

Title (en)

Process and apparatus for manufacturing heat exchangers.

Title (de)

Verfahren und Anlage zur Herstellung von Wärmetauschern.

Title (fr)

Procédé et dispositif pour la fabrication d'échangeurs de chaleur.

Publication

**EP 0478507 B1 19950329 (DE)**

Application

**EP 91810765 A 19910927**

Priority

CH 313490 A 19900928

Abstract (en)

[origin: EP0478507A1] Tubes (9) are inserted into a pack of heat-exchanger plates (1) and then in each case widened by introducing an expanding mandrel (10, 11), pressed against the plates and joined to the latter. During the widening, the expanding mandrels (10, 11) are introduced from one side into the tubes (9), while the opposite tube ends are supported on a common supporting plate (12) which is moved at a given speed towards the expanding mandrels (10, 11) opposite to the passing-through direction thereof. During the widening, the tubes (9) are put under pre-pressure and a shortening of all tubes to the same length is necessarily obtained. At the same time, displacement of heat-exchanger plates (1) during the widening is avoided. <IMAGE>

IPC 1-7

**B21D 53/08**; F28F 1/32

IPC 8 full level

**B21D 53/08** (2006.01)

CPC (source: EP)

**B21D 53/085** (2013.01)

Cited by

CZ301687B6; GB2415156A; WO2004087348A1

Designated contracting state (EPC)

DE FR GB IT

DOCDB simple family (publication)

**EP 0478507 A1 19920401**; **EP 0478507 B1 19950329**; CH 681565 A5 19930415; DE 59105043 D1 19950504

DOCDB simple family (application)

**EP 91810765 A 19910927**; CH 313490 A 19900928; DE 59105043 T 19910927