

12 **EUROPEAN PATENT APPLICATION**

21 Application number: 85201142.8

61 Int. Cl.⁴: **F 28 F 1/12**
F 28 D 9/00, B 21 D 53/04

22 Date of filing: 09.07.85

30 Priority: 23.07.84 US 633307

43 Date of publication of application:
29.01.86 Bulletin 86/5

88 Date of deferred publication of search report: 08.10.86

84 Designated Contracting States:
DE FR GB IT SE

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54 **Heat exchanger fins and method of making.**

57 Fin structure for a heat exchanger is fabricated by folding a strip (10) of material back over itself at locations along the length of the strip such that integrally joining one of the folds (12, 14, 16) on opposite sides are first confronting portions (18,20,22,24) each of which in turn integrally joins by a further fold (12) with a corresponding second confronting portion of the strip. Each pair of first and second confronting portions are processed to form a fin (26,28) which has an interior space by joining their margins (30). This joining (32) extends from the fold which integrally joins the first and second confronting portions substantially to the one fold. The one fold is deformed by displacing material from it more fully between the two fins, and preferably this is done at both ends of the fold. The displaced material strengthens the structure and spaces the fins apart.

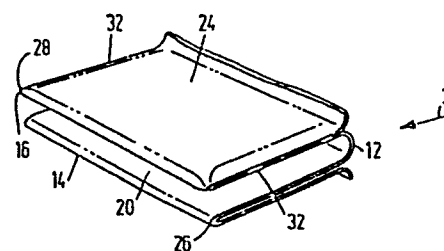


FIG.2



European Patent
Office

EUROPEAN SEARCH REPORT

0169610

Application number

EP 85 20 1142

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)
Y	GB-A-1 193 619 (ASSOCIATED ENGINEERING LTD.) * Page 2, lines 31-59; figures 2,5,6 *	1-6,8, 9,12- 15,17	F 28 F 1/12 F 28 D 9/00 B 21 D 53/04
Y	US-A-2 953 110 (ETHERIDGE) * Column 2, line 53 - column 3, line 56; figures 1-3 *	1-6,8, 9,12- 15,17	
A		7	
A	US-A-4 384 611 (FUNG) * Column 7, lines 28-46; column 8, line 40 - column 9, line 33; figures 6,10-12 *	1	
A	US-A-4 179 781 (LONG) * Column 3, line 45 - column 4, line 63; figures 1-3 *	1	F 28 F F 28 D B 21 D
A	US-A-4 171 015 (BUCEY et al.) * Column 2, lines 47-68; figures 1,2,12 *	1	
A	FR-A- 929 467 (N.V. PHILIPS' GLOEILAMPENFABRIEKEN) * Figures 1,2,7 *	1	
The present search report has been drawn up for all claims			
Place of search THE HAGUE		Date of completion of the search 18-07-1986	Examiner BELTZUNG F.C.
<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 & : member of the same patent family, corresponding document</p>			