Effect of Rolling Parameters on Thin Strip Profile in Cold Rolling

Authors : H. B. Tibar, Z. Y. Jiang

Abstract : In this study, the influence of rolling process parameters such as the work roll cross angle and work roll shifting value on the strip shape and profile of aluminum have been investigated under dry conditions at a speed ratio of 1.3 using Hille 100 experimental mill. The strip profile was found to improve significantly with increase in work roll cross angle from $0 < \sup > o < /\sup > to 1 < \sup > o < /\sup > to 1 < \sup > o < /\sup > to 1 < up > o < /up > to 1 < up > o < /up > to 1 < up > o < /up > to 1 < up > o < /up > to 1 < up > o < /up > to 1 < up > o < /up > to 1 < up > o < /up > to 1 < up > o < /up > to 1 < up > o < /up > to 1 < up > o < /up > to 1 < up > o < /up > to 1 < up > o < /up > to 1 < up > o < /up > to 1 < up > o < /up > to 1 < up > o < /up > to 1 < up > o < /up > to 1 < up > o < /up > to 1 < up > o < /up > to 1 < up > o < /up > to 1 < up > o < /up > to 1 < up > o < /up > to 1 < up > o < /up > to 1 < up > o < /up > to 1 < up > o < /up > to 1 < up > o < /up > to 1 < up > o < /up > to 1 < up > o < /up > to 1 < up > o < /up > to 1 < up > o < /up > to 1 < up > o < /up > to 1 < up > o < /up > to 1 < up > o < /up > to 1 < up > o < /up > to 1 < up > o < /up > to 1 < up > o < /up > to 1 < up > o < /up > to 1 < up > o < /up > to 1 < up > o < /up > to 1 < up > o < /up > to 1 < up > o < /up > to 1 < up > o < /up > to 1 < up > o < /up > to 1 < up > o < /up > to 1 < up > o < /up > to 1 < up > o < /up > to 1 < up > o < /up > to 1 < up > o < /up > to 1 < up > o < /up > to 1 < up > o < /up > to 1 < up > o < /up > to 1 < up > o < /up > to 1 < up > o < up > o < /up > to 1 < up > o <$

Keywords : rolling speed ratio, strip shape, work roll cross angle, work roll shifting

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