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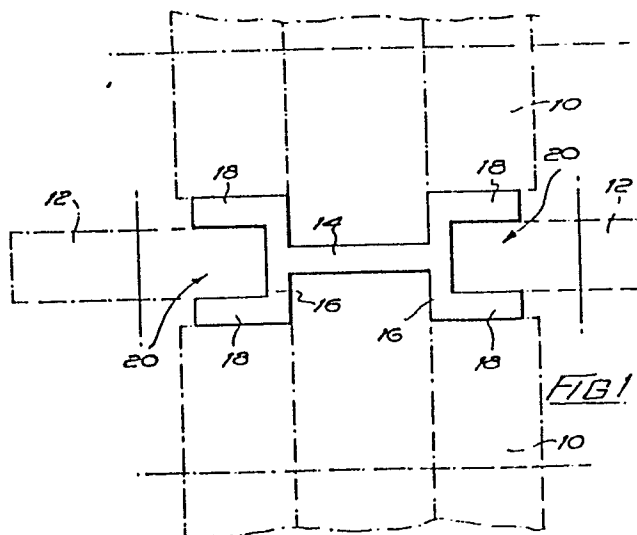
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(54) **Method of forming metal.**

(57) A method of forming metal to produce structural steel sections, the method involving the step of hot rolling an elongate section in a universal rolling mill stand having a first pair of rolls located at right angles to a second pair of rolls.

In order that the finished product can have oppositely disposed flanges (16,16) with side flanges (18,18) parallel to a web portion (14) of the section, the second pair of rolls (12,12) are located in such a position in relation to said first pair of rolls (10,10) that the side flanges (18,18) of the product are rolled between end portions of the first pair of rolls (10,10) and the respective flanks of the second pair of rolls (12,12).





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	DE-C- 240 433 (A. SACK) * figures 1-5; claim, column 1, lines 1-10 *	1,4	B 21 B 1/08
Y	---	2,3,6	
Y	DE-C- 506 528 (A. HACKER) * figures 1-6, claim *	2,6	
Y	DE-B-1 452 122 (VOEST) * figures 5-10, claims 1-4, 7, column 4, lines 39-45 *	3	
Y	DE-B-1 299 974 (VSESOJUZNY) * figures 1-3, claim *	2,6	
Y	DE-C- 235 296 (GEWERKSCHAFT DEUTSCHER KAISER) * figure 3, claim *	2,6	

The present search report has been drawn up for all claims			
Place of search BERLIN		Date of completion of the search 15-05-1987	Examiner BROESAMLE
<p>CATEGORY OF CITED DOCUMENTS</p> <p>X : particularly relevant if taken alone Y : particularly relevant if combined with another document of the same category A : technological background O : non-written disclosure P : intermediate document</p> <p>T : theory or principle underlying the invention E : earlier patent document, but published on, or after the filing date D : document cited in the application L : document cited for other reasons</p> <p>& : member of the same patent family, corresponding document</p>			