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54 Standard line plant for the surface treatment of preheating, brushing, painting, drying and marking of metallic tubes.

57 A standard line plant for the surface treatment of preheating, brushing, painting, drying and marking of metallic tubes, comprising a loading conveyor by means of transversal translation (CT1), after a weighing station (S), which conveyor (CT1) transfers a set of tubes in a predetermine number transversally with loading step by step, one after the other, a determinate number of tubes on an orthogonal line conveyor (R1) formed by a plurality of transversal motorized rollers independently movable on a frame from the bottom upward and from under the translation line (CT1) on the same line to take said set of tubes and

set them along the treatment line where are installed: a data checking and detecting station (CRD) to automatically control the plant according to the tube number and size, a station of preheating, with upper and lower burners, and cooling (R2-H); a surface treatment station with brushing in contraposition and blowing equipment (R3-SG); a following double cabin painting station (P), a following drying station (R4-E); a marking station (M) and an unloading station (R5-CT2) set up and functionally structured as the loading one, being the painting transport with cross slides instead of rollers (Figure 1).

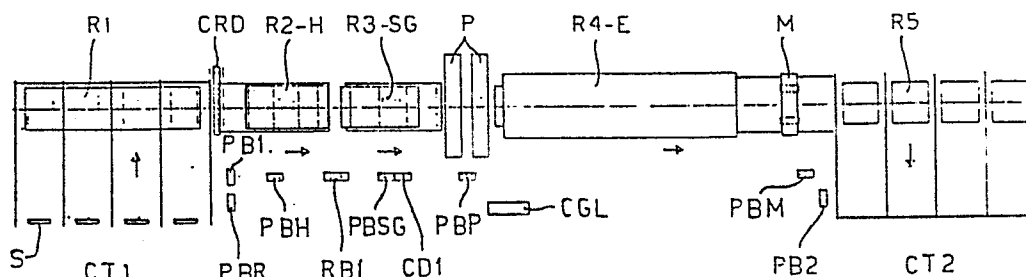


FIG 1



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EUROPEAN SEARCH REPORT

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EP 82 83 0247

DOCUMENTS CONSIDERED TO BE RELEVANT			
Category	Citation of document with indication, where appropriate, of relevant passages	Relevant to claim	CLASSIFICATION OF THE APPLICATION (Int. Cl. 3)
A	US-A-2 794 448 (MARANTZ) * whole document *	1-11	B 05 B 13/00
A	--- US-A-4 173 198 (ALLEN) * whole document and especially column 3, lines 15-21; column 5, lines 3-19 *	1,5,10,11	
A	--- US-A-3 134 476 (PIERSON) * column 3, lines 13-56; claim 1; figures 1,2 *	1,3	
A	--- US-A-4 096 300 (WILLIAM) -----		
The present search report has been drawn up for all claims			TECHNICAL FIELDS SEARCHED (Int. Cl. 3)
			B 05 B B 05 C B 23 Q B 65 G
Place of search THE HAGUE		Date of completion of the search 01-11-1984	Examiner WELSCH H.R.
CATEGORY OF CITED DOCUMENTS			
X : particularly relevant if taken alone Y : particularly relevant if combined with another document of the same category A : technological background O : non-written disclosure P : intermediate document		T : theory or principle underlying the invention E : earlier patent document, but published on, or after the filing date D : document cited in the application L : document cited for other reasons & : member of the same patent family, corresponding document	