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54 **Method of manufacturing a refrigerator with cooling air ducts.**

57 A method of manufacturing a refrigerator having an inner wall and an outer wall (2) which together define an interspace and cooling air ducts (17) which are at least partially embedded in the thermal insulation (30) generated in-situ in the interspace between the two walls.

To avoid penetration of insulating material in the ducts via gaps between the ends of the ducts and the wall during the foaming operation, the ducts are formed initially with closed ends (A) by blow-moulding from a plastics material and are fitted to the refrigerator inner wall with the closed ends protruding through apertures in the inner wall, said ends subsequently being removed after the forming of the thermal insulation.

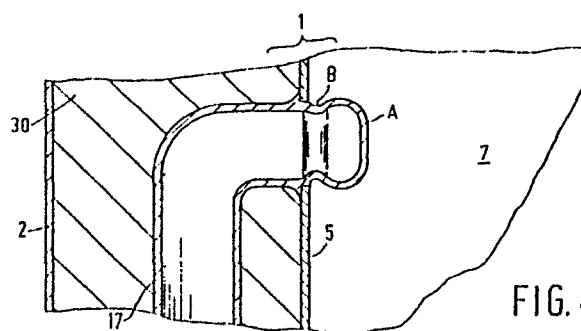


FIG. 4



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EUROPEAN SEARCH REPORT

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EP 85 20 1834

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)
A	DE-A-2 453 796 (BOSCH-SIEMENS HAUSGERÄTE GmbH) * Whole document *	1	F 25 D 17/08 F 25 D 23/06
A	DE-B-1 227 921 (SIEMENS-ELECTROGERÄTE GmbH)		
A	US-A-3 321 933 (SCHEITLIN et al.)		
A	US-A-3 177 271 (SLAYMAN)		
A	US-A-3 048 024 (JACOBS)		
			TECHNICAL FIELDS SEARCHED (Int. Cl.4)
			F 25 D E 04 B
The present search report has been drawn up for all claims			
Place of search THE HAGUE		Date of completion of the search 16-04-1987	Examiner SILVIS H.
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	