

STRIP ROLLING

As a manufacturer of innovative high-tech machines, HMP Rolling offers a wide range of high-precision rolling mills for producing blanks and coils in reversing process. State-of-the-art machine technology ensures minimum downtime and maximum output.

Based on our standard range, the machines are customized towards customer and material requirements. HMP Rolling mills are generally designed as combination rolling mills for operation with 2Hi and 4Hi roll Sets.



2HI ROLLING MILL

The material is formed by two work rolls to reduce the thickness of the strip. This process is suitable for processing thicker strips using especially high rolling forces.



4HI ROLLING MILL

This system uses two work rolls and two additional back-up rolls to process the finest strip thicknesses with the lowest tolerances.

CONFIGURATION		SRM 100	SRM 200	SRM 400	SRM 800	SRM 1600	SRM 2500	SRM 3500	SRM 5000
2Hi Roll Set	Rolling force [kN]	100	200	400	800	1600	2500	3500	5000
	Roll diameter [mm]	120	160	220; 200	250	300	320	400	520
4Hi Roll Set	Rolling force [kN]	60	100	200	400	800	1250	2500	3500
	Roll diameter [mm]	100/40	120/65	160/65; 180/80	200/80	235/100	265/120	320/150	400/180
2Hi and 4Hi Roll Set	Barrel width [mm]	100; 150	100; 200	100; 200	200; 300	200; 300	300; 400	300; 400; 500	300; 400; 500

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PROPERTIES AND FEATURES:

- Rigid and heavy-duty roll stand
- High precision screw down – Hydraulic or Servo-Mechanic
- Versatile mill configuration – 2Hi and 4Hi configuration in each stand applicable
- Mill drive as Mono and Twin drive with infinitely variable speed range
- 4Hi roll set with active roll bending, to eliminate long edge and wave problems
- Rolls available in forged version or with tungsten carbide ring
- Compact machine design – reduce the footprint in your factory
- High accuracy thickness measurement – contact and laser gauges
- Mills applicable for dry rolling with inner workroll cooling, floating lubrication and minimal quantity lubrication
- Full instrumentation including temperature, torque and separating force
- Hot & Cold rolling applicable on the same stand
- Big thickness range, from Blocks to foil – Combination of Brake Down and finishing mill

SOFTWARE AND CONTROL SYSTEMS:

- Full AGC control system:
 - Thickness measurement
 - Feed forward control
 - Feed backward control
 - Mass flow regulation
- Fully digital control system and diagnostics
- Pre-calculation and storage of pass schedules
- Elongation compensation of the mill stand
- Felss Edge Device – Your step into Industry 4.0

MODULAR MACHINE DESIGN:

Easy to maintain:

- Automatic roll change devices
- Central lubrication system
- Predictive warning of critical machine status
- Electronic overload protection

Rolling mills available as:

- Solo rolling mill for manual rolling of blanks and blocks
- Rolling mill with automatic blank feed for automatic rolling without operator intervention
- Reversing rolling mill for coil production – Completely equipped production rolling mill with AGC control system, various coiler and handling applications
- Combination Mill – for plate and coil to coil production

