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KAWASAKI STEEL GIHO

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High Productive and High Accuracy Cold Rolling Technologies in 12 -Hi Cluster Mill of
 Stainless Steel Strips

Í5 W •(Masashi Hoshino) 9 5 (ç M(jun-ichi Tateno) Ý1Â D / (Toshihoro
 Fukaya)

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Synopsis :

A 12-high cluster mill (SCM : stainless cold mill) at Chiba Works has been used for the cold rolling of high brightness stainless steel strips since March 1991. To produce higher quality strips with higher productivity, two new technologies were developed and applied to the mill. One is an automatic gauge control system and it improves accuracy of thickness in the accelerating and decelerating stages, while maintaining the accuracy during the constant stage of the rolling process. The other technology is the development of an automatic set-up system to control strip flatness. A mathematical model for the set-up of optimal positioning of flatness actuators makes good strip flatness possible and allows an immediate increase in rolling speed after the start of rolling.

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12段クラスターミルにおける非定常部板厚・形状制御によるステンレス鋼板の高能率圧延技術*

High Productive and High Accuracy Cold Rolling Technologies

12-Stage Cluster Mill Cold Rolling Technology



要旨

千葉製鉄所の12段クラスター型冷間圧延機SCM(stainless cold mill)は、1991年3月に稼動してから、ステンレス光沢材を圧延している。本ミルでは高精度の板厚および形状制御技術を開発し、高

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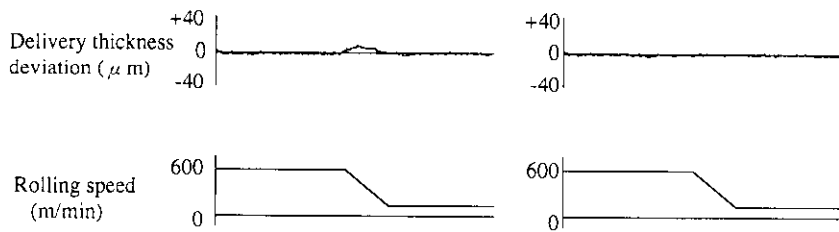
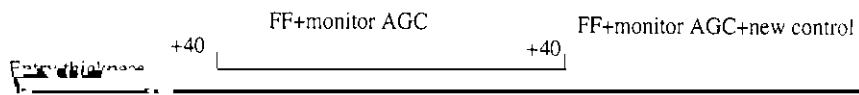


Fig. 5. System configuration of

