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㉔ Applicant: **FUCHS, BRUNO, R 12 de Outubro 220, BR-Ijuí, RS (BR)**

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㉕ Inventor: **FUCHS, BRUNO, R 12 de Outubro 220, BR-Ijuí, RS (BR)**

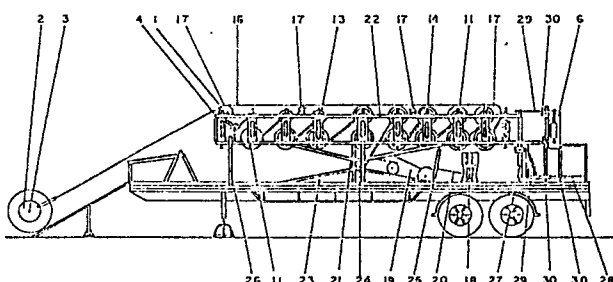
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㉗ Representative: **Greenstreet, Cyril Henry et al, Haseltine Lake & Co. Hazlitt House 28 Southampton Buildings Chancery Lane, London WC2A 1AT (GB)**

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㉙ **Production of profiled self-portable tiles.**

㉚ The invention provides a process and a machine by which self-portable tiles for the roofs of warehouses, industrial buildings and other structures can be produced on the building site. A machine mounted on the chassis of a truck includes a train of rolls (5) for profiling metal strip, regulation and maintenance systems corresponding to each pair of rolls, an operating system made up of a single chain (16), and means for balancing the profiling machine through central hinges (24) and hydraulic pistons (25), all synchronised to allow the profiling and curving of the self-portable tiles produced. Another feature is a venation device that, conjugated to the profiling machine and located between the last group of profiling rolls and the first group of bending rolls, and working synchronously with these groups, preferably using the system of movement transmission of the profiling machine, makes a transverse cold venation in the lateral longitudinal sections of the adjusted tile, offering a higher mechanical resistance to the efforts and demands originated by the wind and by the weight of the self-portable covering.





European Patent
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EUROPEAN SEARCH REPORT

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Application number

EP 85 10 6678

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	US-A-3 128 818 (BOTTOM) * Figures 1-3 *	11	B 21 D 13/04
A		1-10	
Y	WO-A-8 202 914 (KNUDSON) * Page 2, lines 17-24; page 4, lines 20-31; abstract *	11-13	
Y	US-A-3 529 461 (KNUDSON) * Figure 1, reference numeral 12; column 3, lines 11-16 *	11-13	
A	US-A-3 059 685 (BEHLEN) * Figures 6,9,11 *	1-3,5	
A	US-A-4 269 055 (SIVACHENKO) * Figures 14,15 *	6	
The present search report has been drawn up for all claims			
Place of search THE HAGUE		Date of completion of the search 13-05-1987	Examiner ASH
CATEGORY OF CITED DOCUMENTS			
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		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 & : member of the same patent family, corresponding document	