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54 **Forming contoured shapes.**

57 Contoured shapes, especially elongated saddle-section shapes such as helicopter rotor blade erosion shields, are formed from a sheet metal workpiece by providing the workpiece with lateral flange portions that are engaged with respective lateral tools movable in synchronism adjacent to the flanks of an elongate male tool so as to draw the workpiece, by its flange portions, over the male tool and into contiguity therewith. The lateral tools may cooperate with gripper means to grip the flange portions and facilitate stretch-forming. Apparatus for performing this method is also disclosed.



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	FR-A-1 036 632 (CONSTRUCTIONS AERONAUTIQUES DU SUD-OUEST) * Figures 1-3; page 3, penultimate paragraph - page 4, paragraph 3 *	1-6	B 21 D 11/02 B 21 D 25/02
X	US-A-1 811 259 (CURTIS) * Figures 1,4,5 *	5-10	
A		1-4	
X	US-A-2 339 032 (SCHLENZIG) * Figures 4,8 *	1-6	
A		7-9	
X	US-A-1 880 454 (KLOCKE) * Figures 1-3; page 1, line 88 - page 2, line 6 *	6-10	TECHNICAL FIELDS SEARCHED (Int. Cl.4) B 21 D
The present search report has been drawn up for all claims			
Place of search THE HAGUE		Date of completion of the search 23-07-1987	Examiner ASH
<b>CATEGORY OF CITED DOCUMENTS</b> 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			