

[54] **PRODUCTION OF INTERMITTENTLY FLUTED TUBES**

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[58] Field of Search..... **72/283, 276, 75; 29/157.4; 113/118 R, 118 A**

[57] **ABSTRACT**

A fluted mandrel is movable axially within the tube which is drawn through a fluting die, the ridges of the fluted mandrel being aligned with the valleys formed by the fluted die. In one axial position of the mandrel, where it is fully within the die, its ridges and valleys are radially opposite the valleys and ridges, respectively, of the die, whereby the tube is fluted internally and externally as it is drawn through the die. However, when the mandrel is withdrawn axially from this fluting position and the tube moves through the die, the tube-fluting operation is interrupted and the die merely forms shallow impressions in the external surface of the tube.

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4 Claims, 9 Drawing Figures

