Title (en)
BENDING WORK METHOD FOR HEAT EXCHANGER AND HEAT EXCHANGER

Title (de)
BIEGEBEARBEITUNGSVERFAHREN FÜR EINEN WÄRMETAUSCHER UND WÄRMETAUSCHER

Title (fr)
PROCÉDÉ DE PLIAGE POUR ÉCHANGEUR DE CHALEUR ET ÉCHANGEUR DE CHALEUR

Publication
EP 2599565 A1 20130605 (EN)

Application
EP 11812360 A 20110721

Priority
- JP 2010172363 A 20100730
- JP 2011066538 W 20110721

Abstract (en)
To suppress projecting sections of heat transfer fins from buckling in a heat exchanger bending method that performs bending by pressing a flat panel-like heat exchanger, in which heat transfer fins and heat transfer tubes are arranged with parts of the heat transfer fins projecting in a direction orthogonal to a lengthwise direction of the heat transfer tubes, against a bending die in such a way as to wrap the heat exchanger around the bending die. An outdoor heat exchanger (7) bending method employs, as a bending die (55), a bending die having a curved surface (58) whose bend radius changes in such a way as to become smaller from a starting point to an end point of the bending of the outdoor heat exchanger (7). The curved surface (58) has a first curved surface (61), which is positioned near the starting point and has a bend radius that is large, and a main curved surface (62), which is positioned near the end point and has a bend radius that is smaller than that of the first curved surface (61). At the time of the start of the bending, this bending method performs a first step of pressing projecting sections of the heat transfer fins (21) against the first curved surface (61), and after the first step, the bending method performs a main step of pressing the projecting sections of the heat transfer fins (21) against the main curved surface (62).

IPC 8 full level
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CPC (source: EP)
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AU2013247864B2; US11644244B2

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