

Title (en)
Method for the manufacture of a flat radiator.

Title (de)
Verfahren zur Herstellung eines Flachheizkörper.

Title (fr)
Procédé pour la construction d'un radiateur plat.

Publication
EP 0162271 A2 19851127 (DE)

Application
EP 85104469 A 19850412

Priority
DE 3418316 A 19840517

Abstract (en)
1. A method of production of a flat heater unit having a front wall and a rear wall between which are formed a flow (2) and a return (3) as well as channels (1) arranged in parallel with one another between the flow (2) and the return (3) and separated from one another by stiffening corrugations (4), and having connections (5) to the flow (2) and the return (3) in the front wall and/or the rear wall, the front wall and the rear wall being formed from the same metal sheet welded into two sheetmetal parts stamped with mirror symmetry and folded, characterized in that a metal sheet is corrugated, stamped and cut to length into the sheetmetal parts (7 ; 8) formed with mirror symmetry and furthermore holes are cut in it, that the sheetmetal parts (7 ; 8) are folded into the front wall and the rear wall to lie against one another and so form the flow (2), the return (3) and the channels (1) by the stiffening corrugations (4) and a flange (9) bounding the return (3) on the outside, that the connections (5) are welded round the holes, that the flow (2) and the return (3) are closed off at their ends by in each case bending the one sheetmetal part (7 ; 8) in the direction of the other sheetmetal part (8 ; 7) and that in the case of the flow (2) the sheetmetal parts (7 ; 8) bent together and in the case of the return (3) the flanges (9) and furthermore the stiffening corrugations (4) are all respectively welded.

Abstract (de)
Vorderwand und Rückwand des Flachheizkörpers sind durch je ein profiliertes Blechteil (7; 8) gebildet. Der Flachheizkörper ist mit einem Vorlauf (2) sowie einem Rücklauf (3) und mit durch Sicken (4) voneinander getrennten Kanälen (1) zwischen Vorlauf (2) und Rücklauf (3) versehen. An Vorlauf (2) und Rücklauf (3) sind Anschlüsse (5) für Zu- und Abfuhr des Heizmediums vorgesehen. Jedes profilierte Blechteil (7; 8) ist an den Enden des Vorlaufs (2) und des Rücklaufs (3) in Richtung des anderen Blechteils (8; 7) gebogen und mit ihm durch eine Rundnaht (10) verschweißt.

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F28D 1/02; F28F 3/12

IPC 8 full level
F28D 1/02 (2006.01); **F28D 1/03** (2006.01); **F28F 3/12** (2006.01); **F28F 9/26** (2006.01)

CPC (source: EP)
F28D 1/0325 (2013.01); **F28F 9/262** (2013.01); **F28D 2021/0035** (2013.01)

Cited by
ES2144919A1; US5837096A; CN105874277A; WO2015092517A1

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