

Title (en)
Metal roofing sheets and the method of their manufacture

Title (de)
Metalleindeckbleche und Verfahren zu deren Herstellung

Title (fr)
Feuilles de couverture métallique et procédé de leur fabrication

Publication
EP 2824252 B1 20181107 (EN)

Application
EP 14460018 A 20140321

Priority
PL 40405313 A 20130524

Abstract (en)
[origin: EP2824252A1] The method of manufacture of metal roofing sheets is characterized by the fact that the unwound metal sheet is moulded from one edge making a system of capillary grooves and small run-off gutters, with a place for the sealing tape, and the extreme edges of the metal sheet are rolled on both sides, and then in the stamping die (5) the modules of transverse outlines of roof tiles are shaped, together with grooves symbolizing side edges of the points of contact of the tiles; and the method of manufacture is automatic with the use of an electronic control system, with the possibility of manual control; the shaped metal roofing sheet is cut off and piled. Flat metal roofing sheet with mouldings is characterized by the fact that it is flat with semicircular ending, with alternately placed outlines of the edges of the tiles with rows mutually shifted by a half of the width of the tile; and on its underside it has a place for a seal (sealing tape) close to the rolled part of the metal sheet.

IPC 8 full level
E04D 1/06 (2006.01); **B21D 28/06** (2006.01); **B21D 35/00** (2006.01); **B21D 47/00** (2006.01); **E04D 3/30** (2006.01)

CPC (source: EP)
B21D 28/06 (2013.01); **B21D 35/001** (2013.01); **B21D 47/00** (2013.01); **E04D 3/30** (2013.01)

Cited by
CN111496083A; CN104998964A

Designated contracting state (EPC)
AL AT BE BG CH CY CZ DE DK EE ES FI FR GB GR HR HU IE IS IT LI LT LU LV MC MK MT NL NO PL PT RO RS SE SI SK SM TR

DOCDB simple family (publication)
EP 2824252 A1 20150114; **EP 2824252 B1 20181107**; PL 226689 B1 20170831; PL 404053 A1 20141208

DOCDB simple family (application)
EP 14460018 A 20140321; PL 40405313 A 20130524