

The invention relates to metallurgy and can be used within the equipment of vertical machine of continuous casting. Is disclosed a method of centering the starting bar in the area of vertical withdrawal-roll set, in which after passage by forward section of the starting bar of last rolls of withdrawal-roll set the starting bar is stopped placing its triangular groove opposite the axis of cylindrical driving pin, and the pin is introduced into the triangular groove. The pairs of rolls are rotated in opposite direction and the starting bar is displaced to the contact of the surfaces of its triangular groove with cylindrical surface of pin. The drives of rotation of the rolls of withdrawal-roll set are switched off, the pairs of rolls are moved apart the starting bar is moved by centering devices located in the lower part of its withdrawal-roll set up to the alignment of its axis with vertical axis of the withdrawal-roll set. Pairs of rolls are brought together, their drives of rotation are switched on and the starting bar is moved upward and cylindrical pin is displaced from the groove of the starting bar. The area of vertical withdrawal-roll set is characterized by the presence of support with driving cylindrical pin made with possibility of axial displacement and located over the axis of the withdrawal-roll set, in horizontal plane perpendicular to the axes of the rolls of withdrawal-roll set. One of mentioned grooves of the forward section of the body of the starting bar is made in the form of a triangle, which apex is directed toward the head of the starting bar, and the bisectors of angle with this apex coincide with the axis of the starting bar. The technical result is in increase of service life and reliability of the equipment of the section of vertical withdrawal-roll set.