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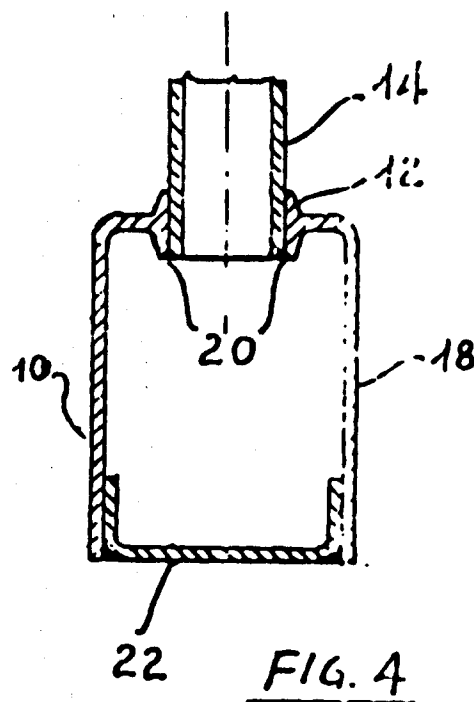
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05.08.92 Bulletin 92/32(71) Applicant: **Wolfsgruber, Guglielmo**
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Negri 10
I-20123 Milano(IT)(54) **Process for the manufacture of radiant panels and the like and radiant panel thus obtained.**

(57) Process for the manufacture of radiant panels and the like comprising:

- formation on a front of the opposing supporting channels (10) of the holes with collar (12) by means of hot flow drilling, and
- housing in each of said holes of a tubular element (14) and subsequently constraining of said tubular elements (14) to the channels by welding or braze welding; the collars (12) are preferably made in cone form and extend inside the section bar and have at the top an annular seat with a countersink for the welding alloy.

The supporting channels (10) can be made of two channels (18,22) with "U" cross section inserted one in the other and welded.

In this case welding (20) of the tubular elements (14) is performed from the inside.



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EUROPEAN SEARCH REPORT

Application Number

EP 91 11 9671

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.5)
A	DE-A-2 359 794 (GEFFEN) * claim 1; figures 3,4 * ---	1,2	B21053/06
A	FR-A-512 347 (SERCK) * page 2, line 8 - line 12; claims 1,2; figure 13 * ---	1	
A	DE-C-193 541 (JOLLES) * claim 1; figure 1 * ---	1	
A	US-A-2 948 054 (KRITZER) * claim 1; figures 8,9 * -----	1	
			TECHNICAL FIELDS SEARCHED (Int. Cl.5)
			B21D B23B
The present search report has been drawn up for all claims			
Place of search BERLIN		Date of completion of the search 27 MAY 1992	Examiner SCHLAITZ J.
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			