

FUNDAMENTALS OF SHEET SHAPE

A solution to this problem is presented by the six high mill. In this case, a set of intermediate rolls is inserted between the work rolls and the backup rolls. These rolls are placed asymmetrically in the mill so that the edge of the intermediate roll is close to the strip edge. By adjusting the side shift on these rolls, the fulcrum points for roll bending and roll deflection are changed and it is reported that buckles may not only be changed but eliminated. The adjusting the intermediate rolls on a six high mill is an adjustment of mechanical crown.

A simple roll coolant system is then used to satisfy the lubrication and cooling requirements. Recently, the concept has been further developed with intermediate rolls taking on "coke" bottle shapes. Originally, these mills were designed to be without shape control, as it was thought that the mechanical crown adjustments would suffice, however, modern quality and productivity requirements have meant that successfully operated mills do possess sophisticated shape control systems.

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