

CPC**COOPERATIVE PATENT CLASSIFICATION****B21B**

ROLLING OF METAL (auxiliary operations used in connection with metal-working operations covered in [B21](#), see [B21C](#); bending by rolling [B21D](#); manufacture of particular objects, e.g. screws, wheels, rings, barrels, balls, by rolling [B21H](#); pressure welding by means of a rolling mill [B23K 20/04](#))

NOTE

In this subclass, the following terms or expressions are used with the meanings indicated:

- "rolling" means rolling operations in which plastic deformations occur;
- "continuous process" means a process employing a mill train designed to have the workpiece enter one pair of rolls before leaving the preceding pair.

B21B 1/00

Metal-rolling methods or mills for making semi-finished products of solid or profiled cross-section ([B21B 17/00](#) to [B21B 23/00](#) take precedence; with respect to composition of material to be rolled [B21B 3/00](#); extending closed shapes of metal bands by simultaneous rolling at two or more zones [B21B 5/00](#); metal-rolling stands as units [B21B 13/00](#); continuous casting into moulds having walls formed by moving rolls [B22D 11/06](#)); **Sequence of operations in milling trains; Layout of rolling-mill plant, e.g. grouping of stands; Succession of passes or of sectional pass alternations**

B21B 1/02

- for rolling heavy work, e.g. ingots, slabs, {blooms} billets, in which the cross-sectional form is unimportant {Rolling combined with forging or pressing}

B21B 2001/022

- • {Blooms or billets}

B21B 1/024

- • {Forging or pressing (forging or pressing devices as units [B21B 15/0035](#))}

B21B 1/026

- • {Rolling}

B21B 2001/028

- • {Slabs}

B21B 1/04

- • in a continuous process

B21B 1/06

- • in a non-continuous process, {e.g. triplet mill, reversing mill}

B21B 1/08

- for rolling {structural sections, i.e.} work of special cross-section, e.g. angle steel (rolling metal of indefinite length in repetitive shapes specially designed for the manufacture of particular objects [B21H 8/00](#))

B21B 1/0805

- • {Flat bars, i.e. having a substantially rectangular cross-section}

B21B 2001/081

- • {Roughening or texturing surfaces of structural sections, bars, rounds, wire rods}

B21B 1/0815

- • {from flat-rolled products, e.g. by longitudinal shearing}

B21B 1/082

- • Piling sections having lateral edges specially adapted for interlocking with each other in order to build a wall

B21B 1/085

- • Rail sections

B21B 1/0855

- • • {Rerolling or processing worn or discarded rail sections}

B21B 1/088

- • H- or I-sections

B21B 1/0883

- • • {using forging or pressing devices}

B21B 1/0886

- • • {using variable-width rolls}

B21B 1/09

- • L-sections

- B21B 1/092 . . T-sections
 - B21B 1/095 . . U-or channel sections
 - B21B 1/098 . . Z-sections
- WARNING**
- Groups [B21B 1/098](#) is not complete. See also other subgroups of [B21B 1/08](#)
- B21B 1/10 . . in a single two-high or universal rolling mill {stand ([B21B 1/085](#) to [B21B 1/098](#) take precedence)}
 - B21B 1/12 . . in a continuous process, {i.e. without reversing stands ([B21B 1/085](#) to [B21B 1/098](#) take precedence)}
 - B21B 1/14 . . in a non-continuous process, {i.e. at least one reversing stand ([B21B 1/085](#) to [B21B 1/098](#) take precedence)}
 - B21B 1/16 . . for rolling {wire rods, bars, merchant bars, rounds} wire or material of like small cross-section
 - B21B 1/163 . . {Rolling or cold-forming of concrete reinforcement bars or wire (reinforcement bars per se [E04C 5/03](#)); Rolls therefor}
 - B21B 1/166 . . {Rolling wire into sections or flat ribbons}
 - B21B 1/18 . . in a continuous process
 - B21B 1/20 . . in a non-continuous process, (e.g. skew rolling, i.e. planetary cross rolling)
 - B21B 1/22 . . for rolling {plates, strips,} bands or sheets of indefinite length ([B21B 1/42](#) takes precedence)
 - B21B 2001/221 . . {by cold-rolling}
 - B21B 1/222 . . {in a rolling-drawing process; in a multi-pass mill}
 - B21B 1/224 . . {Edge rolling of flat products}
 - B21B 2001/225 . . {by hot-rolling}
 - B21B 1/227 . . {Surface roughening or texturing}
 - B21B 2001/228 . . {skin pass rolling or temper rolling}
 - B21B 1/24 . . in a continuous {or semi-continuous} process {(B21B 1/224 takes precedence)}
 - B21B 1/26 . . . by hot-rolling, {e.g. Steckel hot mill}
 - B21B 1/265 {and by compressing or pushing the material in rolling direction}
 - B21B 1/28 . . . by cold-rolling, {e.g. Steckel cold mill}
 - B21B 1/30 . . in a non-continuous process {(B21B 1/224 takes precedence)}
 - B21B 1/32 . . . in reversing {single stand} mills, e.g. with intermediate storage reels for accumulating work
 - B21B 1/34 by hot-rolling
 - B21B 1/36 by cold-rolling
 - B21B 1/38 . . for rolling sheets of limited length, e.g. folded sheets, superimposed sheets, {pack rolling} ([B21B 1/40](#) takes precedence; folding sheets before, or separating layers after, rolling [B21B 47/00](#))
 - B21B 2001/383 . . {Cladded or coated products}
 - B21B 2001/386 . . {Plates}

- B21B 1/40 . for rolling foils which present special problems, e.g. because of thinness
- B21B 1/42 . for step-by-step or planetary rolling ([making tubes by pilgrim-step rolling B21B 21/00](#))
- B21B 1/46 . for rolling metal immediately subsequent to continuous casting ([metal-rolling stands B21B 13/22](#); [continuous casting B22D 11/00](#), e.g. into moulds with rolls [B22D 11/06](#))
- B21B 1/463 . . {in a continuous process, i.e. the cast not being cut before rolling}
- B21B 1/466 . . {in a non-continuous process, i.e. the cast being cut before rolling}

- B21B 3/00** **Rolling materials of special alloys so far as the composition of the alloy requires or permits special rolling methods or sequences {Rolling of aluminium, copper, zinc or other non-ferrous metals}** (altering special metallurgical properties of alloys, other than structure consolidation or mechanical properties resulting therefrom [C21D](#), [C22F](#))

- B21B 2003/001 . {Aluminium or its alloys}
- B21B 3/003 . {Rolling non-ferrous metals immediately subsequent to continuous casting, i.e. in-line rolling}
- B21B 2003/005 . {Copper or its alloys}
- B21B 2003/006 . {Powder metal alloys}
- B21B 2003/008 . {Zinc or its alloys}
- B21B 3/02 . Rolling special iron alloys, {e.g. stainless steel}

- B21B 5/00** **Extending closed shapes of metal bands by rolling** ([manufacture of circular shapes, e.g. wheel rims, B21H 1/06](#))

- B21B 9/00** **Measures for carrying out rolling operations under special conditions, e.g. in vacuum or inert atmosphere to prevent oxidation of work; Special measures for removing fumes from rolling mills**

- B21B 11/00** **Subsidising the rolling process by subjecting rollers or work to vibrations, {e.g. ultrasonic vibrations}**

- B21B 13/00** **Metal-rolling stands, i.e. an assembly composed of a stand frame, rolls, and accessories** ([B21B 17/00](#) to [B21B 23/00](#) take precedence; details, component parts, accessories, auxiliary means, procedures in connection with metal rolling, see the relevant groups)

- B21B 13/001 . {Convertible or tiltable stands, e.g. from duo to universal stands, from horizontal to vertical stands}
- B21B 2013/003 . {Inactive rolling stands}
- B21B 13/005 . {Cantilevered roll stands}
- B21B 2013/006 . {Multiple strand rolling mills; Mill stands with multiple caliber rolls}
- B21B 13/008 . {Skew rolling stands, e.g. for rolling rounds}
- B21B 13/02 . with axes of rolls arranged horizontally
- B21B 2013/021 . . {Twin mills}
- B21B 13/023 . . {the axis of the rolls being other than perpendicular to the direction of movement of the product, e.g. cross-rolling}
- B21B 2013/025 . . {Quarto, four-high stands}

- B21B 2013/026 . . {Quinto, five high-stands}
- B21B 2013/028 . . {Sixto, six-high stands}
- B21B 13/04 . . Three-high arrangement
- B21B 13/06 . with axes of rolls arranged vertically, {e.g. edgers}
- B21B 13/08 . with differently-directed roll axes, e.g. for the so-called "universal" rolling process
- B21B 13/10 . . all axes being arranged in one plane
- B21B 13/103 . . . {for rolling bars, rods or wire}
- B21B 2013/106 . . . {for sections, e.g. beams, rails}
- B21B 13/12 . . axes being arranged in different planes
- B21B 13/14 . having counter-pressure devices acting on rolls to inhibit deflection of same under load; {Back-up rolls} (counter-pressure devices as such [B21B 29/00](#))
- B21B 13/142 . . {by axially shifting the rolls, e.g. rolls with tapered ends or with a curved contour for continuously-variable crown CVC}
- B21B 13/145 . . {Lateral support devices for rolls acting mainly in a direction parallel to the movement of the product}
- B21B 13/147 . . {Cluster mills, e.g. Sendzimir mills, Rohn mills, i.e. each work roll being supported by two rolls only arranged symmetrically with respect to the plane passing through the working rolls}
- B21B 13/16 . with alternatively operative rolls, {e.g. revolver stands, turret mills}
- B21B 13/18 . for step-by-step or planetary rolling; {pendulum mills} (methods [B21B 1/42](#); making tubes by pilgrim-step rolling [B21B 21/00](#))
- B21B 13/20 . . for planetary rolling
- B21B 13/22 . for rolling metal immediately subsequent to continuous casting, {i.e. in-line rolling of steel} (methods therefor [B21B 1/46](#); continuous casting [B22D 11/00](#), e.g. into moulds with rolls [B22D 11/06](#))

- B21B 15/00** **Arrangements for performing additional metal-working operations specially combined with or arranged in, or specially adapted for use in connection with, metal-rolling mills**
- B21B 15/0007 . {Cutting or shearing the product}
- B21B 2015/0014 . . {transversely to the rolling direction}
- B21B 2015/0021 . . {in the rolling direction}
- B21B 2015/0028 . {Drawing the rolled product}
- B21B 15/0035 . {Forging or pressing devices as units}
- B21B 15/0042 . . {Tool changers}
- B21B 15/005 . . {Lubricating, cooling or heating means}
- B21B 2015/0057 . {Coiling the rolled product}
- B21B 2015/0064 . {Uncoiling the rolled product}
- B21B 2015/0071 . {Levelling the rolled product}
- B21B 2015/0078 . {Extruding the rolled product}
- B21B 15/0085 . {Joining ends of material to continuous strip, bar or sheet}
- B21B 2015/0092 . {Welding in the rolling direction}

- B21B 15/02
- in which work is subjected to permanent internal twisting, e.g. for producing reinforcement bars for concrete

Rolling methods or mills specially designed for making or processing tubes ([control of tube rolling B21B 37/78](#))

B21B 17/00 Tube-rolling by rollers of which the axes are arranged essentially perpendicular to the axis of the work, e.g. "axial" tube-rolling

- B21B 17/02
- with mandrel, {i.e. the mandrel rod contacts the rolled tube over the rod length} ([B21B 17/08](#) takes precedence)
- B21B 17/04
- in a continuous process
- B21B 17/06
- in a discontinuous process
- B21B 17/08
- with mandrel having one or more protrusions, {i.e. only the mandrel plugs contact the rolled tube; Press-piercing mills}
- B21B 17/10
- in a continuous process
- B21B 17/12
- in a discontinuous process, {e.g. plug-rolling mills}
- B21B 17/14
- without mandrel, {e.g. stretch-reducing mills}

B21B 19/00 Tube-rolling by rollers arranged outside the work and having their axes not perpendicular to the axis of the work ([straightening by rollers B21D](#))

- B21B 19/02
- the axes of the rollers being arranged essentially diagonally to the axis of the work, e.g. "cross" tube-rolling {Diescher mills, Stiefel disc piercers, Stiefel rotary piercers}
- B21B 19/04
- Rolling basic material of solid, i.e. non-hollow, structure; Piercing, {e.g. rotary piercing mills}
- B21B 19/06
- Rolling hollow basic material, {e.g. Assel mills} ([B21B 19/04](#) takes precedence; [separating work from mandrel B21C 45/00](#))
- B21B 19/08
- Enlarging tube diameter
- B21B 19/10
- Finishing, e.g. smoothing, sizing, {reeling}
- B21B 19/12
- the axes of the rollers being arranged essentially parallel to the axis of the work
- B21B 19/14
- Rolling tubes by means of additional rollers arranged inside the tubes
- B21B 19/16
- Rolling tubes without additional rollers arranged inside the tubes

B21B 21/00 Pilgrim-step tube-rolling, {i.e. pilger mills}

- B21B 21/005
- {with reciprocating stand, e.g. driving the stand}
- B21B 21/02
- Rollers therefor
- B21B 21/04
- Pilgrim-step feeding mechanisms ([B21B 21/06](#) takes precedence)
- B21B 21/045
- {for reciprocating stands}
- B21B 21/06
- Devices for revolving work between the steps
- B21B 21/065
- {for reciprocating stands}

- B21B 23/00** Tube-rolling not restricted to methods provided for in only one of groups [B21B 17/00](#), [B21B 19/00](#), [B21B 21/00](#), e.g. combined processes {planetary tube rolling, auxiliary arrangements, e.g. lubricating, special tube blanks, continuous casting combined with tube rolling} ([B21B 25/00](#) takes precedence)
- [B21B 2023/005](#) . {Roughening or texturing surfaces of tubes}
- B21B 25/00** Mandrels for metal tube rolling mills, e.g. mandrels of the types used in the methods covered by group [B21B 17/00](#); Accessories or auxiliary means therefor; {Construction of, or alloys for, mandrels or plugs}
- [B21B 25/02](#) . Guides, supports, or abutments for mandrels, e.g. carriages {or steadiers}; Adjusting devices for mandrels
- [B21B 25/04](#) . Cooling or lubricating mandrels during operation
- [B21B 25/06](#) . Interchanging mandrels, {fixing plugs on mandrel rods or cooling during interchanging mandrels (separating tubes from mandrels [B21C 45/00](#))}
- B21B 27/00** Rolls, {roll alloys or roll fabrication} (shape of working surfaces required by special processes [B21B 1/00](#)); Lubricating, cooling or heating rolls while in use
- [B21B 27/005](#) . {Rolls with a roughened or textured surface; Methods for making same}
- [B21B 27/02](#) . Shape or construction of rolls (for rolling metal of indefinite length in repetitive shapes specially designed for the manufacture of particular objects [B21H 8/02](#) (; [B21B 27/005](#) takes precedence))
- [B21B 27/021](#) . . {Rolls for sheets or strips}
- [B21B 2027/022](#) . . . {Rolls having tapered ends}
- [B21B 27/024](#) . . {Rolls for bars, rods, rounds, tubes, wire or the like}
- [B21B 27/025](#) . . . {Skew rolls}
- [B21B 27/027](#) . . {Vertical rolls}
- [B21B 27/028](#) . . {Variable-width rolls}
- [B21B 27/03](#) . . Sleeved rolls {([B21B 27/028](#) takes precedence)}
- [B21B 27/032](#) . . . {Rolls for sheets or strips}
- [B21B 27/035](#) . . . {Rolls for bars, rods, rounds, tubes, wire or the like}
- [B21B 27/037](#) {Skew rolls}
- [B21B 27/05](#) . . . with deflectable sleeves
- [B21B 27/055](#) {with sleeves radially deflectable on a stationary beam by means of hydraulic supports (in general [F16C 13/00](#); for paper-making machines [D21G 1/00](#); regulating devices therefor [B21B 37/36](#))}
- [B21B 27/06](#) . Lubricating, cooling or heating rolls
- [B21B 27/08](#) . . internally
- [B21B 2027/083](#) . . . {cooling internally}
- [B21B 2027/086](#) . . . {heating internally}
- [B21B 27/10](#) . . externally
- [B21B 2027/103](#) . . . {cooling externally}
- [B21B 27/106](#) . . . {Heating the rolls}

- B21B 28/00** **Maintaining rolls or rolling equipment in effective condition** (lubricating, cooling or heating rolls while in use [B21B 27/06](#))
- [B21B 28/02](#) . Maintaining rolls in effective condition, e.g. reconditioning
- [B21B 28/04](#) . . while in use, e.g. polishing {or grinding while the rolls are in their stands}
- B21B 29/00** **Counter-pressure devices acting on rolls to inhibit deflection of same under load, e.g. backing rolls; {Roll bending devices, e.g. hydraulic actuators acting on roll shaft ends** (control devices responsive to roll bending [B21B 37/38](#))
- B21B 31/00** **Rolling stand structures; Mounting, adjusting, or interchanging rolls, roll mountings, or stand frames**
- [B21B 31/02](#) . Rolling stand frames {or housings}; Roll mountings; {Roll chocks}
- [B21B 2031/021](#) . . {Integral tandem mill housings}
- [B21B 2031/023](#) . . {Transverse shifting one housing}
- [B21B 2031/025](#) . . {Shifting the stand in or against the rolling direction}
- [B21B 2031/026](#) . . {Transverse shifting the stand}
- [B21B 31/028](#) . . {Prestressing of rolls or roll mountings in stand frames}
- [B21B 31/04](#) . . with tie rods {in frameless stands}, e.g. prestressed tie rods
- [B21B 31/06](#) . . Fastening stands or frames to foundation, e.g. to the sole plate (in general [F16M](#))
- [B21B 31/07](#) . Adaptation of roll {neck} bearings (bearings in general [F16C](#))
- [B21B 2031/072](#) . . {Bearing materials}
- [B21B 31/074](#) . . {Oil film bearings, e.g. "Morgoil" bearings}
- [B21B 31/076](#) . . {Cooling; Lubricating roller bearings}
- [B21B 31/078](#) . . {Sealing devices (Sealings in general [F16J 15/00](#))}
- [B21B 31/08](#) . Interchanging rolls, roll mountings, or stand frames, {e.g. using C-hooks; Replacing roll chocks on roll shafts}
- [B21B 31/10](#) . . by horizontally displacing, {i.e. horizontal roll changing}
- [B21B 31/103](#) . . . {Manipulators or carriages therefor}
- [B21B 31/106](#) . . . {Vertical displacement of rolls or roll chocks during horizontal roll changing}
- [B21B 31/12](#) . . by vertically displacing
- [B21B 31/14](#) . . by pivotally displacing
- [B21B 31/16](#) . Adjusting {or positioning} rolls (control devices [B21B 37/00](#))
- [B21B 31/18](#) . . by moving rolls axially
- [B21B 31/185](#) . . . {and by crossing rolls}
- [B21B 31/20](#) . . by moving rolls perpendicularly to roll axis
- [B21B 31/203](#) . . . {Balancing rolls}
- [B21B 2031/206](#) . . . {Horizontal offset of work rolls}
- [B21B 31/22](#) . . . mechanically, {e.g. by thrust blocks, inserts for removal}
- [B21B 31/24](#) by screws
- [B21B 31/26](#) Adjusting eccentrically-mounted roll bearings

B21B 31/28	<ul style="list-style-type: none"> by toggle-lever mechanisms
B21B 31/30	<ul style="list-style-type: none"> by wedges or their equivalent
B21B 31/32	<ul style="list-style-type: none"> by liquid pressure, {e.g. hydromechanical adjusting}
B21B 33/00	Safety devices not otherwise provided for (safety devices in general F16P); Breaker blocks; Devices for freeing jammed rolls {for handling cobbles; Overload safety devices}
B21B 2033/005	<ul style="list-style-type: none"> {Cobble-freeing}
B21B 33/02	<ul style="list-style-type: none"> Preventing fracture of rolls
B21B 35/00	Drives for metal-rolling mills, {e.g. hydraulic drives}
B21B 2035/005	<ul style="list-style-type: none"> {Hydraulic drive motors}
B21B 35/02	<ul style="list-style-type: none"> for continuously-operating mills (B21B 35/10, B21B 35/12 take precedence)
B21B 35/025	<ul style="list-style-type: none"> <ul style="list-style-type: none"> {for stretch-reducing of tubes}
B21B 35/04	<ul style="list-style-type: none"> <ul style="list-style-type: none"> each stand having its own motor or motors
B21B 35/06	<ul style="list-style-type: none"> for non-continuously-operating mills or for single stands (B21B 35/10, B21B 35/12 take precedence)
B21B 35/08	<ul style="list-style-type: none"> for reversing rolling mills
B21B 35/10	<ul style="list-style-type: none"> Driving arrangements for rolls which have only a low-power drive; Driving arrangements for rolls which receive power from the shaft of another roll
B21B 2035/103	<ul style="list-style-type: none"> <ul style="list-style-type: none"> {Fluid-driven rolls or rollers}
B21B 2035/106	<ul style="list-style-type: none"> <ul style="list-style-type: none"> {Non-driven or idler rolls or rollers}
B21B 35/12	<ul style="list-style-type: none"> Toothed-wheel gearings specially adapted for metal-rolling mills; Housings or mountings therefor
B21B 35/14	<ul style="list-style-type: none"> Couplings, driving spindles, or spindle carriers specially adapted for, or specially arranged in, metal-rolling mills (couplings or shafts in general F16)
B21B 35/141	<ul style="list-style-type: none"> <ul style="list-style-type: none"> {Rigid spindle couplings, e.g. coupling boxes placed on roll necks (rigid couplings in general F16D 1/00)}
B21B 35/142	<ul style="list-style-type: none"> <ul style="list-style-type: none"> {Yielding spindle couplings; Universal joints for spindles (yielding couplings in general F16D 3/00)}
B21B 35/143	<ul style="list-style-type: none"> <ul style="list-style-type: none"> <ul style="list-style-type: none"> {having slidably-interengaging teeth, e.g. gear-type couplings (universal joints with the coupling parts having slidably-interengaging teeth, in general, F16D 3/18)}
B21B 35/144	<ul style="list-style-type: none"> <ul style="list-style-type: none"> <ul style="list-style-type: none"> {Wobbler couplings}
B21B 35/145	<ul style="list-style-type: none"> <ul style="list-style-type: none"> <ul style="list-style-type: none"> {Hooke's joints or the like with each coupling part pivoted with respect to an intermediate member (Hooke's joints in general F16D 3/26)}
B21B 35/146	<ul style="list-style-type: none"> <ul style="list-style-type: none"> <ul style="list-style-type: none"> {Tongue and slipper joints (tongue and slipper joints in general F16D 3/265)}
B21B 35/147	<ul style="list-style-type: none"> <ul style="list-style-type: none"> {Lubrication of spindle couplings}
B21B 35/148	<ul style="list-style-type: none"> <ul style="list-style-type: none"> {Spindle carriers or balancers}
B21B 2035/149	<ul style="list-style-type: none"> <ul style="list-style-type: none"> {Measuring devices for spindles or couplings}
B21B 37/00	Control devices or methods specially adapted for metal-rolling mills or the work produced thereby (methods or devices for measuring specially adapted for metal-rolling mills B21B 38/00)

- B21B 2037/002 . {Mass flow control}
- B21B 37/005 . {Control of time interval or spacing between workpieces}
- B21B 37/007 . {Control for preventing or reducing vibration, chatter or chatter marks (B21B 37/66 takes precedence)}
- B21B 37/16 . Control of thickness, width, diameter or other transverse dimensions (B21B 37/58 takes precedence)
- B21B 37/165 . . {responsive mainly to the measured thickness of the product}
- B21B 37/18 . . Automatic gauge control
- B21B 37/20 . . . in tandem mills
- B21B 37/22 . . Lateral spread control; Width control, e.g. by edge rolling
- B21B 37/24 . . Automatic variation of thickness according to a predetermined programme
- B21B 37/26 . . . for obtaining one strip having successive lengths of different constant thickness
- B21B 37/28 . Control of flatness or profile during rolling of strip, sheets or plates
- B21B 37/30 . . using roll camber control
- B21B 37/32 . . . by cooling, heating or lubricating the rolls
- B21B 37/34 . . . by hydraulic expansion of the rolls
- B21B 37/36 . . . by radial displacement of the roll sleeve on a stationary roll beam by means of hydraulic supports
- B21B 37/38 . . using roll bending (B21B 37/42 takes precedence)
- B21B 37/40 . . using axial shifting of the rolls (B21B 37/42 takes precedence)
- B21B 37/42 . . using a combination of roll bending and axial shifting of the rolls
- B21B 37/44 . . using heating, lubricating or water-spray cooling of the product
- B21B 37/46 . Roll speed or drive motor control (B21B 37/52, B21B 37/60 take precedence)
- B21B 37/48 . Tension control; Compression control
- B21B 37/50 . . by looper control
- B21B 37/52 . . by drive motor control
- B21B 37/54 . . . including coiler drive control, e.g. reversing mills
- B21B 37/56 . Elongation control
- B21B 37/58 . Roll-force control; Roll-gap control {(B21B 38/105 takes precedence)}
- B21B 37/60 . . by control of a motor which drives an adjusting screw
- B21B 37/62 . . by control of a hydraulic adjusting device
- B21B 37/64 . . Mill spring or roll spring compensation systems, e.g. control of prestressed mill stands
- B21B 37/66 . . Roll eccentricity compensation systems
- B21B 37/68 . Camber or steering control for strip, sheets or plates, e.g. preventing meandering
- B21B 37/70 . Length control (B21B 37/56 takes precedence)
- B21B 37/72 . Rear end control; Front end control
- B21B 37/74 . Temperature control, e.g. by cooling or heating the rolls or the product (B21B 37/32, B21B 37/44 take precedence)
- B21B 37/76 . . Cooling control on the run-out table

B21B 37/78 . Control of tube rolling

B21B 38/00 **Methods or devices for measuring, {detecting or monitoring} specially adapted for metal-rolling mills, e.g. position detection, inspection of the product {(Control devices or methods [B21B 37/00](#))}**

B21B 2038/002 . {Measuring axial forces of rolls}

B21B 2038/004 . {Measuring scale thickness}

B21B 38/006 . {for measuring temperature}

B21B 38/008 . {Monitoring or detecting vibration, chatter or chatter marks}

B21B 38/02 . for measuring flatness or profile of strips

B21B 38/04 . for measuring thickness, width, diameter or other transverse dimensions of the product

B21B 38/06 . for measuring tension or compression

B21B 38/08 . for measuring roll-force

B21B 38/10 . for measuring roll-gap, e.g. pass indicators

B21B 38/105 . . {Calibrating or presetting roll-gap}

B21B 38/12 . for measuring roll camber

B21B 39/00 **Arrangements for moving, supporting, or positioning work, or controlling its movement, combined with or arranged in, or specially adapted for use in connection with, metal-rolling mills (guiding, conveying, or accumulating easily-flexible work in loops or curves [B21B 41/00](#); specially associated with cooling-beds [B21B 43/00](#); conveying or transporting in general [B65G](#))**

B21B 39/002 . {Piling, unpling, unscrambling}

B21B 39/004 . {Transverse moving}

B21B 39/006 . {Pinch roll sets}

B21B 39/008 . {Rollers for roller conveyers (roller-ways in general [B65G 13/00](#), [B21B 39/00](#))}

B21B 39/02 . Feeding or supporting work; Braking or tensioning arrangements, {e.g. threading arrangements}

B21B 39/04 . . Lifting or lowering work for conveying purposes, e.g. tilting tables arranged immediately in front of or behind the pass (turn-over or like manipulating means as such [B21B 39/20](#))

B21B 39/06 . . Pushing or forcing work into pass

B21B 39/08 . . Braking or tensioning arrangements

B21B 39/082 . . . {Bridle devices}

B21B 39/084 . . . {Looper devices}

B21B 39/086 . . . {Braking devices}

B21B 39/088 . . . {Bumpers, stopping devices}

B21B 39/10 . . Arrangement or installation of feeding rollers in rolling stands

B21B 39/12 . . Arrangement or installation of roller tables in relation to a roll stand

B21B 39/14 . Guiding, positioning or aligning work ([B21B 43/12](#) takes precedence; guides in which work is subjected to permanent internal twisting [B21B 15/02](#))

B21B 39/16 . . immediately before entering or after leaving the pass

- B21B 39/165 . . . {Guides or guide rollers for rods, bars, rounds, tubes ([B21B 39/28](#) takes precedence); Aligning guides}
- B21B 39/18 . . Switches for directing work in metal-rolling mills or trains
- B21B 39/20 . Revolving, turning-over, or like manipulation of work, {e.g. revolving in trio stands} (guides in which work is subjected to permanent internal twisting [B21B 15/02](#))
- B21B 39/22 . . by tipping, e.g. by lifting one side by levers or wedges ([B21B 39/26](#), [B21B 39/28](#) take precedence)
- B21B 39/223 . . . {Side-guard manipulators}
- B21B 39/226 . . . {Tiltable ingot chairs}
- B21B 39/24 . . by tongs or grippers
- B21B 39/26 . . by members, e.g. grooved, engaging opposite sides of the work and moved relatively to each other to revolve the work
- B21B 39/28 . . by means of guide members shaped to revolve the work during its passage
- B21B 39/30 . . by lodging it in a rotating ring manipulator or ring segment manipulator
- B21B 39/32 . . Devices specially adapted for turning sheets
- B21B 39/34 . Arrangements or constructional combinations specifically designed to perform functions covered by more than one of groups [B21B 39/02](#), [B21B 39/14](#), [B21B 39/20](#)

B21B 41/00 Guiding, conveying, or accumulating easily-flexible work, e.g. wire, sheet metal bands, in loops or curves; Loop lifters

- B21B 41/02 . Returning work to repeat the pass or passes {within the same stand}
- B21B 41/04 . . above or underneath the rolling stand or rolls
- B21B 41/06 . in which the direction of movement of the work is turned through approximately 180 degrees, {e.g. repeaters, i.e. from one stand to another}
- B21B 41/08 . without overall change in the general direction of movement of the work
- B21B 41/10 . . Loop deflectors {([B21B 39/084](#) takes precedence)}
- B21B 41/12 . Arrangements of interest only with respect to provision for indicating or controlling operations

B21B 43/00 Cooling beds, whether stationary or moving; Means specially associated with cooling beds, e.g. for braking work or for transferring it to or from the bed (conveying means in general [B65G](#))

- B21B 43/003 . {Transfer to bed}
- B21B 43/006 . {Transfer from bed}
- B21B 43/02 . Cooling beds comprising rakes {racks, walking beams} or bars ([B21B 43/10](#) takes precedence)
- B21B 43/04 . Cooling beds comprising rolls or worms
- B21B 43/06 . Cooling beds comprising carriages ([B21B 43/08](#) takes precedence)
- B21B 43/08 . Cooling beds comprising revolving drums or recycling chains {or discs}
- B21B 43/10 . Cooling beds with other work-shifting elements projecting through the bed
- B21B 43/12 . Devices for positioning workpieces "flushed", i.e. with all their axial ends arranged in line on cooling beds or on co-operating conveyers, {e.g. before cutting}

B21B 45/00	Devices for surface {or other} treatment of work, specially combined with or arranged in, or specially adapted for use in connection with, metal-rolling mills (B21B 15/00, B21B 1/227 and B21B 27/005) take precedence; technical features of scaling-off devices B21C 43/00)
B21B 45/002	. {Increasing friction between work and working rolls by using friction increasing substance}
B21B 45/004	. {Heating the product}
B21B 2045/006	. . {in vacuum or in inert atmosphere}
B21B 45/008	. {Heat shields}
B21B 45/02	. for lubricating, cooling, or cleaning {(in particular in combination with forging or pressing devices B21B 15/005 , control of flatness or profile using lubricating or cooling B21B 37/44)}
B21B 45/0203	. . {Cooling}
B21B 45/0206	. . . {Coolants}
B21B 45/0209	. . . {Cooling devices, e.g. using gaseous coolants}
B21B 2045/0212 {using gaseous coolants}
B21B 45/0215 {using liquid coolants, e.g. for sections, for tubes}
B21B 45/0218 {for strips, sheets, or plates (B21B 45/023 , B21B 45/0233 take precedence)}
B21B 2045/0221 {for structural sections, e.g. H-beams}
B21B 45/0224 {for wire, rods, rounds, bars (B21B 45/023 , B21B 45/0233 take precedence)}
B21B 2045/0227 {for tubes}
B21B 45/023 {by immersion in a bath}
B21B 45/0233 {Spray nozzles, Nozzle headers; Spray systems}
B21B 2045/0236	. . {Laying heads for overlapping rings on cooling conveyer}
B21B 45/0239	. . {Lubricating}
B21B 45/0242	. . . {Lubricants}
B21B 45/0245	. . . {Lubricating devices}
B21B 45/0248 {using liquid lubricants, e.g. for sections, for tubes}
B21B 45/0251 {for strips, sheets, or plates}
B21B 2045/0254 {for structural sections, e.g. H-beams}
B21B 45/0257 {for wire, rods, rounds, bars}
B21B 2045/026 {for tubes}
B21B 45/0263 {using solid lubricants}
B21B 45/0266	. . {Measuring or controlling thickness of liquid films}
B21B 45/0269	. . {Cleaning}
B21B 45/0272	. . . {Cleaning compositions}
B21B 45/0275	. . . {Cleaning devices}
B21B 45/0278 {removing liquids}
B21B 45/0281 {removing coolants}
B21B 45/0284 {removing lubricants}

- B21B 45/0287 {removing solid particles, e.g. dust, rust}
- B21B 45/029 . . . {Liquid recovering devices}
- B21B 45/0293 {Recovering coolants}
- B21B 45/0296 {Recovering lubricants}
- B21B 45/04 . for de-scaling, {e.g. by brushing (descaling of rod or wire [B21C 43/04](#))}
- B21B 45/06 . . of strip material ([B21B 45/08](#) takes precedence)
- B21B 45/08 . . hydraulically

B21B 47/00 **Auxiliary arrangements, devices or methods in connection with rolling of multi-layer sheets of metal** ([soaking pits C21D 9/70](#))

- B21B 47/02 . for folding sheets before rolling
- B21B 47/04 . for separating layers after rolling

B21B 99/00 **Subject matter not provided for in other groups of this subclass**

B21B 2201/00 **Special rolling modes**

- B21B 2201/02 . Austenitic rolling
- B21B 2201/04 . Ferritic rolling
- B21B 2201/06 . Thermomechanical rolling
- B21B 2201/08 . Batch rolling
- B21B 2201/10 . Endless rolling
- B21B 2201/12 . Isothermic rolling
- B21B 2201/14 . Soft reduction
- B21B 2201/16 . Two-phase or mixed-phase rolling
- B21B 2201/18 . Vertical rolling pass lines

Equipment codes

B21B 2203/00 **Auxiliary arrangements, devices or methods in combination with rolling mills or rolling methods**

- B21B 2203/02 . Backlash elimination
- B21B 2203/04 . Brakes
- B21B 2203/06 . Cassettes
- B21B 2203/08 . Clutches
- B21B 2203/10 . Counterweights
- B21B 2203/12 . Covers or shieldings
- B21B 2203/14 . Dummy bars or slabs
- B21B 2203/16 . Eccentrics
- B21B 2203/18 . Rolls or rollers
- B21B 2203/182 . . Fluid driven rolls or rollers
- B21B 2203/185 . . Reversible rolls for changing grooves
- B21B 2203/187 . . Tilting rolls

B21B 2203/20	. Flywheels
B21B 2203/22	. Hinged chocks
B21B 2203/24	. Hydrostatic bearings or guides
B21B 2203/26	. Motors, drives
B21B 2203/28	. Mounting or dismounting bearing and chock as a unit
B21B 2203/30	. Quick or bayonet couplings
B21B 2203/32	. Roll changing stools
B21B 2203/34	. Rotational position or alignment
B21B 2203/36	. Spacers
B21B 2203/38	. Strain gauges
B21B 2203/40	. Torsion bars or shafts
B21B 2203/42	. Turntables
B21B 2203/44	. Vibration dampers
B21B 2205/00	Particular shaped rolled products
B21B 2205/02	. Tailored blanks
B21B 2205/04	. Taper- or wedge-shaped profiles
B21B 2261/00	Product parameters
B21B 2261/02	. Transverse dimensions
B21B 2261/04	. . Thickness, gauge
B21B 2261/043	. . . Blanks with variable thickness in the rolling direction
B21B 2261/046	. . . Different thickness in width direction
B21B 2261/05	. . . Different constant thicknesses in one rolled product
B21B 2261/06	. . Width
B21B 2261/065	. . . Blanks with variable width
B21B 2261/08	. . Diameter
B21B 2261/10	. . Cross-sectional area
B21B 2261/12	. Length
B21B 2261/14	. Roughness
B21B 2261/18	. Weight
B21B 2261/20	. Temperature
B21B 2261/21	. . Temperature profile
B21B 2261/22	. Hardness
B21B 2263/00	Shape of product
B21B 2263/02	. Profile, e.g. of plate, hot strip, sections
B21B 2263/04	. Flatness
B21B 2263/06	. . Edge waves
B21B 2263/08	. . Centre buckles
B21B 2263/10	. Lateral spread defects

- B21B 2263/12
 - . . Dog bone
- B21B 2263/16
 - . Alligating
- B21B 2263/20
 - . End shape; fish tail; tongue
- B21B 2263/30
 - . Shape in top view

B21B 2265/00**Forming parameters**

- B21B 2265/02
 - . Tension
- B21B 2265/04
 - . . Front or inlet tension
- B21B 2265/06
 - . . Interstand tension
- B21B 2265/08
 - . . Back or outlet tension
- B21B 2265/10
 - . Compression, e.g. longitudinal compression
- B21B 2265/12
 - . Rolling load or rolling pressure; roll force
- B21B 2265/14
 - . Reduction rate
- B21B 2265/16
 - . . Extension
- B21B 2265/18
 - . Elongation
- B21B 2265/20
 - . Slip
- B21B 2265/22
 - . Pass schedule
- B21B 2265/24
 - . asymmetric rolling

B21B 2267/00**Roll parameters**

- B21B 2267/02
 - . Roll dimensions
- B21B 2267/06
 - . . Roll diameter
- B21B 2267/065
 - . . . Top and bottom roll have different diameters; Asymmetrical rolling
- B21B 2267/08
 - . . Roll eccentricity
- B21B 2267/10
 - . Roughness of roll surface
- B21B 2267/12
 - . Roll temperature
- B21B 2267/18
 - . Roll crown; roll profile
- B21B 2267/19
 - . . Thermal crown
- B21B 2267/20
 - . . Ground camber or profile
- B21B 2267/22
 - . . Hydraulic expansion of rolls
- B21B 2267/24
 - . Roll wear
- B21B 2267/26
 - . Hardness of the roll surface
- B21B 2267/28
 - . Elastic moduli of rolls

B21B 2269/00**Roll bending or shifting**

- B21B 2269/02
 - . Roll bending; vertical bending of rolls
- B21B 2269/04
 - . . Work roll bending
- B21B 2269/06
 - . . Intermediate roll bending
- B21B 2269/08
 - . . Back-up roll bending
- B21B 2269/10
 - . Horizontal bending of rolls
- B21B 2269/12
 - . Axial shifting the rolls

- B21B 2269/14
 - . . Work rolls
- B21B 2269/16
 - . . Intermediate rolls
- B21B 2269/18
 - . . Back-up rolls

B21B 2271/00**Mill stand parameters**

- B21B 2271/02
 - . Roll gap, screw-down position, draft position
- B21B 2271/025
 - . . Tapered roll gap
- B21B 2271/04
 - . . Screw-down speed, draft speed
- B21B 2271/06
 - . Mill spring

B21B 2273/00**Path parameters**

- B21B 2273/02
 - . Vertical deviation, e.g. slack, looper height
- B21B 2273/04
 - . Lateral deviation, meandering, camber of product
- B21B 2273/06
 - . Threading
- B21B 2273/08
 - . . Threading-in or before threading-in
- B21B 2273/10
 - . . Threading-out or after threading-out
- B21B 2273/12
 - . End of product
- B21B 2273/14
 - . . Front end or leading end
- B21B 2273/16
 - . . Tail or rear end
- B21B 2273/18
 - . Presence of product
- B21B 2273/20
 - . Track of product
- B21B 2273/22
 - . Aligning on rolling axis, e.g. of roll calibers
- B21B 2273/24
 - . Web positioning

B21B 2275/00**Mill drive parameters**

- B21B 2275/02
 - . Speed
- B21B 2275/04
 - . . Roll speed
- B21B 2275/05
 - . . . Speed difference between top and bottom rolls
- B21B 2275/06
 - . . Product speed
- B21B 2275/08
 - . . Coiler speed
- B21B 2275/10
 - . Motor power; motor current
- B21B 2275/12
 - . . Roll torque