

Title (en)  
METHOD AND INSTALLATION FOR PRODUCTION OF SPACER FRAMES

Publication  
**EP 0435076 B1 19930421 (DE)**

Application  
**EP 90123966 A 19901212**

Priority  
DE 3942808 A 19891223

Abstract (en)  
[origin: EP0435076A1] In order to produce a spacer frame (2) containing a drying agent (1) for insulating glass panes, a hollow profile (3), which is initially free of drying agent, is bent several times to form the frame corners, but is left open at the final corner. Subsequently one, or appropriately both frame legs (5 and 7) leading to this open point can be filled with drying agent (1) and the frame (2) then finally closed. The frame leg (5) to be bent to form the final closure is first completely filled with drying agent, subsequently emptied from its still open front end (10) up to or beyond the bending area (12) and then bent over, so that no drying agent can hinder this final bending operation, and then connected by its open front end (10) to the other open frame leg (7). Thus, despite the fact that the frame is filled with drying agent, the bending operations are not hindered by drying agent. Even so, a very simple installation for carrying out this method is possible, because the hollow profile (3) can be removed from the filling device (8) after filling the still open frame legs and can be placed in the bending device; this may be the same bending device (13) which also carried out the previous bending operations. The emptying process up to the final bending area can be achieved with a combined sucking and blowing device, and carried out without the risk of removing too much drying agent (Fig. 5). <IMAGE>

IPC 1-7  
**E06B 3/66**

IPC 8 full level  
**E06B 3/66** (2006.01); **E06B 3/673** (2006.01)

CPC (source: EP)  
**E06B 3/67317** (2013.01); **E06B 3/67313** (2013.01)

Cited by  
US5390406A; AT410909B; US6619098B2; WO2020070245A1; WO9210635A1

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