KAWASAKI STEEL TECHNICAL REPORT
No.43 (October 2000)
Automative Materials and Instrumentation
and Process Control

Advanced Process Control Technologies for Realization of Endless Hot Strip Rolling

Yasuo Ichii, Takahiro Yamasaki, Shoji Murayama

Synopsis :

Kawasaki Steel was the first in the world to start the so-called "endless hot strip rolling" at the No. 3 Hot Strip(")56 .6 (nM(r)3.8(l)11.2l (i)11.2n C)9i aorkrinegah (o)3 (t)6.8( )]TJ0 TJ-0281 T

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

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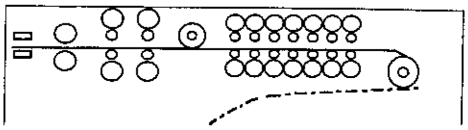
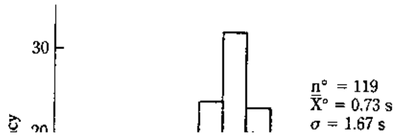
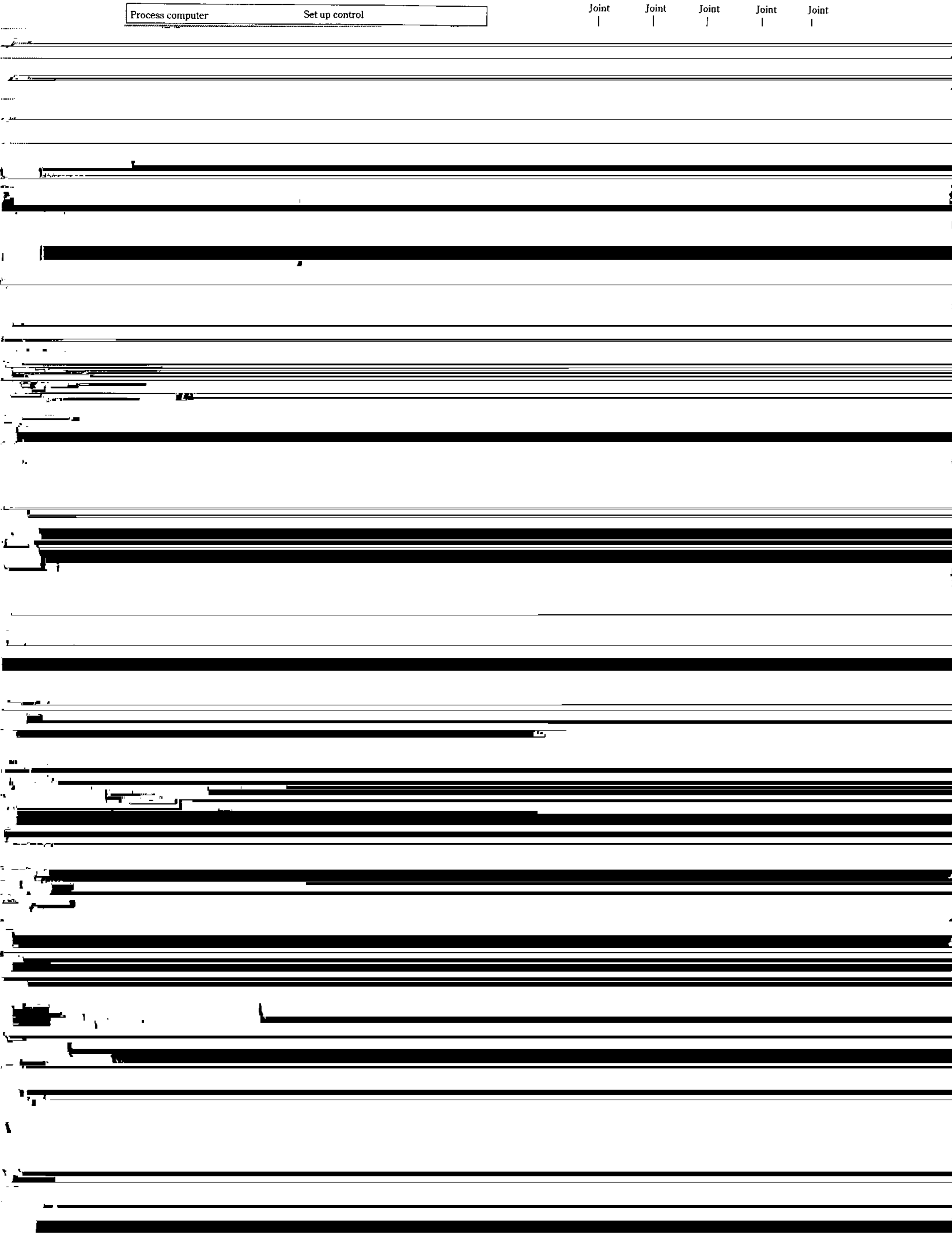
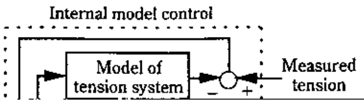
Kawasaki Steel was the first in the world to start the so-called "endless hot strip rolling" at the No. 3 Hot Strip Mill in Chiba Works by realizing hot sheet bar




30
20
cy
$\underline{n}^\circ = 119$
$\overline{X}^\circ = 0.73$ s
$\sigma = 1.67$ s


Sheet bar coiler
Leveler
Crop shear
Bar joining car
68


Process computer
Set up control
Joint
Joint
Joint
Joint
Joint


Internal model control
Model of tension system
−
+
Measured tension

Finishing mill No. 0 Strip shear No. 1 No. 2

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