

KAWASAKI STEEL TECHNICAL REPORT

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Automotive Materials and Instrumentation  
and Process Control

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Advanced Process Control Technologies for Realization of Endless Hot Strip Rolling

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Synopsis :

Kawasaki Steel was the first in the world to start the so-called "endless hot strip

rolling" at the No. 3 Hot Strip( ")5 .6 (nM(r)3.8(l)11.2l (i)11.2n C)9i aorkninh (o)3 (t)6.8)TJ0 TJ-0281 T

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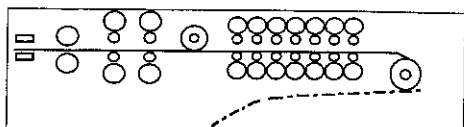
# Advanced Process Control Technologies for Realization of Endless Hot Strip Rolling\*



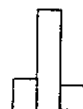
*Synopsis:*

*Kawasaki Steel was the first in the world to start the so-called "endless hot strip rolling" at the No. 3 Hot Strip Mill in Chiba Works by realizing hot sheet bar*





30  
20  
10



$n^{\circ} = 119$   
 $\bar{X}^{\circ} = 0.73 \text{ s}$   
 $\sigma = 1.67 \text{ s}$

Sheet bar roller

Leveler

Crop shear

Bar joining car

ft

Process computer

Set up control

Joint

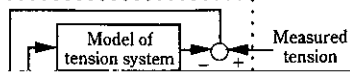
Joint

Joint

Joint

Joint

Internal model control



Finishing mill

No. 0

Strip shear No. 1

No. 2

14. A cycle time of 40 s has been achieved for changing