

Title (en)  
METHODS AND DEVICES FOR ROLLING-IN TUBES COATED ON THE INTERIOR

Publication  
**EP 0028809 B1 19850612 (DE)**

Application  
**EP 80106822 A 19801105**

Priority  
DE 2945085 A 19791108

Abstract (en)  
[origin: EP0028809A1] 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.

IPC 1-7  
**B21D 39/06**

IPC 8 full level  
**B21D 39/06** (2006.01)

CPC (source: EP)  
**B21D 39/06** (2013.01)

Cited by  
EP0191663A3; FR2609330A2; FR2592147A1; EP0232527A1; US4735263A; US8918982B2; WO2008106911A1

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