

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.

1/00	Metal-rolling methods or mills for making semi-finished products of solid or profiled cross-section (B21B 17/00 - 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	1/098	. . Z-sections
			WARNING
			Groups B21B 1/098 is not complete. See also other subgroups of B21B 1/08
		1/10	. . in a single two-high or universal rolling mill {stand (B21B 1/085 - B21B 1/098 take precedence)}
		1/12	. . in a continuous process, {i.e. without reversing stands (B21B 1/085 - B21B 1/098 take precedence)}
		1/14	. . in a non-continuous process, {i.e. at least one reversing stand (B21B 1/085 - B21B 1/098 take precedence)}
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}	1/16	. for rolling {wire rods, bars, merchant bars, rounds} wire or material of like small cross-section
2001/022	. . {Blooms or billets}	1/163	. . {Rolling or cold-forming of concrete reinforcement bars or wire (reinforcement bars per se E04C 5/03); Rolls therefor}
1/024	. . {Forging or pressing (forging or pressing devices as units B21B 15/0035)}	1/166	. . {Rolling wire into sections or flat ribbons}
1/026	. . {Rolling}	1/18	. . in a continuous process
2001/028	. . {Slabs}	1/20	. . in a non-continuous process, (e.g. triplet mill, reversing mill)
1/04	. . in a continuous process	1/22	. for rolling {plates, strips,} bands or sheets of indefinite length (B21B 1/42 takes precedence)
1/06	. . in a non-continuous process, {e.g. triplet mill, reversing mill}	2001/221	. . {by cold-rolling}
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)	1/222	. . {in a rolling-drawing process; in a multi-pass mill}
1/0805	. . {Flat bars, i.e. having a substantially rectangular cross-section}	1/224	. . {Edge rolling of flat products}
2001/081	. . {Roughening or texturing surfaces of structural sections, bars, rounds, wire rods}	2001/225	. . {by hot-rolling}
1/0815	. . {from flat-rolled products, e.g. by longitudinal shearing}	1/227	. . {Surface roughening or texturing}
1/082	. . Piling sections having lateral edges specially adapted for interlocking with each other in order to build a wall	2001/228	. . {skin pass rolling or temper rolling}
1/085	. . Rail sections	1/24	. . in a continuous {or semi-continuous} process {(B21B 1/224 takes precedence)}
1/0855	. . . {Rerolling or processing worn or discarded rail sections}	1/26	. . . by hot-rolling, {e.g. Steckel hot mill}
1/088	. . H- or I-sections	1/265 {and by compressing or pushing the material in rolling direction}
1/0883	. . . {using forging or pressing devices}	1/28	. . . by cold-rolling, {e.g. Steckel cold mill}
1/0886	. . . {using variable-width rolls}	1/30	. . in a non-continuous process {(B21B 1/224 takes precedence)}
1/09	. . L-sections	1/32	. . . in reversing {single stand} mills, e.g. with intermediate storage reels for accumulating work
1/092	. . T-sections	1/34 by hot-rolling
1/095	. . U-or channel sections	1/36 by cold-rolling

- 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](#))
- 2001/383 . . {Cladded or coated products}
- 2001/386 . . {Plates}
- 1/40 . for rolling foils which present special problems, e.g. because of thinness
- 1/42 . for step-by-step or planetary rolling ([making tubes by pilgrim-step rolling B21B 21/00](#))
- 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](#))
- 1/463 . . {in a continuous process, i.e. the cast not being cut before rolling}
- 1/466 . . {in a non-continuous process, i.e. the cast being cut before rolling}
- 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)**
- 2003/001 . {Aluminium or its alloys}
- 3/003 . {Rolling non-ferrous metals immediately subsequent to continuous casting, i.e. in-line rolling}
- 2003/005 . {Copper or its alloys}
- 2003/006 . {Powder metal alloys}
- 2003/008 . {Zinc or its alloys}
- 3/02 . Rolling special iron alloys, {e.g. stainless steel}
- 5/00 Extending closed shapes of metal bands by rolling (manufacture of circular shapes, e.g. wheel rims, B21H 1/06)**
- 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**
- 11/00 Subsidising the rolling process by subjecting rollers or work to vibrations, {e.g. ultrasonic vibrations}**
- 13/00 Metal-rolling stands, i.e. an assembly composed of a stand frame, rolls, and accessories (B21B 17/00 - B21B 23/00 take precedence; details, component parts, accessories, auxiliary means, procedures in connection with metal rolling, see the relevant groups)**
- 13/001 . {Convertible or tiltable stands, e.g. from duo to universal stands, from horizontal to vertical stands}
- 2013/003 . {Inactive rolling stands}
- 13/005 . {Cantilevered roll stands}
- 2013/006 . {Multiple strand rolling mills; Mill stands with multiple caliber rolls}
- 13/008 . {Skew rolling stands, e.g. for rolling rounds}
- 13/02 . with axes of rolls arranged horizontally
- 2013/021 . . {Twin mills}
- 13/023 . . {the axis of the rolls being other than perpendicular to the direction of movement of the product, e.g. cross-rolling}
- 2013/025 . . {Quarto, four-high stands}
- 2013/026 . . {Quinto, five high-stands}
- 2013/028 . . {Sixto, six-high stands}
- 13/04 . . Three-high arrangement
- 13/06 . with axes of rolls arranged vertically, {e.g. edgers}
- 13/08 . with differently-directed roll axes, e.g. for the so-called "universal" rolling process
- 13/10 . . all axes being arranged in one plane
- 13/103 . . . {for rolling bars, rods or wire}
- 2013/106 . . . {for sections, e.g. beams, rails}
- 13/12 . . axes being arranged in different planes
- 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](#))
- 13/142 . . {by axially shifting the rolls, e.g. rolls with tapered ends or with a curved contour for continuously-variable crown CVC}
- 13/145 . . {Lateral support devices for rolls acting mainly in a direction parallel to the movement of the product}
- 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}
- 13/16 . with alternatively operative rolls, {e.g. revolver stands, turret mills}
- 13/18 . for step-by-step or planetary rolling; {pendulum mills} ([methods B21B 1/42](#); [making tubes by pilgrim-step rolling B21B 21/00](#))
- 13/20 . . for planetary rolling
- 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](#))
- 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**
- 15/0007 . {Cutting or shearing the product}
- 2015/0014 . . {transversely to the rolling direction}
- 2015/0021 . . {in the rolling direction}
- 2015/0028 . {Drawing the rolled product}
- 15/0035 . {Forging or pressing devices as units}
- 15/0042 . . {Tool changers}
- 15/005 . . {Lubricating, cooling or heating means}
- 2015/0057 . {Coiling the rolled product}
- 2015/0064 . {Uncoiling the rolled product}
- 2015/0071 . {Levelling the rolled product}
- 2015/0078 . {Extruding the rolled product}
- 15/0085 . {Joining ends of material to continuous strip, bar or sheet}
- 2015/0092 . {Welding in the rolling direction}
- 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](#))**
- 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**

17/02	<ul style="list-style-type: none"> with mandrel, {i.e. the mandrel rod contacts the rolled tube over the rod length} (B21B 17/08 takes precedence) 	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
17/04	<ul style="list-style-type: none"> in a continuous process 	27/005	<ul style="list-style-type: none"> {Rolls with a roughened or textured surface; Methods for making same}
17/06	<ul style="list-style-type: none"> in a discontinuous process 	27/02	<ul style="list-style-type: none"> 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)
17/08	<ul style="list-style-type: none"> with mandrel having one or more protrusions, {i.e. only the mandrel plugs contact the rolled tube; Press-piercing mills} 	27/021	<ul style="list-style-type: none"> {Rolls for sheets or strips}
17/10	<ul style="list-style-type: none"> in a continuous process 	2027/022	<ul style="list-style-type: none"> {Rolls having tapered ends}
17/12	<ul style="list-style-type: none"> in a discontinuous process, {e.g. plug-rolling mills} 	27/024	<ul style="list-style-type: none"> {Rolls for bars, rods, rounds, tubes, wire or the like}
17/14	<ul style="list-style-type: none"> without mandrel, {e.g. stretch-reducing mills} 	27/025	<ul style="list-style-type: none"> {Skew rolls}
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)	27/027	<ul style="list-style-type: none"> {Vertical rolls}
19/02	<ul style="list-style-type: none"> 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} 	27/028	<ul style="list-style-type: none"> {Variable-width rolls}
19/04	<ul style="list-style-type: none"> Rolling basic material of solid, i.e. non-hollow, structure; Piercing, {e.g. rotary piercing mills} 	27/03	<ul style="list-style-type: none"> Sleeved rolls {(B21B 27/028 takes precedence)}
19/06	<ul style="list-style-type: none"> Rolling hollow basic material, {e.g. Assel mills} (B21B 19/04 takes precedence; separating work from mandrel B21C 45/00) 	27/032	<ul style="list-style-type: none"> {Rolls for sheets or strips}
19/08	<ul style="list-style-type: none"> Enlarging tube diameter 	27/035	<ul style="list-style-type: none"> {Rolls for bars, rods, rounds, tubes, wire or the like}
19/10	<ul style="list-style-type: none"> Finishing, e.g. smoothing, sizing, {reeling} 	27/037	<ul style="list-style-type: none"> {Skew rolls}
19/12	<ul style="list-style-type: none"> the axes of the rollers being arranged essentially parallel to the axis of the work 	27/05	<ul style="list-style-type: none"> with deflectable sleeves
19/14	<ul style="list-style-type: none"> Rolling tubes by means of additional rollers arranged inside the tubes 	27/055	<ul style="list-style-type: none"> {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)}
19/16	<ul style="list-style-type: none"> Rolling tubes without additional rollers arranged inside the tubes 	27/06	<ul style="list-style-type: none"> Lubricating, cooling or heating rolls
21/00	Pilgrim-step tube-rolling, {i.e. pilger mills}	27/08	<ul style="list-style-type: none"> internally
21/005	<ul style="list-style-type: none"> {with reciprocating stand, e.g. driving the stand} 	2027/083	<ul style="list-style-type: none"> {cooling internally}
21/02	<ul style="list-style-type: none"> Rollers therefor 	2027/086	<ul style="list-style-type: none"> {heating internally}
21/04	<ul style="list-style-type: none"> Pilgrim-step feeding mechanisms (B21B 21/06 takes precedence) 	27/10	<ul style="list-style-type: none"> externally
21/045	<ul style="list-style-type: none"> {for reciprocating stands} 	2027/103	<ul style="list-style-type: none"> {cooling externally}
21/06	<ul style="list-style-type: none"> Devices for revolving work between the steps 	27/106	<ul style="list-style-type: none"> {Heating the rolls}
21/065	<ul style="list-style-type: none"> {for reciprocating stands} 	28/00	Maintaining rolls or rolling equipment in effective condition (lubricating, cooling or heating rolls while in use B21B 27/06)
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)	28/02	<ul style="list-style-type: none"> Maintaining rolls in effective condition, e.g. reconditioning
2023/005	<ul style="list-style-type: none"> {Roughening or texturing surfaces of tubes} 	28/04	<ul style="list-style-type: none"> while in use, e.g. polishing {or grinding while the rolls are in their stands}
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}	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)}
25/02	<ul style="list-style-type: none"> Guides, supports, or abutments for mandrels, e.g. carriages {or steadiers}; Adjusting devices for mandrels 	31/00	Rolling stand structures; Mounting, adjusting, or interchanging rolls, roll mountings, or stand frames
25/04	<ul style="list-style-type: none"> Cooling or lubricating mandrels during operation 	31/02	<ul style="list-style-type: none"> Rolling stand frames {or housings}; Roll mountings; {Roll chocks}
25/06	<ul style="list-style-type: none"> Interchanging mandrels, {fixing plugs on mandrel rods or cooling during interchanging mandrels (separating tubes from mandrels B21C 45/00)} 	2031/021	<ul style="list-style-type: none"> {Integral tandem mill housings}
		2031/023	<ul style="list-style-type: none"> {Transverse shifting one housing}
		2031/025	<ul style="list-style-type: none"> {Shifting the stand in or against the rolling direction}
		2031/026	<ul style="list-style-type: none"> {Transverse shifting the stand}
		31/028	<ul style="list-style-type: none"> {Prestressing of rolls or roll mountings in stand frames}
		31/04	<ul style="list-style-type: none"> with tie rods {in frameless stands}, e.g. prestressed tie rods

31/06	. . Fastening stands or frames to foundation, e.g. to the sole plate (in general F16M)	35/141	. . {Rigid spindle couplings, e.g. coupling boxes placed on roll necks (rigid couplings in general F16D 1/00)}
31/07	. Adaptation of roll {neck} bearings (bearings in general F16C)	35/142	. . {Yielding spindle couplings; Universal joints for spindles (yielding couplings in general F16D 3/00)}
2031/072	. . {Bearing materials}	35/143	. . . {having slidably-interengaging teeth, e.g. gear-type couplings (universal joints with the coupling parts having slidably-interengaging teeth, in general, F16D 3/18)}
31/074	. . {Oil film bearings, e.g. "Morgoil" bearings}	35/144 {Wobbler couplings}
31/076	. . {Cooling; Lubricating roller bearings}	35/145	. . . {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)}
31/078	. . {Sealing devices (Sealings in general F16J 15/00)}	35/146 {Tongue and slipper joints (tongue and slipper joints in general F16D 3/265)}
31/08	. Interchanging rolls, roll mountings, or stand frames, {e.g. using C-hooks; Replacing roll chocks on roll shafts}	35/147	. . {Lubrication of spindle couplings}
31/10	. . by horizontally displacing, {i.e. horizontal roll changing}	35/148	. . {Spindle carriers or balancers}
31/103	. . . {Manipulators or carriages therefor}	2035/149	. . {Measuring devices for spindles or couplings}
31/106	. . . {Vertical displacement of rolls or roll chocks during horizontal roll changing}	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)
31/12	. . by vertically displacing	2037/002	. {Mass flow control}
31/14	. . by pivotally displacing	37/005	. {Control of time interval or spacing between workpieces}
31/16	. Adjusting {or positioning} rolls (control devices B21B 37/00)	37/007	. {Control for preventing or reducing vibration, chatter or chatter marks (B21B 37/66 takes precedence)}
31/18	. . by moving rolls axially	37/16	. Control of thickness, width, diameter or other transverse dimensions (B21B 37/58 takes precedence)
31/185	. . . {and by crossing rolls}	37/165	. . {responsive mainly to the measured thickness of the product}
31/20	. . by moving rolls perpendicularly to roll axis	37/18	. . Automatic gauge control
31/203	. . . {Balancing rolls}	37/20	. . . in tandem mills
2031/206	. . . {Horizontal offset of work rolls}	37/22	. . Lateral spread control; Width control, e.g. by edge rolling
31/22	. . . mechanically, {e.g. by thrust blocks, inserts for removal}	37/24	. . Automatic variation of thickness according to a predetermined programme
31/24 by screws	37/26	. . . for obtaining one strip having successive lengths of different constant thickness
31/26 Adjusting eccentrically-mounted roll bearings	37/28	. Control of flatness or profile during rolling of strip, sheets or plates
31/28 by toggle-lever mechanisms	37/30	. . using roll camber control
31/30 by wedges or their equivalent	37/32	. . . by cooling, heating or lubricating the rolls
31/32	. . . by liquid pressure, {e.g. hydromechanical adjusting}	37/34	. . . by hydraulic expansion of the rolls
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}	37/36	. . . by radial displacement of the roll sleeve on a stationary roll beam by means of hydraulic supports
2033/005	. {Cobble-freeing}	37/38	. . using roll bending (B21B 37/42 takes precedence)
33/02	. Preventing fracture of rolls	37/40	. . using axial shifting of the rolls (B21B 37/42 takes precedence)
35/00	Drives for metal-rolling mills, {e.g. hydraulic drives}	37/42	. . using a combination of roll bending and axial shifting of the rolls
2035/005	. {Hydraulic drive motors}	37/44	. . using heating, lubricating or water-spray cooling of the product
35/02	. for continuously-operating mills (B21B 35/10, B21B 35/12 take precedence)	37/46	. Roll speed or drive motor control (B21B 37/52, B21B 37/60 take precedence)
35/025	. . {for stretch-reducing of tubes}	37/48	. Tension control; Compression control
35/04	. . each stand having its own motor or motors	37/50	. . by looper control
35/06	. for non-continuously-operating mills or for single stands (B21B 35/10, B21B 35/12 take precedence)	37/52	. . by drive motor control
35/08	. . for reversing rolling mills		
35/10	. Driving arrangements for rolls which have only a low-power drive; Driving arrangements for rolls which receive power from the shaft of another roll		
2035/103	. . {Fluid-driven rolls or rollers}		
2035/106	. . {Non-driven or idler rolls or rollers}		
35/12	. Toothed-wheel gearings specially adapted for metal-rolling mills; Housings or mountings therefor		
35/14	. Couplings, driving spindles, or spindle carriers specially adapted for, or specially arranged in, metal-rolling mills (couplings or shafts in general F16)		

37/54	. . . including coiler drive control, e.g. reversing mills	39/10	. . Arrangement or installation of feeding rollers in rolling stands
37/56	. Elongation control	39/12	. . Arrangement or installation of roller tables in relation to a roll stand
37/58	. Roll-force control; Roll-gap control {(B21B 38/105 takes precedence)}	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)
37/60	. . by control of a motor which drives an adjusting screw	39/16	. . immediately before entering or after leaving the pass
37/62	. . by control of a hydraulic adjusting device	39/165	. . . {Guides or guide rollers for rods, bars, rounds, tubes (B21B 39/28 takes precedence); Aligning guides}
37/64	. . Mill spring or roll spring compensation systems, e.g. control of prestressed mill stands	39/18	. . Switches for directing work in metal-rolling mills or trains
37/66	. . Roll eccentricity compensation systems	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)
37/68	. Camber or steering control for strip, sheets or plates, e.g. preventing meandering	39/22	. . by tipping, e.g. by lifting one side by levers or wedges (B21B 39/26, B21B 39/28 take precedence)
37/70	. Length control (B21B 37/56 takes precedence)	39/223	. . . {Side-guard manipulators}
37/72	. Rear end control; Front end control	39/226	. . . {Tiltable ingot chairs}
37/74	. Temperature control, e.g. by cooling or heating the rolls or the product (B21B 37/32, B21B 37/44 take precedence)	39/24	. . by tongs or grippers
37/76	. . Cooling control on the run-out table	39/26	. . by members, e.g. grooved, engaging opposite sides of the work and moved relatively to each other to revolve the work
37/78	. Control of tube rolling	39/28	. . by means of guide members shaped to revolve the work during its passage
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)}	39/30	. . by lodging it in a rotating ring manipulator or ring segment manipulator
2038/002	. {Measuring axial forces of rolls}	39/32	. . Devices specially adapted for turning sheets
2038/004	. {Measuring scale thickness}	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
38/006	. {for measuring temperature}	41/00	Guiding, conveying, or accumulating easily-flexible work, e.g. wire, sheet metal bands, in loops or curves; Loop lifters
38/008	. {Monitoring or detecting vibration, chatter or chatter marks}	41/02	. Returning work to repeat the pass or passes {within the same stand}
38/02	. for measuring flatness or profile of strips	41/04	. . above or underneath the rolling stand or rolls
38/04	. for measuring thickness, width, diameter or other transverse dimensions of the product	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}
38/06	. for measuring tension or compression	41/08	. without overall change in the general direction of movement of the work
38/08	. for measuring roll-force	41/10	. . Loop deflectors {(B21B 39/084 takes precedence)}
38/10	. for measuring roll-gap, e.g. pass indicators	41/12	. Arrangements of interest only with respect to provision for indicating or controlling operations
38/105	. . {Calibrating or presetting roll-gap}	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)
38/12	. for measuring roll camber	43/003	. {Transfer to bed}
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)	43/006	. {Transfer from bed}
39/002	. {Piling, unpling, unscrambling}	43/02	. Cooling beds comprising rakes {racks, walking beams} or bars (B21B 43/10 takes precedence)
39/004	. {Transverse moving}	43/04	. Cooling beds comprising rolls or worms
39/006	. {Pinch roll sets}	43/06	. Cooling beds comprising carriages (B21B 43/08 takes precedence)
39/008	. {Rollers for roller conveyors (roller-ways in general B65G 13/00, B21B 39/00)}		
39/02	. Feeding or supporting work; Braking or tensioning arrangements, {e.g. threading arrangements}		
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)		
39/06	. . Pushing or forcing work into pass		
39/08	. . Braking or tensioning arrangements		
39/082	. . . {Bridle devices}		
39/084	. . . {Looper devices}		
39/086	. . . {Braking devices}		
39/088	. . . {Bumpers, stopping devices}		

43/08	• Cooling beds comprising revolving drums or recycling chains {or discs}	45/04	• for de-scaling, {e.g. by brushing (descaling of rod or wire B21C 43/04)}
43/10	• Cooling beds with other work-shifting elements projecting through the bed	45/06	• . of strip material (B21B 45/08 takes precedence)
43/12	• Devices for positioning workpieces "flushed", i.e. with all their axial ends arranged in line on cooling beds or on co-operating conveyors, {e.g. before cutting}	45/08	• . hydraulically
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)	47/00	Auxiliary arrangements, devices or methods in connection with rolling of multi-layer sheets of metal (soaking pits C21D 9/70)
45/002	• {Increasing friction between work and working rolls by using friction increasing substance}	47/02	• for folding sheets before rolling
45/004	• {Heating the product}	47/04	• for separating layers after rolling
2045/006	• . {in vacuum or in inert atmosphere}	99/00	Subject matter not provided for in other groups of this subclass
45/008	• {Heat shields}		
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)}		
45/0203	• . {Cooling}		
45/0206	• . . {Coolants}		
45/0209	• . . {Cooling devices, e.g. using gaseous coolants}		
2045/0212	• . . . {using gaseous coolants}		
45/0215	• . . . {using liquid coolants, e.g. for sections, for tubes}		
45/0218	• {for strips, sheets, or plates (B21B 45/023 , B21B 45/0233 take precedence)}		
2045/0221	• {for structural sections, e.g. H-beams}		
45/0224	• {for wire, rods, rounds, bars (B21B 45/023 , B21B 45/0233 take precedence)}		
2045/0227	• {for tubes}		
45/023	• {by immersion in a bath}		
45/0233	• {Spray nozzles, Nozzle headers; Spray systems}		
2045/0236	• . {Laying heads for overlapping rings on cooling conveyor}		
45/0239	• . {Lubricating}		
45/0242	• . . {Lubricants}		
45/0245	• . . {Lubricating devices}		
45/0248	• . . . {using liquid lubricants, e.g. for sections, for tubes}		
45/0251	• {for strips, sheets, or plates}		
2045/0254	• {for structural sections, e.g. H-beams}		
45/0257	• {for wire, rods, rounds, bars}		
2045/026	• {for tubes}		
45/0263	• . . . {using solid lubricants}		
45/0266	• . {Measuring or controlling thickness of liquid films}		
45/0269	• . {Cleaning}		
45/0272	• . . {Cleaning compositions}		
45/0275	• . . {Cleaning devices}		
45/0278	• . . . {removing liquids}		
45/0281	• {removing coolants}		
45/0284	• {removing lubricants}		
45/0287	• {removing solid particles, e.g. dust, rust}		
45/029	• . . {Liquid recovering devices}		
45/0293	• . . . {Recovering coolants}		
45/0296	• . . . {Recovering lubricants}		
		2201/00	Special rolling modes
		2201/02	• Austenitic rolling
		2201/04	• Ferritic rolling
		2201/06	• Thermomechanical rolling
		2201/08	• Batch rolling
		2201/10	• Endless rolling
		2201/12	• Isothermic rolling
		2201/14	• Soft reduction
		2201/16	• Two-phase or mixed-phase rolling
		2201/18	• Vertical rolling pass lines
		Equipment codes	
		2203/00	Auxiliary arrangements, devices or methods in combination with rolling mills or rolling methods
		2203/02	• Backlash elimination
		2203/04	• Brakes
		2203/06	• Cassettes
		2203/08	• Clutches
		2203/10	• Counterweights
		2203/12	• Covers or shieldings
		2203/14	• Dummy bars or slabs
		2203/16	• Eccentrics
		2203/18	• Rolls or rollers
		2203/182	• . Fluid driven rolls or rollers
		2203/185	• . Reversible rolls for changing grooves
		2203/187	• . Tilting rolls
		2203/20	• Flywheels
		2203/22	• Hinged chocks
		2203/24	• Hydrostatic bearings or guides
		2203/26	• Motors, drives
		2203/28	• Mounting or dismounting bearing and chock as a unit
		2203/30	• Quick or bayonet couplings
		2203/32	• Roll changing stools
		2203/34	• Rotational position or alignment
		2203/36	• Spacers
		2203/38	• Strain gauges
		2203/40	• Torsion bars or shafts
		2203/42	• Turntables
		2203/44	• Vibration dampers
		2205/00	Particular shaped rolled products
		2205/02	• Tailored blanks
		2205/04	• Taper- or wedge-shaped profiles
		2261/00	Product parameters
		2261/02	• Transverse dimensions
		2261/04	• . Thickness, gauge

2261/043	. . . Blanks with variable thickness in the rolling direction	2269/12	. Axial shifting the rolls
2261/046	. . . Different thickness in width direction	2269/14	. . Work rolls
2261/05	. . . Different constant thicknesses in one rolled product	2269/16	. . Intermediate rolls
2261/06	. . Width	2269/18	. . Back-up rolls
2261/065	. . . Blanks with variable width	2271/00	Mill stand parameters
2261/08	. . Diameter	2271/02	. Roll gap, screw-down position, draft position
2261/10	. . Cross-sectional area	2271/025	. . Tapered roll gap
2261/12	. Length	2271/04	. . Screw-down speed, draft speed
2261/14	. Roughness	2271/06	. Mill spring
2261/18	. Weight	2273/00	Path parameters
2261/20	. Temperature	2273/02	. Vertical deviation, e.g. slack, looper height
2261/21	. . Temperature profile	2273/04	. Lateral deviation, meandering, camber of product
2261/22	. Hardness	2273/06	. Threading
2263/00	Shape of product	2273/08	. . Threading-in or before threading-in
2263/02	. Profile, e.g. of plate, hot strip, sections	2273/10	. . Threading-out or after threading-out
2263/04	. Flatness	2273/12	. End of product
2263/06	. . Edge waves	2273/14	. . Front end or leading end
2263/08	. . Centre buckles	2273/16	. . Tail or rear end
2263/10	. Lateral spread defects	2273/18	. Presence of product
2263/12	. . Dog bone	2273/20	. Track of product
2263/16	. Alligatoring	2273/22	. Aligning on rolling axis, e.g. of roll calibers
2263/20	. End shape; fish tail; tongue	2273/24	. Web positioning
2263/30	. Shape in top view	2275/00	Mill drive parameters
2265/00	Forming parameters	2275/02	. Speed
2265/02	. Tension	2275/04	. . Roll speed
2265/04	. . Front or inlet tension	2275/05	. . . Speed difference between top and bottom rolls
2265/06	. . Interstand tension	2275/06	. . Product speed
2265/08	. . Back or outlet tension	2275/08	. . Coiler speed
2265/10	. Compression, e.g. longitudinal compression	2275/10	. Motor power; motor current
2265/12	. Rolling load or rolling pressure; roll force	2275/12	. . Roll torque
2265/14	. Reduction rate		
2265/16	. . Extension		
2265/18	. Elongation		
2265/20	. Slip		
2265/22	. Pass schedule		
2265/24	. asymmetric rolling		
2267/00	Roll parameters		
2267/02	. Roll dimensions		
2267/06	. . Roll diameter		
2267/065	. . . Top and bottom roll have different diameters; Asymmetrical rolling		
2267/08	. . Roll eccentricity		
2267/10	. Roughness of roll surface		
2267/12	. Roll temperature		
2267/18	. Roll crown; roll profile		
2267/19	. . Thermal crown		
2267/20	. . Ground camber or profile		
2267/22	. . Hydraulic expansion of rolls		
2267/24	. Roll wear		
2267/26	. Hardness of the roll surface		
2267/28	. Elastic moduli of rolls		
2269/00	Roll bending or shifting		
2269/02	. Roll bending; vertical bending of rolls		
2269/04	. . Work roll bending		
2269/06	. . Intermediate roll bending		
2269/08	. . Back-up roll bending		
2269/10	. Horizontal bending of rolls		