

ABSTRACT

The invention relates to a rolling machine for processing a metal container with a longitudinal seam, in particular a sheet steel container, in which a cylindrical body
5 is bent from a flat metal plate and has adjacent or overlapping butt edges which are securely joined to one another by folding or welding, whereupon a disk-shaped lower bottom and, optionally, a respective upper bottom, is welded or folded with the cylindrical body (= intermediate product) to a closed or to an open-topped container. The problem of conventional steel drums resides in the fact that the
10 inside welding seam edge is oftentimes cause for premature rust formation and contamination of the contents.

Conventional rolling machines have the drawback that the cantilevered arm supporting the rolling drum is subject to great forces and disadvantageous bending stress.

15 In accordance with the present invention, the rolling process is implemented in a continuous rolling machine (18) in which a body 912) is charged in the one station (= loading position A) and a finished body (12) is discharged at the same time in the other station (= unloading position B). The upper inner roll carrier part (26) is hereby supported at a central location. During the rolling process, the rolling
20 machine is supported externally. The particular feature of this continuous rolling machine (18) is thus the so-called "alternating floating" support of the upper roll carrier part, i.e. it is equipped with an alternating central and external lock or securing support.