

Title (en)

Methods and devices for rolling-in tubes coated on the interior.

Title (de)

Verfahren und Einrichtungen zum Einwalzen von innenseitig beschichteten Rohren.

Title (fr)

Procédé et dispositifs de dudgeonnage de tubes revêtus à l'intérieur.

Publication

EP 0028809 A1 19810520 (DE)

Application

EP 80106822 A 19801105

Priority

DE 2945085 A 19791108

Abstract (en)

1. Process for rolling-in a tube (4) coated in the interior with a plastic protective film (3) into a bore (1) associated to said tube (4) ; the diameter of said bore (1) being larger than the outside diameter of the tube (4) ; the tube (4) is introduced with its end to be rolled-in into the bore (1) ; a metallic, cylindrical sleeve (6) is inserted into the tube end to be rolled-in and is expanded and rolled-in together with the tube (4) over part of its end by a rotatable rolling-in tool (8) by means of rolling-in rolls (7) arranged over the circumference of said tool ; said sleeve (6) is subsequently removed from the tube (4), characterized a) in that the sleeve (6) is longer than the rolling-in rolls (7), b) in that the sleeve (6) is expanded only over part of its length, c) in that a drawing-out device (15), supported and centred with small tolerances by means of a mandrel (14) is introduced into the end of the sleeve (6) that is not expanded, d) in that the sleeve (6) is removed out of the tube (4) together with the drawing-out device.

Abstract (de)

Das Verfahren dient zum Einwalzen von innenseitig mit einer plastischen Schutzschicht (3) beschichteten metallischen Rohren (4) in eine Bohrung (1) eines Rohrbodens (2) eines Wärmetauschers. Um eine Beschädigung der plastischen Schutzschicht (3) zu vermeiden, wird eine besondere Hülse (6) verwendet, die nach dem Einwalzen mit besonderen Werkzeugen (14, 15 und 16 bzw. 20 und 21) entfernt wird.

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B21D 39/06 (2006.01)

CPC (source: EP)

B21D 39/06 (2013.01)

Citation (search report)

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