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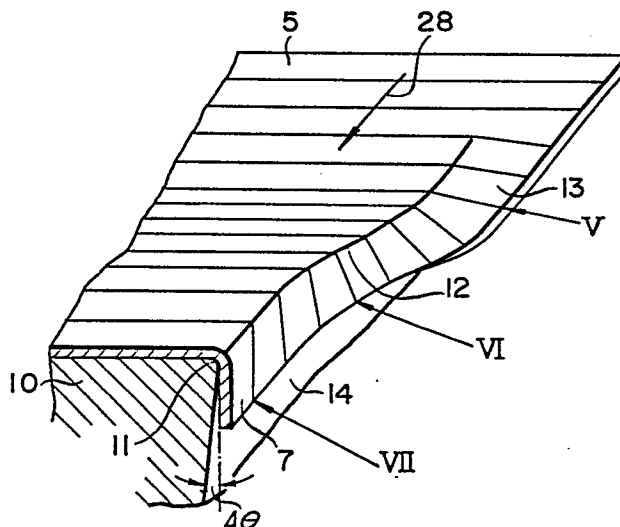
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⑤④ **Method of bending plate materials.**

⑤⑦ Disclosed is a method of bending a plate material by means of an exclusive-use die shoe for the plate material to be worked and a versatile bending means having a pressing surface, wherein the edge portion of the die shoe (10) serves as a bending surface (11) for the plate material (5); the plate material (5) is mounted on and secured to the die shoe (10), bending means (15, 16, and 17; 18) are brought into contact with and pressed against a portion of the surface to be bent (13) of the plate material (5), moving the same along the surface to be bent, and bending the surface to be bent step by step. The bending means (15, 16, and 17) comprise a plurality of bending members, each bending member being formed in such a manner that the angle of each of the pressing surfaces (19, 20, and 21) thereof is formed such as to become gradually larger, and the bending members are used in sequence starting with the one having the pressing surface with the smallest angle. Or, the bending means (18) is a bending member having a pressing surface parallel to the axis of the bending member and is inclined against the plate material step by step.





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-3 756 057 (BROOKS) * claim 1; figures 5, 7 *	1,2	B 21 D 5/08
A	--- DE-C- 641 744 (STEINBÜCHEL)	1	
A	--- FR-A-2 525 504 (UKRAINSKY NAUCHNO-ISSLEDOVATELSKY INSTITUT METALLOV) -----	1	
			TECHNICAL FIELDS SEARCHED (Int. Cl. 4)
			B 21 D 5/00 B 21 D 11/00
The present search report has been drawn up for all claims			
Place of search BERLIN		Date of completion of the search 06-08-1986	Examiner SCHLAITZ J
CATEGORY OF CITED DOCUMENTS		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	
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			