

Title (en)

AUTOMATIC CONTROL METHOD OF ROLL TYPE PIPE CORRECTION MACHINE

Title (de)

AUTOMATISCHES STEUERVERFAHREN FÜR WALZEN-KORREKTURMASCHINE FÜR ROHRE

Title (fr)

PROCEDE DE COMMANDE AUTOMATIQUE DE MACHINE DE CORRECTION DE TUYAU A ROULEAU

Publication

**EP 1870174 A1 20071226 (EN)**

Application

**EP 06730626 A 20060330**

Priority

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- JP 2005101518 A 20050331

Abstract (en)

An automatic control method for a roll-type pipe straightener which can obtain a stable straightening effect is provided. When crushing a pipe using a straightener having at least three stands each having a pair of grooved rolls to perform straightening, automatic control is performed by first through fourth steps. First step: The relationship between the set value of the offset and the amount of bending of a pipe measured on the exit side of the straightener is previously calculated. Second step: The amount of bending of a pipe on the exit side of the straightener is measured. Third step: When the amount of bending measured in the second step is outside a target range, the amount of change of the offset to put the amount of bending of the pipe on the exit side of the straightener into the target range is calculated based on the relationship calculated in the first step. Fourth step: The set value of the offset when straightening the next pipe is determined based on the amount of change of the offset calculated in the third step.

IPC 8 full level

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