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(54) **Heat exchanger fin arrays.**

(57) Heat exchanger fin (12) arrays of uniform width are made and are subsequently divided lengthwise into arrays of smaller width. A pattern (11) of weaknesses is provided for facilitating lengthwise division. Before such division, the array may be attached to uniform number of heat exchange elements (13) to form a heat exchanger sub-assembly of uniform size. Lengthwise division then produces smaller sub-assemblies. The invention allows flowline production of heat exchangers of a wide variety of different sizes and utilizing fin forming and welding apparatus at or near full capacity.

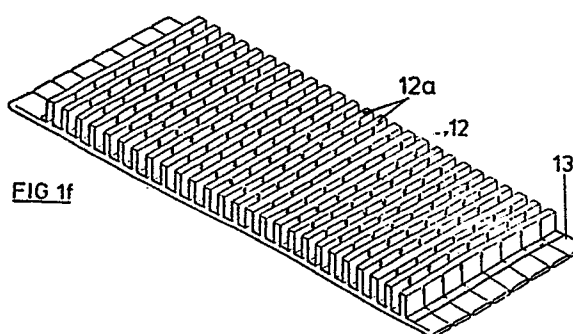


FIG 1f



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-2 014 484 (CARRIER CORP.) * figures 1, 4; page 1, lines 55-92; page 2, lines 3-92 *	1-3,5, 7,8,12	B 21 D 13/02 B 21 D 53/02 F 28 F 3/02
Y	---	2,11	
Y	GB-A-2 014 483 (CARRIER CORP.) * figure 3, page 1, lines 52-55 *	11	
Y	---		
Y	DE-A-2 438 595 (HILLESHEIM) * figures 1, 2, 5; page 1 last, page 2, last three paragraphs *	2	
A	---		
A	DE-A-2 918 191 (BAAL) * figures 1, 5, 6, pages 5-10 *	1	
			TECHNICAL FIELDS SEARCHED (Int. Cl.4)
A	---		
A	US-A-1 767 605 (A.B. MODINE) * figure 4, page 2, lines 10-34, reference sign "20" *	1	B 21 D 13/00 B 21 D 31/00 B 21 D 53/00 F 28 F 1/00 F 28 F 3/00

The present search report has been drawn up for all claims			
Place of search BERLIN		Date of completion of the search 25-06-1987	Examiner BROESAMLE
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	