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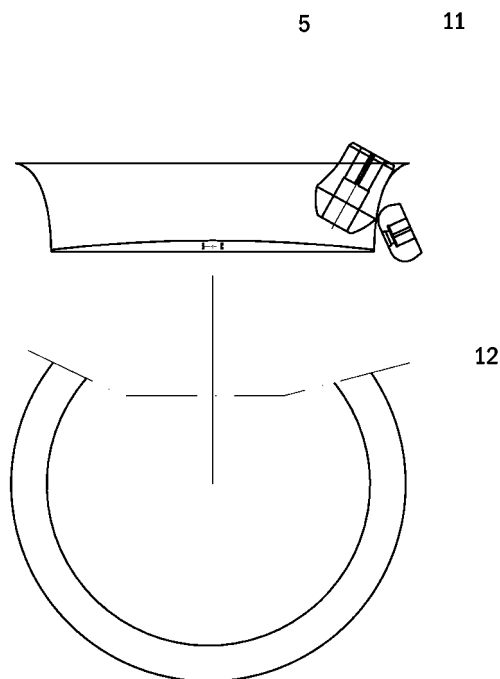
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(54) **Method for manufacturing large metallic tubular piece, and large metallic tubular piece**

(57) The present invention relates to metal technology and to manufacture of large metal pieces, and in particular to manufacture of large metallic sleeve pieces, the large metallic sleeve pieces being suitable for various flow applications, such as those in marine technology and process technology, and to manufacturing methods of these large metallic sleeve pieces. The large, metallic sleeve piece of the invention comprises a sleeve structure (13), (15) made of metal plate, the inner surface of the sleeve structure being formed by means of forming rolls (7 to 12) such that the metallic sleeve piece has assumed its inwardly convex shape.



**Fig. 7**



## EUROPEAN SEARCH REPORT

Application Number  
EP 11 15 6921

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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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X	US 3 342 051 A (EDWARD LESZAK) 19 September 1967 (1967-09-19) * claims; figures 1-3,6 *	1-6,8-19	B21D53/92 B63H5/16 B21D19/04 B21H1/04
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			TECHNICAL FIELDS SEARCHED (IPC)
			B21D B21H B63H
The present search report has been drawn up for all claims			
Place of search Munich		Date of completion of the search 7 February 2012	Examiner Cano Palmero, A
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	

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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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