

12 **EUROPEAN PATENT APPLICATION**

21 Application number: 85114897.3

51 Int. Cl.⁴: F 28 F 1/16
F 28 F 1/22, F 28 D 1/047
B 21 D 53/06

22 Date of filing: 25.11.85

30 Priority: 23.11.84 CH 5599/84

43 Date of publication of application:
04.06.86 Bulletin 86/23

88 Date of deferred publication of search report: 29.10.86

84 Designated Contracting States:
AT BE CH DE FR GB IT LI LU NL SE

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54 Heat exchanger modules and method of manufacturing.

57 A new method of manufacturing of heat exchangers, and more particularly a method of producing completely integrated heat exchanging modules of variable size and capacity, and heat exchangers provided by such method is disclosed. The method comprises steps of providing a hollow shape (2) comprising a tube (21) with one or more voids, longitudinally extending fins (22) projecting from the tube surface, partial removal of fins and bending of the tube in areas free of fins providing a meander-like loop for heat exchanging medium and a multiplicity of convection chambers (24). The heat exchanging module (2) is also provided with apertures (25, 26) constituting inlets and outlets for transverse circulation of heat exchanging media.

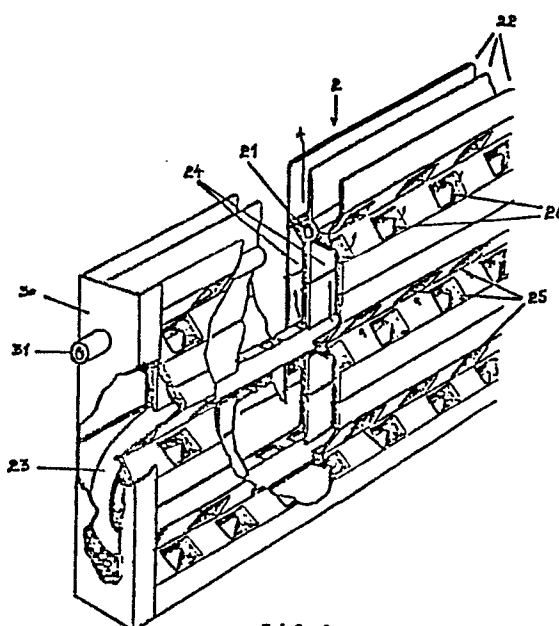


FIG. 1



European Patent
Office

EUROPEAN SEARCH REPORT

0183211

Application number

EP 85 11 4897

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-3 540 530 (KRITZER) * Column 2, line 35 - column 5, line 6; figures 1-4, 7-8 *	1, 3-8	F 28 F 1/16 F 28 F 1/22 F 28 D 1/047 B 21 D 53/06
A		2	
X	US-A-2 347 957 (McCULLOUGH) * Column 2, line 16 - column 3, line 36; figures 1-6 *	1	
A		4	
A	CH-A- 262 895 (BECK) * Page 3, lines 37-53; page 4, lines 86-92; figures 4, 14-15 *	1, 3-6	
A	GB-A-1 594 136 (SIMPSON) * Page 2, lines 30-47; figure 3 *	1, 4, 8	
A	FR-A-2 222 624 (AXLANDER)		
A	FR-A-1 524 182 (RUBANOX)		
The present search report has been drawn up for all claims			
Place of search THE HAGUE		Date of completion of the search 13-08-1986	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>			