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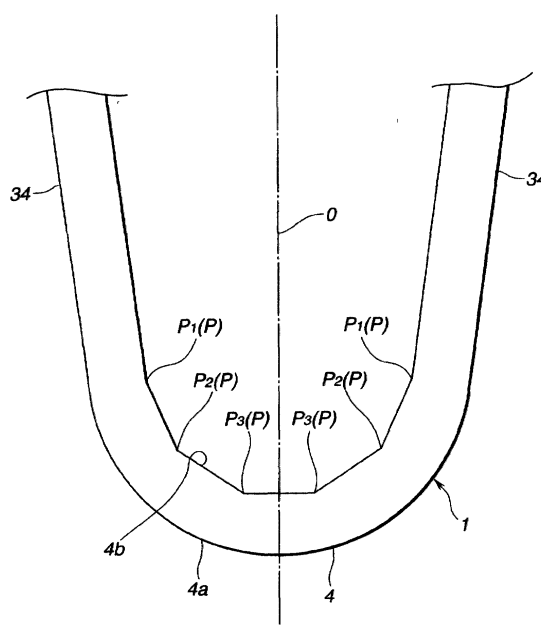
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(54) **Formed strip and roll forming**

(57) A V-shaped metal strip has a U-shaped bottom having U-shaped inside and outside surfaces. Only the U-shaped inside surface is formed with a plurality of fold lines extending in a longitudinal direction of the strip and reducing the influence of springback. The fold lines may be arranged in a manner of bilateral symmetry with respect to an imaginary median plane bisecting the V-shaped cross section of the metal strip.

FIG.1



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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.7)
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	* abstract; figure 9 *		

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Y	* abstract; figures 5-8 *	13,14	
X	* figure 1 *	15	

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	* abstract; figure 5 *		

A	GB 1 547 685 A (HADLEY & EVANS SECTIONS LTD) 27 June 1979 (1979-06-27)	15-18	
	* figure 1 *		

			TECHNICAL FIELDS SEARCHED (Int.Cl.7)
			B21D B21C B21B
The present search report has been drawn up for all claims			
Place of search MUNICH		Date of completion of the search 12 March 2002	Examiner Vinci, V
CATEGORY OF CITED DOCUMENTS		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	
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			

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**LACK OF UNITY OF INVENTION
SHEET B**

Application Number
EP 99 12 0154

The Search Division considers that the present European patent application does not comply with the requirements of unity of invention and relates to several inventions or groups of inventions, namely:

1. Claims: 1-14

A formed metal strip and a method of forming a metal strip, wherein the strip has a U-shaped bottom and is provided with a plurality of fold lines on the inner side of the U-shaped bottom only.

2. Claims: 15-18

A roll forming apparatus with rolls for forming the flanges on the edge of a strip.

**ANNEX TO THE EUROPEAN SEARCH REPORT
ON EUROPEAN PATENT APPLICATION NO.**

EP 99 12 0154

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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12-03-2002

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