

METHOD AND DEVICE FOR MANUFACTURING SMALL-DIAMETER METAL TUBES

ABSTRACT OF DISCLOSURE

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The present invention enables manufacturing small-diameter metal tubes with high accuracy and high production efficiency by using a roll having large diameter comprising rolls each having clearly a larger outside diameter than an outside diameter of a metal tube to be manufactured. A metal band is formed into a cylindrical shape
10 through a single stand by using a pair of large-diameter side rolls designed to have an outside diameter ratio, ϕ_2/ϕ_1 , of 10 or more, preferably 25 or more, between an outside diameter ϕ_1 of the metal tube to be manufactured and an outside diameter ϕ_2 of the forming rolls, and thereafter the edge parts of the metal band are butted and welded. The roll having a large diameter based on a three-sided roll system or four-sided roll
15 system may be used.

Figure 1 accompanies the abstract.