

Title (en)
METHOD FOR THE MANUFACTURE OF A FLAT RADIATOR

Publication
EP 0162271 B1 19880713 (DE)

Application
EP 85104469 A 19850412

Priority
DE 3418316 A 19840517

Abstract (en)
[origin: EP0162271A2] 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.

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IPC 8 full level
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CPC (source: EP)
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Cited by
US5837096A; CN105874277A; ES2144919A1; WO2015092517A1

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