

Title (en)

METHOD FOR MAKING A SHELF COLUMN AND A SHELF COLUMN

Title (de)

VERFAHREN ZUR HERSTELLUNG EINER REGALSÄULE UND REGALSÄULE

Title (fr)

PROCÉDÉ PERMETTANT DE RÉALISER UNE COLONNE À ÉTAGÈRES ET COLONNE À ÉTAGÈRES

Publication

**EP 2035161 B1 20130918 (EN)**

Application

**EP 06764439 A 20060619**

Priority

FI 2006000213 W 20060619

Abstract (en)

[origin: WO2008003813A1] The invention relates to a method for making a shelf column in which method a shelf column (17) mainly T-shaped in cross section and including a flange plate (2) and mainly perpendicular to it a web plate (3) and the necessary fastening openings (4) and/or holes (5, 6) for whereby to fasten the other shelf parts (18, 19) to the shelf column, which is made of a band thin metal sheet (1) using sheet technical methods and in which method the edges of the thin metal sheet (1) are at least partly bent double with other parts of the sheet and such that when the bending has been completed the cross section of the thin metal sheet is mainly T-shaped and in which method a form joint (7) is formed between the edges of the band of thin metal sheet (1) in order to fasten the edges to each other. The method in accordance with the invention is characterised in that the form joint (7) is formed by bending locking bends (8, 9) into the edges of the band of thin metal sheet (1), these locking bends. being bent to oppose each other in conjunction with the bending of the T profile of the shelf column (17) and the locking bends are fitted at least partly within each other and locked to each other. The invention also relates to a shelf column (17) manufactured in accordance with a method in accordance with the invention, the said shelf column including a form joint (7) formed between the edges of the band of thin metal sheet.

IPC 8 full level

**A47B 96/14** (2006.01); **B21D 5/06** (2006.01); **B21D 5/08** (2006.01); **B21D 39/02** (2006.01)

CPC (source: EP)

**A47B 96/1408** (2013.01); **B21D 5/08** (2013.01); **B21D 39/02** (2013.01)

Designated contracting state (EPC)

AT BE BG CH CY CZ DE DK EE ES FI FR GB GR HU IE IS IT LI LT LU LV MC NL PL PT RO SE SI SK TR

Designated extension state (EPC)

HR

DOCDB simple family (publication)

**WO 2008003813 A1 20080110**; EP 2035161 A1 20090318; EP 2035161 A4 20130313; EP 2035161 B1 20130918

DOCDB simple family (application)

**FI 2006000213 W 20060619**; EP 06764439 A 20060619