KAWASAKI STEEL TECHNICAL REPORT No. 25 September 1991

Development of Rolling Techniques to Control Outer Dimensions of H-Shapes*

Synopsis:

The conventional universal rolling of H-shapes results in fixed inner dimensions that are governed by the roll sizes

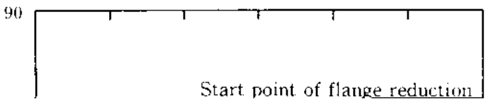
2 Controlling the Web Depth

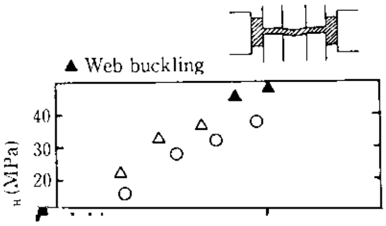
1.0

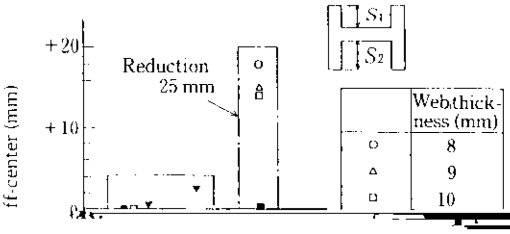
[illegible]

Table 2 Experimental conditions for universal rolling

Material	Pure lead (99.99%)




▲ Web buckling
H (MPa)
40
30
20


S1
S2
+20
+10
0
ff-center (mm)
Reduction 25 mm
Web thickness (mm)
○ 8
△ 9
□ 10

H 500 × 200 × 12 × 25

upper and lower flange lengths.[6] However, because the groove depth of the edger rolls is fixed during rolling

Table 3. Experimental conditions for grooveless [illegible]

sults that VG was not necessary and that the HG plus

The equipment specifications were determined from the results of the model experiments, and the new control techniques were applied to a production process. In the newly developed equipment, the distance between the universal rough rolling mill and the edger mill was

Table 4 Effect of reducing the number of guide facili-

	Conventional	New
Kind of shape	23	1
Number of rolls	30 set	1 set