

KAWASAKI STEEL TECHNICAL REPORT

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**Highly Efficient Production and
Application of sheet Products, and
Application Development in Open System's Age**

Outline of Newly Built Chiba No. 3 Hot Strip Mill

Yasuo Ogawa, Takehisa Nakamura, Nariharu Kitao

Synopsis :

Kawasaki Steel has finished the construction of No. 3 Hot Strip Mill in Chiba Works and started up its operation in May 1995. Features of this mill are: (1) World's first fully continuous finisher rolling (endless hot-strip rolling) mill; (2) high accuracy and high quality rolling based on (a) paircross mills with excellent control by inter-stand measurement of strip gauge and crown, and (b) full-line temperature control using high accuracy slab heating and strip cooling equipment.

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The body can be viewed from the next page.

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2 Outline and Effects of Endless Rolling

In conventional hot rolling, slabs are individually rolled by a roughing mill to sheet bars 30 to 60 mm in

Furthermore, the problem of pinchers tends to occur when the gauge of the strip is thin and the rigidity of the strip decreases. Incidentally, pincher marks occur in connection with side walk during the tailing out at the finishing mill.

Table 1 Main equipment specifications

the succeeding sheet bar without delay. This is espe-

Furnace combustion control
Accurate reheating temperature control

Mill reheating control

quality. Skid marks are prevented by using a special
alloy material for the skid buttons and increasing the

(2) The water injection sections were subdivided. (They
were subdivided so that changes in the ceiling tem

F1

F2

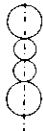
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F5

F6

F7



Roll transporter