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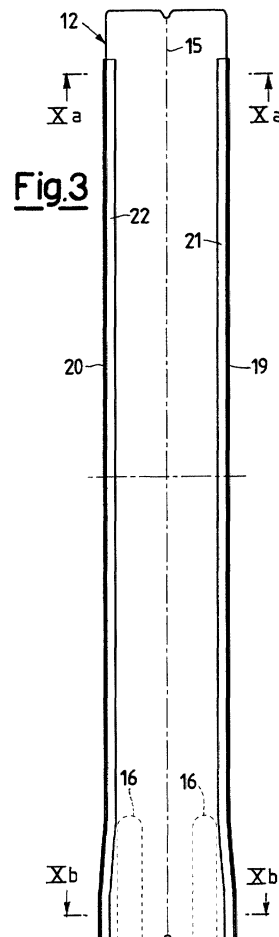
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(54) **Process for the blanking of metallic drawer guides**

(57) A process for the blanking of metallic drawer guides, in particular metallic guides for so-called "self-closing" drawers, by a transfer machine, comprising at least one shearing phase from a strip (10) to shape the contours of a preform (12), a phase of separating said preform (12) from said strip (10) to shape a single flat preform (12) in an elongated rectangular form, suitable for producing a whole (13, 14) with two opposed right and left-side guides of a drawer, with additional molding and shaping phases of said flat preform in two parts in the shape of a "Z" facing each other in a specular manner while being centrally joined, and a separating phase by blanking the said two parts so as to shape two guides having an essentially Z-formed cross section (30,40) with an inclined ramp (31,41) in a terminal area (12a).





European Patent
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EUROPEAN SEARCH REPORT

Application Number
EP 98 20 3839

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Category	Citation of document with indication, where appropriate, of relevant passages	Relevant to claim	CLASSIFICATION OF THE APPLICATION (Int.Cl.6)
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			TECHNICAL FIELDS SEARCHED (Int.Cl.6)
			B21D A47B
The present search report has been drawn up for all claims			
Place of search		Date of completion of the search	Examiner
THE HAGUE		10 December 2001	Peeters, L
<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</p> <p>& : member of the same patent family, corresponding document</p>			

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**ANNEX TO THE EUROPEAN SEARCH REPORT
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EP 98 20 3839

This annex lists the patent family members relating to the patent documents cited in the above-mentioned European search report.
The members are as contained in the European Patent Office EDP file on
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