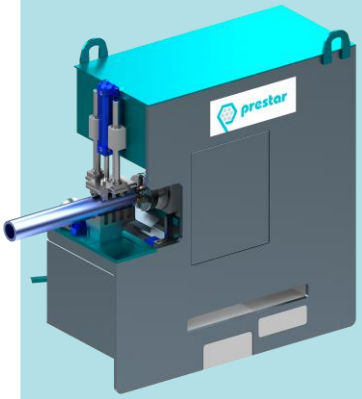
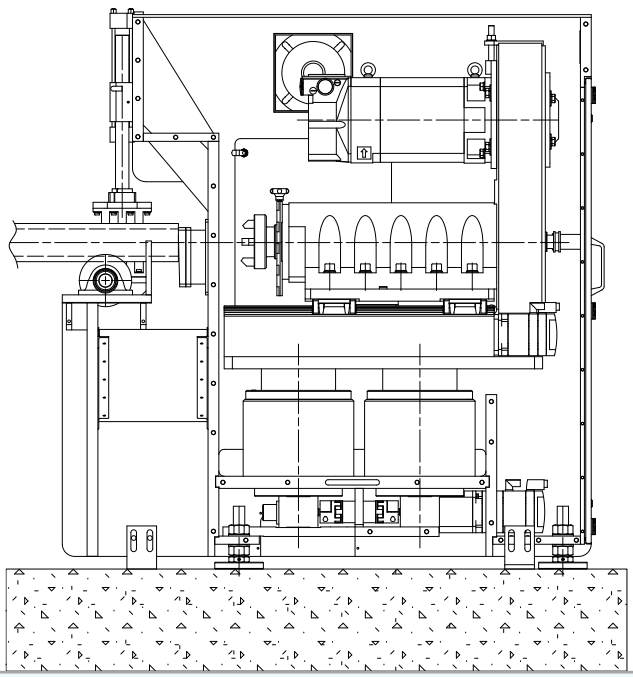
MODIFICATION OF PIPE ENDS AFTER CUTTING

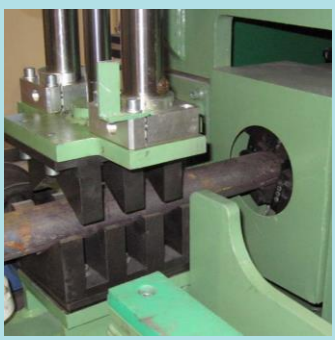
After cutting the pipes on circular saws, the following is used to adjust the ends of the pipes:

Bevelling of pipe ends



Bevelling of edges due to the preparation of pipe ends for welding. Chamfer ranges are 2 – 10 mm x 30, 45 or 60 degrees.
To chamfer the edges, the chuck is equipped with two to three clamped knives with changeable plates. In one take the outer edge, the inner edge are chamfered, and the face of the pipe is aligned.
Hydraulic cylinders must be used to clamp the pipes. The pipe must always be centred in the anti-chuck axis





Chamfering

These are smaller diameters of pipes. The pipe arrives at the stop to establish the position, and then is moved to the bevelling position. A chamfering head arrives at the pipe

MODIFICATION OF PIPE ENDS AFTER CUTTING



Brushing pipe ends

After cutting on saws, there is a requirement to remove burrs after cutting and removing sharp edges
Brushing of the ends takes place continuously when the tube is stopped

a. Continuous brushing – around the rotating steel brush (e.g. OD 300 mm, L- 450 mm) are moved around the brushes using transverse carriers. The distance between the two brushes at the end corresponds to the length of the pipes. When passing by the brushes, the pipes rotate spontaneously and they are cleaned.

This continuous brushing is possible only with the same length of pipes in the entire processed package of pipes. When changing the lengths of the pipes, the distance of two opposite brushes is repositioned from the control panel

b. With the pipe not moving - the pipe is aligned with its ends to the stop, which corresponds to the position of the edge of the brush. From this position, the pipe is moved just in front of the brush. The pipe is clamped between the rollers, which allow the pipe to rotate and at the same time prevent the pipe from being pushed away. The brush is moved around the pipe using a pneumatic cylinder in the length of 300 mm back and forth. By moving the brush, the tubes rotate and are brushed evenly around the circumference.

Both methods are used to brush both the outer and inner edges of the pipe
When the brush wears, operator manually moves the brush according to the measuring ruler back into the frame.

For larger sizes of brushed pipes, it is necessary to set the brush higher so that the axis of the brush corresponds to the axis of the tube.