(19) Europäisches Patentamt
European Patent Office
Office européen des brevets

(11) Publication number: **0 397 993 A3**

(12) EUROPEAN PATENT APPLICATION

(21) Application number: **90105460.1**

(51) Int. Cl.5: **B21B 28/04**, B24B 5/36

(22) Date of filing: **22.03.90**

(30) Priority: **19.05.89 JP 126017/89**

(43) Date of publication of application:
22.11.90 Bulletin 90/47

(84) Designated Contracting States:
DE FR GB

(88) Date of deferred publication of the search report:
13.01.93 Bulletin 93/02

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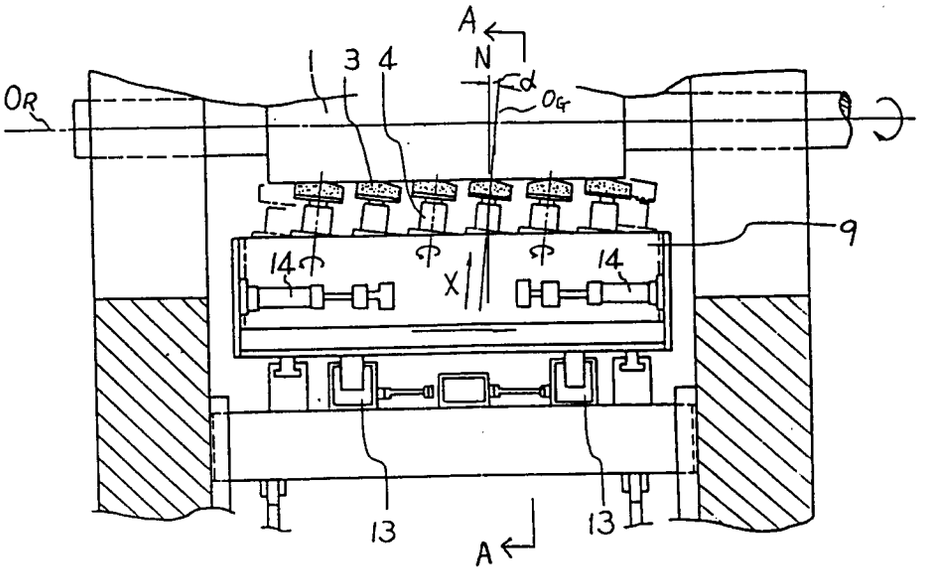
(54) Method for grinding roll.

(57) The known on-line roll grinding method is improved so as to avoid clogging of grinder, breaking of a grinder corner portion, complication of a grinder construction and buzzing vibration of a grinder. A plurality of grinder holders adapted to press grinders mounted to their tip end portions against a roll surface, are arrayed along the axial direction of the roll within a frame which can reciprocate along the roll axis. The grinders are mounted within the holders with their rotary axes inclined in the axial direction of the roll with respect to normal lines of the roll surface. The rotary axes of the grinders are displaced by a given offset amount H with respect to the rotary axis of the roll. The improvements reside in that an inner diameter d_G and an outer diameter D_G of the grinder and the offset amount H are chosen so as to fulfil the following formulae:
$0.1 \leqq H/D_G \leqq 0.4$, and
$0.1 \leqq d_G/D_G$.

EP 0 397 993 A3

Fig. 1



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EUROPEAN SEARCH REPORT

Application Number

EP 90 10 5460

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.5)
X	PATENT ABSTRACTS OF JAPAN vol. 11, no. 102 (M-576)(2549) 31 March 1987 & JP-A-61 249 609 (MITSUBISHI HEAVY IND LTD) 6 November 1986 * abstract *	1	B21B28/04 B24B5/36
P,A	EP-A-0 344 610 (NORITAKE CO., LTD & MITSUBISHI JUKOGYO K.K.) * page 7, line 44 - page 8, line 3 * * page 6, line 56 - line 58 * * page 11, line 55 - page 12, line 25 * * figures 1,5-7,14 *	1	
A	US-A-4 716 687 (TSUKAMOTO ET AL) * claim 1; figures *	1	

TECHNICAL FIELDS SEARCHED (Int. Cl.5)

B21B
B24B

The present search report has been drawn up for all claims

Place of search	Date of completion of the search	Examiner
THE HAGUE	06 NOVEMBER 1992	PLASTIRAS D.

CATEGORY OF CITED DOCUMENTS

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