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(54) **Method and machine for shaping the edges of bent pieces**

(57) A method and a machine for shaping the edges (12, 13) of a roll bent metal piece (10), more particularly tubular or annular members (10) from a metal sheet or a sectional bar; the flat or non-curved longitudinal edges (12, 13) of the roll bent metal piece (10) are subjected to a roll shaping step of making it move forwards with one or both edges (12, 13) clamped between opposing shaping elements (25, 26); the shaping elements are rotatably supported to act on the internal and on the external surfaces respectively of the bent piece (10) in order to provide the flat edges (12,13) of the same bent piece (10) with the required circular shape.

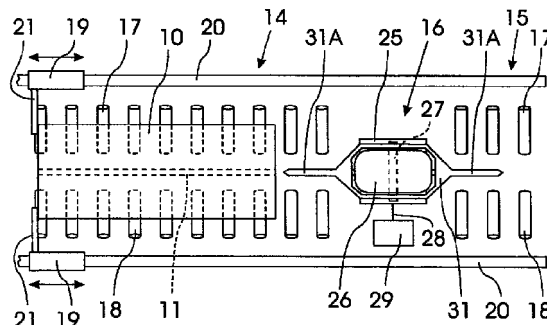


Fig. 2

EP 0 924 004 A3



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EUROPEAN SEARCH REPORT

Application Number
EP 98 12 3722

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.6)
X	DE 588 960 C (MANNESMANNROHREN) 16 November 1933 (1933-11-16) * the whole document *	1,2	B21C37/06 B21C37/08 B21D5/12
Y	---	3-5, 7-12, 14-18	
Y	DE 915 932 C (LINDE'S EISMASCHINEN) 2 August 1954 (1954-08-02) * page 2, line 115 - page 3, line 11; figures 1-3 * -----	3-5, 7-12, 14-18	
			TECHNICAL FIELDS SEARCHED (Int.Cl.6)
			B21C B21D
The present search report has been drawn up for all claims			
Place of search THE HAGUE		Date of completion of the search 24 January 2000	Examiner Marc Augé
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
ON EUROPEAN PATENT APPLICATION NO.**

EP 98 12 3722

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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Patent document cited in search report	Publication date	Patent family member(s)	Publication date
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DE 915932	C	NONE	