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(54) **A method and apparatus for bending a corrugated sheet.**

(57) A method of and apparatus for bending a corrugated sheet transversely of the direction of corrugation, the corrugated sheet being of the type having a plurality of parallel ridges and troughs formed by ridge tops (17) connected to ridge bottoms (18) by intermediate side walls (19 and 20). The apparatus comprises a first tool (11) in the form of a pressure bar formed along the length thereof with alternating projections (16A) and notches (16B) and a second tool (10) in the form of an elongate member (12) carrying a plurality of projections (13), a channel (14) being provided in each projection (13) to receive the first tool (11) in use of the apparatus. In use of the apparatus, a corrugated sheet is pressed between the first and second tools so that each projection (13) of the second tool (10) enters a respective valley between two ridge tops (17) of the corrugated sheet and the first tool (11) enters the channels (14) of the projections (13) to form a fold (22) extending transversely of the corrugations and into the valleys of the corrugated sheet. The trough bottom (18) of each corrugation is brought into contact with the base of the respective notch (16B) during the pressing operation and at the same time the side walls (19 and 20) of the respective valley contact the edges of the notch (16B) whereby the portions (19A and 20A) of the side walls between the point of contact with the notch edge and the trough bottom (18) are moved away from the valley (21)

and the portions (19B and 20B) of the side walls between the point of contact and the ridge tap are moved into the valley.

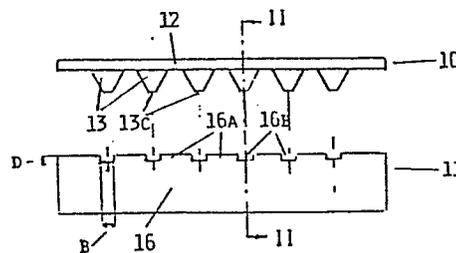


FIG 1

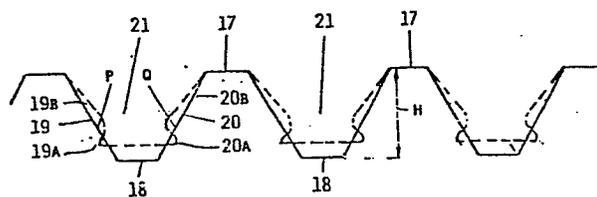


FIG 3

**EP 0 146 352 A3**



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**EUROPEAN SEARCH REPORT**

**0146352**

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EP 84 30 8696

DOCUMENTS CONSIDERED TO BE RELEVANT			
Category	Citation of document with indication where appropriate, of relevant passages	Relevant to claim	CLASSIFICATION OF THE APPLICATION (Int Cl 4)
X	GB-A-2 101 507 (PHILLIPS) * Whole document *	1-10	B 21 D 11/20
P, X	EP-A-0 103 340 (DUPRAL) * Pages 8,9; figures *	1-10	
D, A	BE-A- 855 785 (KONSTRASK MEKANISKA) & SE - A - 75 14 338		
A	WO-A-8 000 932 (NÄSLUND)		
A	EP-A-0 049 313 (VAW LEICHTMETALL)		
A	AU-B- 504 467 (JURY)		
The present search report has been drawn up for all claims			TECHNICAL FIELDS SEARCHED (Int Cl 4)
			B 21 D
Place of search THE HAGUE		Date of completion of the search 14-03-1986	Examiner PEETERS L.
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