

Method of manufacturing a helical blank, in which air-plasma through-cutting of the wall of a hollow blank is performed along a helical line using an air-plasma jet until an initial helical blank is formed, one end of which is joined to the uncut portion of the hollow blank. Simultaneously with the air-plasma cutting of the hollow blank, asymmetric upsetting of the initial helical blank is performed across the width of its coil, between two rolls rotating about their own axes, until a flat ring-shaped section is formed at the roll output, which is bent to form a helical blank.