cles produced during the in-bed attrition lie in the range of from 5 kN/m^2 to 70 kN/m^2, in particular 7 kN/m^2 to 20 kN/m^2.

3. Method according to claim 1 or 2,
characterised in that
the grinding bed height (s) is controlled to a maximum of 8% of the grinding pan diameter.

4. Method according to one of claims 1 to 3,
characterised in that
the grinding bed height (s) is controlled to approximately 4% of the grinding pan diameter.

5. Method according to one of claims 1 to 4,
characterised in that
with a required pressing force (F_W) the grinding bed height (s) is adjusted by means of a feed mass flow ($m_{m,in}$), a grinding pan speed (n_s), a height (h) of a retention rim of the grinding pan (31) and / or an inner circulating flow.

~~6. Method according to one of claims 1 to 4,~~
~~characterised in that~~
~~if the material bonding of the multi-substance system is increased the pressing force (F_W) is increased in order to achieve the in-bed attrition, wherein the feed mass flow ($m_{m,in}$) is increased, the height (h) of the retention rim is increased, the inner circulating flow is increased and / or the grinding pan speed (n_s) is reduced in order to maintain a grinding bed height (s).~~

~~7. Method according to one of claims 1 to 6,~~
~~characterised in that~~
~~the feed mass flow ($m_{m,in}$) is increased in order to increase the throughput, wherein the grinding pan speed (n_s) is increased in order to maintain a grinding bed height (s).~~

8. Method according to one of claims 1 to 7,
characterised in that

the roller mill (30) is operated during start-up with a higher pressing force (F_W) of the grinding rollers (31) than the pressing force (F_W) selected during operation.

~~9. Method according to one of claims 1 to 8,~~
~~characterised in that~~
~~the rotation of the grinding rollers (31) is monitored during operation, and~~
~~the pressing force (F_W) of the grinding rollers (31) is increased at least over time if a rotation of the grinding rollers (31) that is too low is ascertained.~~

10. Method according to one of claims 1 to 9,
characterised in that
the roller mill (30) is operated in an over-running and / or air stream mode.

11. Method according to one of claims 1 to 10,
characterised in that
crushed concrete comprising grit, sand and cement stone is fed as material, and grit and sand are separated from each other and from cement stone by means of the in-bed attrition.

12. Method according to claim 11,
characterised in that
a vertical roller mill with a classifier (34) is used,
a process air stream is adjusted in such a way that cement stone and at least in part compounds of cement stone and sand from the over-running grinding material are transported by means of the process air stream to the classifier (34), and grit and sand are removed from the grinding process as coarse material, comminuted cement stone is removed from the grinding process as fines at the classifier (34), and cement stone as well as compounds of cement stone and sand are rejected by the classifier (34) and fed back to the grinding pan (32), and
sand is separated from the discharged coarse material by means of screening.

13. Vertical roller mill,
with a rotatable grinding pan (32), on which a grinding bed (41) of grinding material (42) is formed during operation,
with at least two stationary, rotatable grinding rollers (31) which roll on the grinding

cles produced during the in-bed attrition lie in the range of from 5 kN/m^2 to 70 kN/m^2, in particular 7 kN/m^2 to 20 kN/m^2.

3. Method according to claim 1 or 2,
characterised in that
the grinding bed height (s) is controlled to a maximum of 8% of the grinding pan diameter.

4. Method according to one of claims 1 to 3,
characterised in that
the grinding bed height (s) is controlled to approximately 4% of the grinding pan diameter.

5. Method according to one of claims 1 to 4,
characterised in that
with a required pressing force (F_W) the grinding bed height (s) is adjusted by means of a feed mass flow ($m_{m,in}$), a grinding pan speed (n_s), a height (h) of a retention rim of the grinding pan (31) and / or an inner circulating flow.

6. Method according to one of claims 1 to 4,
characterised in that
if the material bonding of the multi-substance system is increased the pressing force (F_W) is increased in order to achieve the in-bed attrition, wherein a feed mass flow ($m_{m,in}$) is increased, a height (h) of the retention rim is increased, an inner circulating flow is increased and / or a grinding pan speed (n_s) is reduced in order to maintain a grinding bed height (s).

7. Method according to one of claims 1 to 6,
characterised in that
a feed mass flow ($m_{m,in}$) is increased in order to increase a throughput, wherein a grinding pan speed (n_s) is increased in order to maintain a grinding bed height (s).

8. Method according to one of claims 1 to 7,
characterised in that

the roller mill (30) is operated during start-up with a higher pressing force (F_W) of the grinding rollers (31) than the pressing force (F_W) selected during operation.

9. Method according to one of claims 1 to 8,
characterised in that
the rotation of the grinding rollers (31) is monitored during operation, and
the pressing force (F_W) of the grinding rollers (31) is increased at least over time if a peripheral speed of the roller is lower than 50% of the speed of the material flow under the roller is ascertained.

10. Method according to one of claims 1 to 9,
characterised in that
the roller mill (30) is operated in an over-running and / or air stream mode.

11. Method according to one of claims 1 to 10,
characterised in that
crushed concrete comprising grit, sand and cement stone is fed as material, and grit and sand are separated from each other and from cement stone by means of the in-bed attrition.

12. Method according to claim 11,
characterised in that
a vertical roller mill with a classifier (34) is used,
a process air stream is adjusted in such a way that cement stone and at least in part compounds of cement stone and sand from the over-running grinding material are transported by means of the process air stream to the classifier (34), and grit and sand are removed from the grinding process as coarse material, comminuted cement stone is removed from the grinding process as fines at the classifier (34), and cement stone as well as compounds of cement stone and sand are rejected by the classifier (34) and fed back to the grinding pan (32), and
sand is separated from the discharged coarse material by means of screening.

13. Vertical roller mill,
with a rotatable grinding pan (32), on which a grinding bed (41) of grinding material (42) is formed during operation,
with at least two stationary, rotatable grinding rollers (31) which roll on the grinding