

Line for preparing the sleeve for rolling includes a roller conveyor section with driven rollers, equipped with four telescopic guides, a wedge-screw mechanism for raising or lowering it, a mechanism for rotating the sleeve around its axis by an angle of 45° , a four-die forging press, between the dies of which a mandrel is placed, which is inserted and removed by a hydraulic cylinder, and a guide support for holding the mandrel on the press axis. Wherein, it also includes a device for blowing scale off the inner surface of the sleeve, consisting of a removable hollow nozzle with a circular slit-nozzle for the exit of a fan-shaped jet of compressed air, located inside the hollow press mandrel. The mandrel is connected to a source of compressed air, and the angle of inclination of the air jets relative to the inner surface of the sleeve is 25° - 35° .