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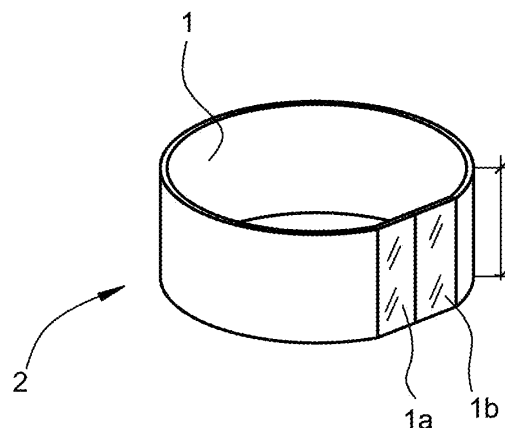
(54) **Method for manufacturing discs for wheels, particularly for commercial vehicles**

(57) The method comprises the operations of:  
- providing a strip of sheet metal (1) substantially shaped like an elongated parallelogram with an essentially uniform thickness;  
- bending such a strip of sheet metal (1) and welding together the end portions (1a, 1b) so as to make a substantially cylindrical ring; and  
- subjecting the ring (2) to press-moulding and shaping operations through plastic deformation so as to give it a desired shape.

The strip of sheet metal (1) is bent so that its end portions (1a, 1b) are level and such end limbs (1a, 1b) are brought together and butt welded substantially on a same plane, so as to obtain a ring (2) which has a chordal flattened wall portion (1a, 1b).

Before undergoing the aforementioned press-moulding and shaping operations, the ring (2) is subjected to a preliminary rounding operation through radial expansion.

**FIG. 2**



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## EUROPEAN SEARCH REPORT

Application Number  
EP 09 16 3363

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The present search report has been drawn up for all claims			
Place of search Munich		Date of completion of the search 29 December 2011	Examiner Vinci, Vincenzo
<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 &amp; : member of the same patent family, corresponding document</p>			

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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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