

Title (en)  
ASSEMBLY LINE FOR PRODUCING STEEL COFFERS FOR CEILING AND/WALL CONSTRUCTIONS FROM SHEET METAL PLATES

Title (de)  
FERTIGUNGSSTRASSE ZUR HERSTELLUNG EINER STAHLKASSETTE FÜR DECKEN- UND/ODER WANDKONSTRUKTIONEN AUS EINER BLECHTAFEL

Title (fr)  
CHAÎNE DE PRODUCTION POUR LA FABRICATION D'UN CAISSON METALLIQUE POUR DES CONSTRUCTIONS DE PLAFONDS ET/OU DE MURS RÉALISÉES À PARTIR DE PLAQUES DE TÔLE

Publication  
**EP 0603366 B1 19981223 (DE)**

Application  
**EP 93914733 A 19930626**

Priority  
• DE 4222741 A 19920710  
• EP 9301640 W 19930626

Abstract (en)  
[origin: US5528818A] PCT No. PCT/EP93/01640 Sec. 371 Date Aug. 2, 1994 Sec. 102(e) Date Aug. 2, 1994 PCT Filed Jun. 26, 1993 PCT Pub. No. WO94/01234 PCT Pub. Date Jan. 20, 1994. The assembly line for producing a steel coffer (2) for ceiling and/or wall structures, in particular for interior finishing and construction of ships, for transportable and movable buildings, for sheds, hotels and the like, from a sheet metal plate (1) comprises a cutting and/or stamping station (3), a bending press (4) with an associated manipulator (5) and an associated roller-ball table (6) and a welding station (7), as well as at least one trolley (8) in the form of an underfloor vehicle, an underfloor trolley, or the like, which can move back and forth under these stations (3, 5, 7). The bending press (4) is combined with a manipulator (5) designed as a semi-portal crane, which is movable with respect to this press (4) and has a gripper which is also movable, adjustable in height and rotatable around the height axis, by means of which the sheet metal plate (1) is fed in its required positions to the bending press (4). The bending press (4) has a hold-down device which can be swiveled to compensate various sheet metal thicknesses.

IPC 1-7  
**B21D 43/10**; **B21D 43/12**; **B21D 43/02**; **B21D 5/04**

IPC 8 full level  
**B21D 43/10** (2006.01); **B21D 5/04** (2006.01); **B21D 28/00** (2006.01); **B21D 43/00** (2006.01); **B21D 43/02** (2006.01); **B21D 43/12** (2006.01); **B21D 53/00** (2006.01)

CPC (source: EP US)  
**B21D 5/042** (2013.01 - EP US); **B21D 28/00** (2013.01 - EP US); **B21D 43/00** (2013.01 - EP US); **B21D 53/00** (2013.01 - EP US); **Y10T 29/5137** (2015.01 - EP US); **Y10T 29/5143** (2015.01 - EP US)

Cited by  
CN116652615A; DE10314517A1

Designated contracting state (EPC)  
AT BE CH DE DK ES FR GB GR IE IT LI LU MC NL PT SE

DOCDB simple family (publication)  
**US 5528818 A 19960625**; AT E174824 T1 19990115; AU 4501093 A 19940131; DE 59309246 D1 19990204; EP 0603366 A1 19940629; EP 0603366 B1 19981223; ES 2126650 T3 19990401; JP H06510487 A 19941124; KR 100323307 B1 20021130; RU 2110349 C1 19980510; WO 9401234 A2 19940120; WO 9401234 A3 19940331

DOCDB simple family (application)  
**US 20426294 A 19940802**; AT 93914733 T 19930626; AU 4501093 A 19930626; DE 59309246 T 19930626; EP 9301640 W 19930626; EP 93914733 A 19930626; ES 93914733 T 19930626; JP 50288394 A 19930626; KR 19940700754 A 19940308; RU 94019481 A 19930626