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(71) Applicant: **SHOWA ALUMINUM CORPORATION**
Sakai-shi Osaka (JP)

(72) Inventors:
• **Saito, Yoshihiro**
Mino-shi, Osaka (JP)
• **Hozumi, Satoshi**
Oyama-shi, Tochigi (JP)

• **Tamura, Takashi**
Chiba (JP)
• **Sakaguchi, Masashi**
Saitama (JP)
• **Kaimura, Satoru**
Tochigi (JP)

(74) Representative: **TER MEER STEINMEISTER & PARTNER GbR**
Mauerkircherstrasse 45
81679 München (DE)

(54) **Process for producing flat heat exchange tubes**

(57) A process for producing a flat heat exchange tube (A) having parallel refrigerant passages (6) in its interior and comprising flat upper and lower walls (1,2), opposite side walls (3,4) and a plurality of reinforcing walls (5) connected between the upper and lower walls (1,2), extending longitudinally of the tube (A) and spaced apart from one another by a predetermined distance, using a rolling mill (33) comprising a central work roll (35) and a plurality of planetary work rolls (36) arranged around a portion of the periphery of the central work roll (35) and spaced apart circumferentially thereof, the central work roll (35) being formed with parallel annular grooves (39,40) in the periphery thereof. An aluminum sheet blank (30) comprising a brazing sheet is rolled by the mill (33) and thereby thinned to a predetermined thickness to form a flat portion serving as the lower wall (2), cause the annular grooves (39) at opposite roll ends to form upright portions (12) providing the respective side walls (3,4) and the other annular grooves (40) to form vertical ridges providing the reinforcing walls (5), the upright portions and the vertical ridges projecting from the flat portion integrally therewith. An aluminum sheet (20) comprising a brazing sheet is placed over all the ridges to provide the upper wall (1) and joined to the upright portions to make the upright portions serve as the opposite side walls (3,4), and the ridges of the lower wall are joined to the upper wall to form the reinforcing walls (5).

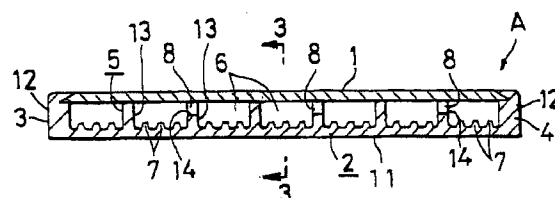


FIG. 1

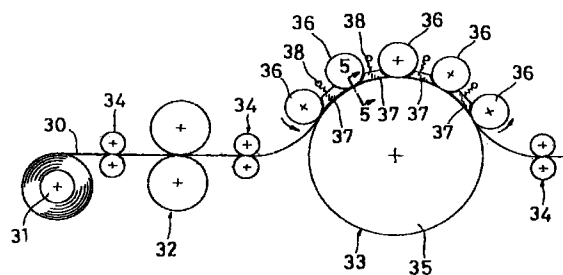


FIG. 4

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EUROPEAN SEARCH REPORT

Application Number
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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.6)
Y	EP 0 617 250 A (SHOWA ALUMINIUM CORP)	1-4, 7-14, 16-18	B21C37/15 B21B1/22 B21B13/00 B21H8/00
A	* column 6, line 22 - column 8, line 20; figures *	6	
Y	DE 36 22 926 A (DOWA MINING CO ;SAITO YOSHIHIRO (JP)) 12 March 1987	1-4, 7-14, 16-18	
A	* abstract; figures *	15	
A	US 4 805 693 A (FLESSATE DENNIS S) 21 February 1989		
A	JOURNAL OF HEAT TREATING, vol. 1, no. 6, 1 December 1992, pages 789-795, XP000356248 SAITO Y ET AL: "DEVELOPMENT OF SATELLITE MILL AND TRIAL ROLLING OF PROFILED METAL STRIP"		
A	US 5 271 151 A (WALLIS BERNARD J) 21 December 1993		
The present search report has been drawn up for all claims			
Place of search THE HAGUE		Date of completion of the search 18 April 1997	Examiner Barrow, J
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