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(54) **A heat exchanger and a method of manufacturing thereof**

(57) The invention relates to a heat exchanger (1) comprising a cooling core (2) consisting of plurality of parallel tubes and cooling fins, two manifolds (3) fluidly connected with opposite ends of each tube, and an inlet and outlet ports for a heat exchanging medium, and a method of manufacturing thereof.

To preliminary assemble the heat exchanger, which allows one-shot furnace brazing of all components thereof, with no need to use auxiliary supporting elements, said method comprises the steps of (i) preliminary assembling on the manifold (3) at least one bracket (4) having a mounting plate (5); (ii) making at least one fitting block (7) having a slot (8) for the mounting plate (5) of the bracket (4) and a flow duct ended by an orifice (10) surrounded by annular groove (16) for a brazing agent (17), bordered at its outer side by securing ring (18); (iii) pushing the fitting block (7) in the mounting plate (5) of the bracket; (iv) placing at least one joint pipe (11) fluidly connected with the manifold (3), in the orifice (10) of the fitting block (7) to create an annular capillary gap; (v) placing the brazing agent (17) in the annular groove (16) and squeezing the securing ring (18) inwards, at least in few points; and (vi) one shot brazing of the heat exchanger components together.

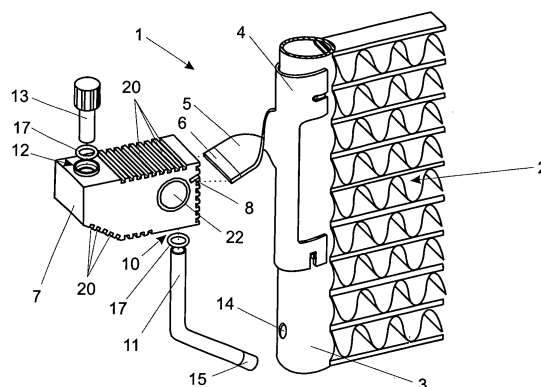


Fig. 1



EUROPEAN SEARCH REPORT

Application Number
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Category	Citation of document with indication, where appropriate, of relevant passages	Relevant to claim	CLASSIFICATION OF THE APPLICATION (IPC)
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			TECHNICAL FIELDS SEARCHED (IPC)
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The present search report has been drawn up for all claims			
Place of search The Hague		Date of completion of the search 29 June 2010	Examiner Mootz, Frank
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			

1
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**ANNEX TO THE EUROPEAN SEARCH REPORT
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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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