

Title (en)

A method for producing head element for heaters and the element obtained by the method

Title (de)

Verfahren zur Herstellung eines Sammelkastenelements für Radiatoren und Sammelkastenelement.

Title (fr)

Procédé de fabrication d'un élément d'une boîte collectrice d'un radiateur et élément de la boîte collectrice

Publication

**EP 1918669 A1 20080507 (EN)**

Application

**EP 06123275 A 20061031**

Priority

EP 06123275 A 20061031

Abstract (en)

According to a method for producing head elements for heaters, a piece of sheet metal (1) is deep drawn and cut along the edge (9) of an open side (6) to obtain a hollow body (8) with larger and narrower sides (4,5,14,15) with an aperture (12) on each opposite larger side (4,5). Notches (16, 46, 56) are made on the opposite large sides (4,5), and then three cores (18) are introduced through the edge (9), so that the edges (17, 47, 57) are press-shaped around the cores (18) so as to close the sheet metal (1) around the cores (18). After the cores (18) have been removed, a welding is made along the notch edges (17, 47, 57) thus obtaining tubular extensions (13) separated from each other.

IPC 8 full level

**F28F 9/02** (2006.01); **F28D 1/053** (2006.01); **F28F 9/26** (2006.01); **F28F 21/08** (2006.01)

CPC (source: EP)

**F28D 1/05308** (2013.01); **F28F 9/0221** (2013.01); **F28F 9/266** (2013.01); **F28F 9/268** (2013.01); **F28F 21/088** (2013.01)

Citation (search report)

- [A] FR 966689 A 19501016
- [A] FR 1349270 A 19640117 - FORGES & ATELIERS DU PLAT DE G
- [DA] WO 02101311 A1 20021219 - LOLLI VALTER [IT]

Cited by

EP3062051A1; CN101907288A; ITUB20152240A1

Designated contracting state (EPC)

CZ HU SK

Designated extension state (EPC)

AL BA HR MK RS

DOCDB simple family (publication)

**EP 1918669 A1 20080507; EP 1918669 B1 20090506**

DOCDB simple family (application)

**EP 06123275 A 20061031**