furnace which is provided with a plurality of cooling rolls (2 to 5) in which a coolant is circulated via a circuit (14 to 18) for cooling the strip as it is brought into contact with the outer peripheral surfaces of the rolls, the coolant temperature being controlled via temperature control means (19 to 21), and a plurality of gas jet coolers (6 to 9) for blowing cooling gas against the strip.

In accordance with the invention, the flow rate of the cooling gas, the angle at which the strip is brought into contact with the surfaces of the rolls and the coolant temperature are controlled selectively in the order of, first, at least one of either the flow rate of coolant, or the angle, and then the coolant temperature, so that the strip may be cooled quickly and efficiently to a predetermined temperature irrespective of

any change in strip gauge during the continuous annealing of a plurality of strips which are different gauge.





DOCUMENTS CONSIDERED TO BE RELEVANT			
Category	Citation of document with indication, where appropriate, of relevant passages	Relevant to claim	CLASSIFICATION OF THE APPLICATION (Int. Cl.4)
A	EP-A-0 058 607 (STEIN HEURTEY) * Claims 1,4; figure *	1,2,4	C 21 D 9/573 C 21 D 11/00
A	--- GB-A-2 054 661 (NIPPON KOKAN) * Claims 1,3,6 *	1,3	
A	--- PATENTS ABSTRACTS OF JAPAN, vol.3, no.138 (C-64); November 16, 1979, page 130; & JP-A- 54 118 315 (NIPPON KOKAN K.K.) 09.13.1979	1	
A	--- PATENTS ABSTRACTS OF JAPAN, vol.6, no.94, (C-105)[972], June 2, 1982, & JP-A- 57 026 127 (SHIN NIPPON SEITETSU K.K.) 12.02.1982	1,6	
A,D	--- JAPANESE PATENTS REPORT, Section Ch, vol.81, no.11, April 10 , 1981, Metallurgy, page 6; Derwent, London, GB; & JP-B- 56 10 973 (MITSUBISHI ELECTRIC CORP.) 11.03.1981 -----		TECHNICAL FIELDS SEARCHED (Int. Cl.4) C 21 D
The present search report has been drawn up for all claims			
Place of search THE HAGUE		Date of completion of the search 03-09-1986	Examiner MOLLET G.H.J.
CATEGORY OF CITED DOCUMENTS			
X : particularly relevant if taken alone Y : particularly relevant if combined with another document of the same category A : technological background O : non-written disclosure P : intermediate document		T : theory or principle underlying the invention E : earlier patent document, but published on, or after the filing date D : document cited in the application L : document cited for other reasons & : member of the same patent family, corresponding document	