

# CPC COOPERATIVE PATENT CLASSIFICATION

## B PERFORMING OPERATIONS; TRANSPORTING

(NOTES omitted)

### SHAPING

**B21 MECHANICAL METAL-WORKING WITHOUT ESSENTIALLY REMOVING MATERIAL; PUNCHING METAL** (casting, powder metallurgy [B22](#); shearing [B23D](#); working of metal by the action of a high concentration of electric current [B23H](#); soldering, welding, flame-cutting [B23K](#); other working of metal [B23P](#); punching sheet material in general [B26F](#); processes for changing of physical properties of metals [C21D](#), [C22F](#); electroforming [C25D 1/00](#))

(NOTES omitted)

**B21D WORKING OR PROCESSING OF SHEET METAL OR METAL TUBES, RODS OR PROFILES WITHOUT ESSENTIALLY REMOVING MATERIAL; PUNCHING METAL** (working or processing of wire [B21F](#))

#### NOTES

1. This subclass covers cutting or perforating of sheet metal or other stock material
2. This subclass does not cover the working of metal foils in a manner analogous to the working of paper, which is covered by classes [B26](#), [B31](#)

#### **Straightening; Restoring form; Bending; Corrugating; Flanging**

- 1/00 Straightening, restoring form or removing local distortions of sheet metal or specific articles made therefrom** ([B21D 3/00](#) takes precedence); **Stretching sheet metal combined with rolling** (working sheet metal of limited length by stretching [B21D 25/00](#); by localised hammering [B21D 31/06](#))
- 1/02 . by rollers ([B21D 1/06](#) takes precedence)
  - 1/05 . Stretching combined with rolling
  - 1/06 . Removing local distortions
  - 1/065 . . {by hammering}
  - 1/08 . . of hollow bodies made from sheet metal (of substantially open bodies [B21D 1/10](#); flattening hollow objects for transport and reforming [B21D 51/14](#))
  - 1/10 . . of specific articles made from sheet metal, e.g. mudguards
  - 1/12 . Straightening vehicle body parts or bodies ([B21D 1/14](#) takes precedence)
  - 1/14 . Straightening frame structures
  - 1/145 . . {Clamps therefor}
- 3/00 Straightening or restoring form of metal rods, metal tubes, metal profiles, or specific articles made therefrom, whether or not in combination with sheet metal parts** (straightening of well casings [in situ E21B](#); straightening rails or rail joints [E01B 31/08](#))
- 3/005 . {by eccentric turning members}
  - 3/02 . by rollers
  - 3/04 . . arranged on axes skew to the path of the work
  - 3/045 . . . {Workpiece feed channels therefor}
  - 3/05 . . arranged on axes rectangular to the path of the work

- 3/06 . . arranged inclined to a revolving flier rolling frame
  - 3/08 . . which move in an orbit without rotating round the work
  - 3/10 . between rams and anvils or abutments
  - 3/12 . by stretching with or without twisting (by twisting only [B21D 11/14](#))
  - 3/14 . Recontouring
  - 3/16 . of specific articles made from metal rods, tubes, or profiles, e.g. crankshafts, by specially adapted methods or means
- 5/00 Bending sheet metal along straight lines, e.g. to form simple curves** ([B21D 11/06](#) - [B21D 11/18](#) take precedence; corrugating sheet metal [B21D 13/00](#); as edge treatment [B21D 19/00](#))
- 5/002 . {Positioning devices}
  - 5/004 . {with program control}
  - 5/006 . {combined with measuring of bends}
  - 5/008 . {combined with heating or cooling of the bends}
  - 5/01 . between rams and anvils or abutments
  - 5/015 . . {for making tubes}
  - 5/02 . on press brakes without making use of clamping means
  - 5/0209 . . {Tools therefor}
  - 5/0218 . . . {Length adjustment of the punch}
  - 5/0227 . . . {Length adjustment of the die}
  - 5/0236 . . . {Tool clamping}
  - 5/0245 . . . . {Fluid operated}
  - 5/0254 . . . {Tool exchanging}
  - 5/0263 . . . {Die with two oscillating halves}
  - 5/0272 . . {Deflection compensating means}
  - 5/0281 . . {Workpiece supporting devices}
  - 5/029 . . {with shearing devices}

- 5/04 . . on brakes making use of clamping means on one side of the work
- 5/042 . . {With a rotational movement of the bending blade}
- 5/045 . . {With a wiping movement of the bending blade}
- 5/047 . . {Length adjustment of the clamping means}
- 5/06 . . by drawing procedure making use of dies or forming-rollers, e.g. making profiles
- 5/08 . . making use of forming-rollers ([B21D 5/12 takes precedence](#))
- 5/083 . . . {for obtaining profiles with changing cross-sectional configuration}
- 5/086 . . . {for obtaining closed hollow profiles}
- 5/10 . . for making tubes
- 5/12 . . . making use of forming-rollers
- 5/14 . . by passing between rollers ([B21D 5/06 takes precedence](#))
- 5/143 . . {making use of a mandrel}
- 5/146 . . {one roll being covered with deformable material}
- 5/16 . . Folding; Pleating
- 7/00 Bending rods, profiles, or tubes**  
([B21D 11/02 - B21D 11/18 take precedence](#); using mandrels or the like [B21D 9/00](#))
- 7/02 . . over a stationary forming member; by use of a swinging forming member or abutment
- 7/021 . . {Construction of forming members having more than one groove}
- 7/022 . . over a stationary forming member only
- 7/0225 . . . {using pulling members}
- 7/024 . . by a swinging forming member
- 7/025 . . . and pulling or pushing the ends of the work
- 7/028 . . . and altering the profile at the same time, e.g. forming bumpers
- 7/03 . . Apparatus with means to keep the profile in shape
- 7/04 . . over a movably-arranged forming member ([B21D 7/02 takes precedence](#))
- 7/06 . . in press brakes or between rams and anvils or abutments; Pliers with forming dies
- 7/063 . . {Pliers with forming dies}
- 7/066 . . {combined with oscillating members}
- 7/08 . . by passing between rollers or through a curved die
- 7/085 . . {by passing through a curved die}
- 7/10 . . by abutting members and flexible bending means, e.g. with chains, ropes
- 7/12 . . with programme control
- 7/14 . . combined with measuring of bends or lengths
- 7/16 . . Auxiliary equipment, e.g. for heating or cooling of bends
- 7/162 . . {Heating equipment}
- 7/165 . . {Cooling equipment}
- 7/167 . . {Greasing}
- 9/00 Bending tubes using mandrels or the like**  
([B21D 11/02 - B21D 11/18 take precedence](#))
- 9/01 . . the mandrel being flexible and engaging the entire tube length
- 9/03 . . and built-up from loose elements, e.g. series of balls
- 9/04 . . the mandrel being rigid
- 9/05 . . co-operating with forming members
- 9/055 . . {Construction of forming members having more than one groove}
- 9/07 . . with one or more swinging forming members engaging tube ends only
- 9/073 . . . {with one swinging forming member}
- 9/076 . . . {with more swinging forming members}
- 9/08 . . in press brakes or between rams and anvils or abutments; Pliers with forming dies
- 9/085 . . {Pliers with forming dies}
- 9/10 . . by passing between rollers
- 9/12 . . by pushing over a curved mandrel; by pushing through a curved die
- 9/125 . . {by pushing through a curved die}
- 9/14 . . Wrinkle-bending, i.e. bending by corrugating
- 9/15 . . using filling material of indefinite shape, e.g. sand, plastic material ([filling of tubes with such material B21D 9/16](#))
- 9/16 . . Auxiliary equipment, e.g. machines for filling tubes with sand
- 9/165 . . {Machines for filling tubes with sand}
- 9/18 . . for heating or cooling of bends
- 11/00 Bending not restricted to forms of material mentioned in only one of groups [B21D 5/00](#), [B21D 7/00](#), [B21D 9/00](#); Bending not provided for in groups [B21D 5/00 - B21D 9/00](#) (corrugating or bending into wave form [B21D 13/00](#), [B21D 15/00](#); flanging [B21D 19/00](#)); Twisting**
- 11/02 . . Bending by stretching or pulling over a die ([working sheet metal of limited length by stretching B21D 25/00](#))
- 11/06 . . Bending into helical or spiral form; Forming a succession of return bends, e.g. serpentine form ([making helically seamed tubing B21C 37/12](#))
- 11/07 . . Making serpentine-shaped articles by bending essentially in one plane
- 11/08 . . Bending by altering the thickness of part of the cross-section of the work ([B21D 11/06 takes precedence](#))
- 11/085 . . {by locally stretching or upsetting}
- 11/10 . . Bending specially adapted to produce specific articles, e.g. leaf springs ([making or bending leaf springs B21D 53/886](#))
- 11/12 . . the articles being reinforcements for concrete
- 11/125 . . . {Bending wire nets}
- 11/14 . . Twisting
- 11/15 . . Reinforcing rods for concrete
- 11/16 . . Crankshafts
- 11/18 . . Jogging
- 11/20 . . Bending sheet metal, not otherwise provided for
- 11/203 . . {Round bending}
- 11/206 . . {Curving corrugated sheets}
- 11/22 . . Auxiliary equipment, e.g. positioning devices
- 13/00 Corrugating sheet metal, rods or profiles; Bending sheet metal, rods or profiles into wave form ([tubes B21D 15/00](#))**
- 13/02 . . by pressing
- 13/04 . . by rolling
- 13/045 . . {the corrugations being parallel to the feeding movement}
- 13/06 . . by drawing
- 13/08 . . by combined methods
- 13/10 . . into a peculiar profiling shape
- 15/00 Corrugating tubes (wrinkle-bending using mandrels or the like [B21D 9/14](#))**

15/02	. longitudinally	22/201	. . {Work-pieces; preparation of the work-pieces, e.g. lubricating, coating}
15/03	. . by applying fluid pressure	22/203	. . {of compound articles}
15/04	. transversely, e.g. helically	22/205	. . {Hydro-mechanical deep-drawing}
15/06	. . annularly {(with thinning <a href="#">B21C 37/205</a> )}	22/206	. . {articles from a strip in several steps, the articles being coherent with the strip during the operation}
15/10	. . by applying fluid pressure		
15/105	. . . {by applying elastic material}	22/208	. . {by heating the blank or deep-drawing associated with heat treatment ( <a href="#">C21D</a> takes precedence)}
15/12	. Bending tubes into wave form	22/21	. . without fixing the border of the blank
<b>17/00</b>	<b>Forming single grooves in sheet metal or tubular or hollow articles</b>	22/22	. . with devices for holding the edge of the blanks ( <a href="#">B21D 22/24</a> - <a href="#">B21D 22/30</a> take precedence; shaping over a die without external former <a href="#">B21D 11/02</a> )
17/02	. by pressing (grooving or notching of bolts, studs, or the like <a href="#">B21K 1/54</a> )		
17/025	. . {by pressing tubes axially}	22/225	. . . {with members for radially pushing the blanks}
17/04	. by rolling	22/24	. . involving two drawing operations having effects in opposite directions with respect to the blank
<b>19/00</b>	<b>Flanging or other edge treatment, e.g. of tubes (connecting by making use of folds <a href="#">B21D 39/00</a>; flaring-out tube ends <a href="#">B21D 41/02</a>)</b>	22/26	. . for making peculiarly, e.g. irregularly, shaped articles
19/005	. {Edge deburring or smoothing}	22/28	. . of cylindrical articles using consecutive dies
19/02	. by continuously-acting tools moving along the edge (edge-curling <a href="#">B21D 19/12</a> )	22/283	. . . {with ram and dies aligning means}
19/04	. . shaped as rollers	22/286	. . . {with lubricating or cooling means}
19/043	. . . {for flanging edges of plates}	22/30	. . to finish articles formed by deep-drawing
19/046	. . . {for flanging edges of tubular products}	<b>24/00</b>	<b>Special deep-drawing arrangements in, or in connection with, presses</b>
19/06	. . . working inwardly	24/005	. {Multi-stage presses}
19/08	. by single or successive action of pressing tools, e.g. vice jaws	24/02	. Die-cushions
19/082	. . {for making negative angles}	24/04	. Blank holders; Mounting means therefor
19/084	. . . {with linear cams, e.g. aerial cams}	24/06	. . Mechanically spring-loaded blank holders
19/086	. . . {with rotary cams}	24/08	. . Pneumatically or hydraulically loaded blank holders
19/088	. . {for flanging holes}	24/10	. Devices controlling or operating blank holders independently, or in conjunction with dies
19/10	. . working inwardly	24/12	. . mechanically
19/12	. Edge-curling	24/14	. . pneumatically or hydraulically
19/14	. . Reinforcing edges, e.g. armouring same	24/16	. Additional equipment in association with the tools, e.g. for shearing, for trimming
19/16	. Reverse flanging of tube ends		
<b>21/00</b>	<b>Combined processes according to methods covered by groups <a href="#">B21D 1/00</a> - <a href="#">B21D 19/00</a></b>	<b>25/00</b>	<b>Working sheet metal of limited length by stretching, e.g. for straightening</b>
<b>Stamping, Spinning, Deep-drawing; Working sheet metal of limited length by stretching; Punching</b>		25/02	. by pulling over a die
<b>22/00</b>	<b>Shaping without cutting, by stamping, spinning, or deep-drawing (otherwise than using rigid devices or tools or yieldable or resilient pads <a href="#">B21D 26/00</a>)</b>	25/04	. Clamping arrangements
22/02	. Stamping using rigid devices or tools	<b>26/00</b>	<b>Shaping without cutting otherwise than using rigid devices or tools or yieldable or resilient pads, i.e. applying fluid pressure or magnetic forces (stamping using resilient pads <a href="#">B21D 22/10</a>)</b>
22/022	. . {by heating the blank or stamping associated with heat treatment ( <a href="#">C21D</a> takes precedence)}	26/02	. by applying fluid pressure
22/025	. . {for tubular articles}	26/021	. . Deforming sheet bodies
22/027	. . {for flattening the ends of corrugated sheets}	26/023	. . . including an additional treatment performed by fluid pressure, e.g. perforating
22/04	. . for dimpling (combined with perforating <a href="#">B21D 28/24</a> )	26/025	. . . Means for controlling the clamping or opening of the moulds
22/06	. . having relatively-movable die parts	26/027	. . . Means for controlling fluid parameters, e.g. pressure or temperature
22/08	. . with die parts on rotating carriers	26/029	. . . Closing or sealing means
22/10	. Stamping using yieldable or resilient pads	26/031	. . . Mould construction ( <a href="#">B21D 26/025</a> - <a href="#">B21D 26/029</a> take precedence)
22/105	. . {of tubular products}	26/033	. . Deforming tubular bodies (corrugating tubes by applying fluid pressure <a href="#">B21D 15/03</a> , <a href="#">B21D 15/10</a> )
22/12	. . using enclosed flexible chambers	26/035	. . . including an additional treatment performed by fluid pressure, e.g. perforating
22/125	. . . {of tubular products}	26/037	. . . Forming branched tubes
22/14	. Spinning		
22/16	. . over shaping mandrels or formers		
22/18	. . using tools guided to produce the required profile		
22/185	. . . {making bombed objects}		
22/20	. Deep-drawing (special deep-drawing arrangements in, or in connection with, presses <a href="#">B21D 24/00</a> )		

- 26/039 . . . Means for controlling the clamping or opening of the moulds
- 26/041 . . . Means for controlling fluid parameters, e.g. pressure or temperature
- 26/043 . . . Means for controlling the axial pusher
- 26/045 . . . Closing or sealing means
- 26/047 . . . Mould construction  
([B21D 26/037](#) - [B21D 26/045](#) take precedence)
- 26/049 . . . Deforming bodies having a closed end
- 26/051 . . . Deforming double-walled bodies
- 26/053 . . characterised by the material of the blanks
- 26/055 . . . Blanks having super-plastic properties
- 26/057 . . . Tailored blanks
- 26/059 . . . Layered blanks
- 26/06 . . by shock waves
- 26/08 . . . generated by explosives, e.g. chemical explosives
- 26/10 . . . generated by evaporation, e.g. of wire, of liquids
- 26/12 . . . initiated by spark discharge
- 26/14 . . applying magnetic forces
- 28/00 Shaping by press-cutting; Perforating**
- 28/002 . {Drive of the tools ([B21D 28/007](#) and [B21D 28/20](#) take precedence)}
- 28/005 . . {Adjustment of the punch stroke for compensating wear}
- 28/007 . {Explosive cutting or perforating}
- 28/02 . Punching blanks or articles with or without obtaining scrap ([cutting nails or pins from strips or sheet material B21G 3/26](#)); Notching
- 28/04 . . Centering the work; Positioning the tools
- 28/06 . . Making more than one part out of the same blank; Scrapless working
- 28/08 . . . Zig-zag sequence working
- 28/10 . . Incompletely punching in such a manner that the parts are still coherent with the work
- 28/12 . . Punching using rotatable carriers
- 28/125 . . . {with multi-tools}
- 28/14 . . Dies ([ejecting or stripping-off devices arranged in punching machines or tools B21D 45/00](#))
- 28/145 . . . {with means for slug retention, e.g. a groove}
- 28/16 . . Shoulder or burr prevention {, e.g. fine-blanking}
- 28/18 . . Yieldable, e.g. rubber, punching pads
- 28/20 . . Applications of drives {for reducing noise or wear}
- 28/22 . . Notching the peripheries of circular blanks, e.g. laminations for dynamo-electric machines
- 28/24 . Perforating, i.e. punching holes
- 28/243 . . {in profiles}
- 28/246 . . {Selection of punches}
- 28/26 . . in sheets or flat parts
- 28/265 . . . {with relative movement of sheet and tools enabling the punching of holes in predetermined locations of the sheet, e.g. holes punching with template}
- 28/28 . . in tubes or other hollow bodies
- 28/285 . . . {punching outwards}
- 28/30 . . in annular parts, e.g. rims
- 28/32 . . in other articles of special shape
- 28/325 . . . {using cam or wedge mechanisms, e.g. aerial cams}
- 28/34 . . Perforating tools; Die holders
- 28/343 . . . {Draw punches}
- 28/346 . . . {length adjustable perforating tools}
- 28/36 . . using rotatable work or tool holders
- 31/00 Other methods for working sheet metal, metal tubes, metal profiles** ([deforming one surface of tubes helically by rolling B21H 3/00](#); [upsetting B21J 5/08](#); [working metal by removing material therefrom B23](#); [embossing B44B](#))
- 31/005 . {Incremental shaping or bending, e.g. stepwise moving a shaping tool along the surface of the workpiece ([B21D 22/14](#) takes precedence)}
- 31/02 . Stabbing or piercing, e.g. for making sieves ([dimpling B21D 22/04](#); [perforating by punching B21D 28/24](#))
- 31/04 . Expanding other than provided for in groups [B21D 1/00](#) - [B21D 28/00](#), e.g. for making expanded metal ([B21D 47/00](#) takes precedence; [enlarging tube ends B21D 41/02](#))
- 31/043 . . {Making use of slitting discs or punch cutters}
- 31/046 . . {making use of rotating cutters}
- 31/06 . Deforming sheet metal, tubes or profiles by sequential impacts, e.g. hammering, beating, peen forming ([forging hammers B21J 7/00](#))
- 33/00 Special measures in connection with working metal foils, e.g. gold foils** ([cutting or perforating of metal foil analogous to paper B26](#))
- 35/00 Combined processes according to {or processes combined with} methods covered by groups [B21D 1/00](#) - [B21D 31/00](#)** ([B21D 21/00](#) takes precedence)
- 35/001 . {Shaping combined with punching, e.g. stamping and perforating}
- 35/002 . {Processes combined with methods covered by groups [B21D 1/00](#) - [B21D 31/00](#)}
- 35/003 . . {Simultaneous forming, e.g. making more than one part per stroke ([B21D 26/06](#) takes precedence)}
- 35/005 . . {characterized by the material of the blank or the workpiece ([B21D 26/053](#) takes precedence)}
- 35/006 . . . {Blanks having varying thickness, e.g. tailored blanks}
- 35/007 . . . {Layered blanks ([B21D 22/203](#) takes precedence; [joining superposed plates B21D 39/031](#), [B21D 39/034](#), [B21D 39/035](#))}
- 35/008 . . {involving vibration, e.g. ultrasonic}
- 37/00 Tools as parts of machines covered by this subclass** ([forms or constructions of tools uniquely adapted for particular operations, see the relevant groups for the operations](#))
- 37/01 . Selection of materials
- 37/02 . Die constructions enabling assembly of the die parts in different ways ([B21D 37/06](#) takes precedence)
- 37/04 . Movable or exchangeable mountings for tools
- 37/06 . . Pivotaly-arranged tools, e.g. disengageable ([die sets with dies pivoted to one another B21D 37/12](#))
- 37/08 . Dies with different parts for several steps in a process
- 37/10 . Die sets; Pillar guides
- 37/12 . . Particular guiding equipment, {e.g. pliers}; Special arrangements for interconnection or cooperation of dies



37/14	• Particular arrangements for handling and holding in place complete dies	41/02	• Enlarging
37/142	• • {Spotting presses}	41/021	• • {by means of tube-flaring hand tools}
37/145	• • {Die storage magazines}	41/023	• • • {comprising rolling elements}
37/147	• • {Tool exchange carts}	41/025	• • {by means of impact-type swaging hand tools}
37/16	• Heating or cooling	41/026	• • {by means of mandrels}
37/18	• Lubricating{, e.g. lubricating tool and workpiece simultaneously (lubricating workpieces for deep-drawing <a href="#">B21D 22/201</a> )}	41/028	• • • {expandable mandrels}
37/20	• Making tools by operations not covered by a single other subclass	41/04	• Reducing; Closing
37/205	• • {Making cutting tools}	41/045	• • {Closing}
<b>39/00</b>	<b>Application of procedures in order to connect objects or parts, e.g. coating with sheet metal otherwise than by plating ({joining mitred profiles <a href="#">B21D 53/745</a>; } riveting <a href="#">B21J</a>; uniting components by forging or pressing to form integral members <a href="#">B21K 25/00</a>; welding <a href="#">B23K</a>; press-fitting, force-fitting, or shrinking in general <a href="#">B23P 11/00</a>, <a href="#">B21D 19/00</a>; by adhesives <a href="#">F16B 11/00</a>{; Connections as such <a href="#">F16L</a>, <a href="#">F16B</a>)}); Tube expanders</b>	<b>43/00</b>	<b>Feeding, positioning or storing devices combined with, or arranged in, or specially adapted for use in connection with, apparatus for working or processing sheet metal, metal tubes or metal profiles; Associations therewith of cutting devices (cutting devices associated with the tool, <a href="#">see the relevant group for the tool</a>)</b>
39/02	• of sheet metal by folding, e.g. connecting edges of a sheet to form a cylinder	43/003	• {Positioning devices ( <a href="#">B21D 28/04</a> and <a href="#">B21D 28/265</a> take precedence; stops <a href="#">B21D 43/26</a> ; centering moving strips <a href="#">B21D 43/023</a> )}
39/021	• • {for panels, e.g. vehicle doors}	43/006	• {Feeding elongated articles, such as tubes, bars, or profiles}
39/023	• • • {using rollers}	43/02	• Advancing work in relation to the stroke of the die or tool
39/025	• • {Hand tools}	43/021	• • {Control or correction devices in association with moving strips}
39/026	• • {Reinforcing the connection by locally deforming}	43/022	• • • {Loop-control}
39/028	• • {Reinforcing the connection otherwise than by deforming, e.g. welding}	43/023	• • • {Centering devices, e.g. edge guiding}
39/03	• of sheet metal otherwise than by folding	43/025	• • {Fault detection, e.g. misfeed detection}
39/031	• • {Joining superposed plates by locally deforming without slitting or piercing}	43/026	• • {Combination of two or more feeding devices provided for in <a href="#">B21D 43/04</a> - <a href="#">B21D 43/18</a> }
39/032	• • • {by fitting a projecting part integral with one plate in a hole of the other plate}	43/027	• • {Combined feeding and ejecting devices}
39/034	• • {Joining superposed plates by piercing}	43/028	• • {Tools travelling with material, e.g. flying punching machines}
39/035	• • {Joining superposed plates by slitting}	43/04	• • by means in mechanical engagement with the work
39/037	• • {Interlocking butt joints}	43/05	• • • specially adapted for multi-stage presses ({ <a href="#">B21D 43/145</a> takes precedence})
39/038	• • {Perpendicular plate connections}	43/052	• • • • {Devices having a cross bar}
39/04	• of tubes with tubes; of tubes with rods ({ <a href="#">crimped pipe joints as such <a href="#">F16L 13/14</a></a> })	43/055	• • • • {Devices comprising a pair of longitudinally and laterally movable parallel transfer bars}
39/042	• • {using explosives (by explosive welding <a href="#">B23K 20/08</a> )}	43/057	• • • • {Devices for exchanging transfer bars or grippers; Idle stages, e.g. exchangeable}
39/044	• • {perpendicular}	43/06	• • • by positive or negative engaging parts co-operating with corresponding parts of the sheet or the like to be processed, e.g. carrier bolts or grooved section in the carriers
39/046	• • {Connecting tubes to tube-like fittings}	43/08	• • • by rollers ({ <a href="#">B21D 43/145</a> takes precedence})
39/048	• • {using presses for radially crimping tubular elements}	43/09	• • • • by one or more pairs of rollers for feeding sheet or strip material
39/06	• of tubes in openings, e.g. rolling-in	43/10	• • • by grippers ({ <a href="#">B21D 43/055</a> , <a href="#">B21D 43/057</a> , <a href="#">B21D 43/145</a> take precedence})
39/063	• • {for assembling ladders}	43/105	• • • • {Manipulators, i.e. mechanical arms carrying a gripper element having several degrees of freedom}
39/066	• • {using explosives}	43/11	• • • • for feeding sheet or strip material
39/08	• Tube expanders	43/12	• • • by chains or belts ({ <a href="#">B21D 43/145</a> takes precedence})
39/10	• • with rollers for expanding only	43/13	• • • by linearly moving tables
39/12	• • with rollers for expanding and flanging	43/14	• • • by turning devices, e.g. turn-tables
39/14	• • with balls	43/145	• • • • {Turnover devices, i.e. by turning about a substantially horizontal axis}
39/16	• • with torque limiting devices	43/16	• • by gravity, e.g. chutes
39/18	• • Rollers of special shape	43/18	• • by means in pneumatic or magnetic engagement with the work
39/20	• • with mandrels, e.g. expandable		
39/203	• • • {expandable by fluid or elastic material}		
39/206	• • • • {by axially compressing the elastic material}		
<b>41/00</b>	<b>Application of procedures in order to alter the diameter of tube ends (<a href="#">B21D 39/00</a> takes precedence{; plastic tubes <a href="#">B29C 57/08</a>})</b>		

43/20	• Storage arrangements; Piling or unpling ( <a href="#">in general B65G, {B65H}</a> )	51/24	• • high-pressure containers, e.g. boilers, bottles
43/22	• • Devices for piling sheets	51/26	• • cans or tins; Closing same in a permanent manner ( <a href="#">making outlet arrangements B21D 51/38; welding or soldering B23K</a> )
43/24	• • Devices for removing sheets from a stack		
43/26	• Stops	51/2607	• • • {Locally embossing the walls of formed can bodies ( <a href="#">B44B 5/00, B44C 1/24, B44C 3/085 take precedence; bulging B21D 51/2646</a> )}
43/28	• Associations of cutting devices therewith	51/2615	• • • {Edge treatment of cans or tins}
43/282	• • {Discharging crop ends or the like}	51/2623	• • • • {Curling}
43/285	• • {Devices for handling elongated articles, e.g. bars, tubes or profiles ( <a href="#">B21D 43/282, B21D 43/287 take precedence</a> )}	51/263	• • • • {Flanging}
43/287	• • {Devices for handling sheet or strip material ( <a href="#">B21D 43/282 takes precedence</a> )}	51/2638	• • • • {Necking}
		51/2646	• • • {Of particular non cylindrical shape, e.g. conical, rectangular, polygonal, bulged}
<b>45/00</b>	<b>Ejecting or stripping-off devices arranged in machines or tools dealt with in this subclass</b>	51/2653	• • • {Methods or machines for closing cans by applying caps or bottoms}
45/003	• {in punching machines or punching tools}	51/2661	• • • • {Sealing or closing means therefor}
45/006	• • {Stripping-off devices}	51/2669	• • • {Transforming the shape of formed can bodies; Forming can bodies from flattened tubular blanks; Flattening can bodies}
45/02	• Ejecting devices	51/2676	• • • {Cans or tins having longitudinal or helical seams}
45/04	• • interrelated with motion of tool	51/2684	• • • {Cans or tins having circumferential side seams}
45/06	• Stripping-off devices	51/2692	• • • {Manipulating, e.g. feeding and positioning devices; Control systems}
45/065	• • {for deep-drawn cans, e.g. using stripping fingers}	51/28	• • • Folding the longitudinal seam
45/08	• • interrelated with motion of tool	51/30	• • • Folding the circumferential seam
45/10	• Combined ejecting and stripping-off devices	51/32	• • • • by rolling
		51/34	• • • • by pressing
		51/36	• • collapsible or like thin-walled tubes, e.g. for toothpaste
		51/365	• • • {involving fixing closure members to the tubes, e.g. nozzles}
		51/38	• • Making inlet or outlet arrangements of cans, tins, baths, bottles, or other vessels; Making can ends; Making closures
		51/383	• • • {scoring lines, tear strips or pulling tabs}
		51/386	• • • • {on the side-wall of containers}
		51/40	• • • Making outlet openings, e.g. bung holes
		51/42	• • • • Making or attaching spouts
		51/44	• • • Making closures, e.g. caps ( <a href="#">folded of thin metal foils in the way of making paper caps B31D 5/00; making closures in conjunction with applying same B67B</a> )
		51/443	• • • • {easily removable closures, e.g. by means of tear strips}
		51/446	• • • • {Feeding or removal of material}
		51/46	• • • • Placing sealings or sealing material ( <a href="#">moulding plastic sealing material into closure members B29C 70/80</a> )}
		51/48	• • • • Making crown caps
		51/50	• • • • Making screw caps
		51/52	• • boxes, cigarette cases, or the like
		51/54	• • cartridge cases, e.g. for ammunition, for letter carriers in pneumatic-tube plants
		<b>53/00</b>	<b>Making other particular articles (<a href="#">making wire fabrics B21F; making chains or chain parts B21L</a>)</b>
		53/02	• heat exchangers {or parts thereof}, e.g. radiators, condensers {fins, headers} ( <a href="#">making finned or ribbed tubes by fixing strip material or the like to tubes B21C 37/22</a> )
		53/022	• • {Making the fins}
		53/025	• • • {Louvered fins}
<b>Processing sheet metal or metal tubes, or processing metal profiles according to any of groups B21D 1/00 - B21D 45/00, in the manufacture of finished or semi-finished articles</b>			
<b>47/00</b>	<b>Making rigid structural elements or units, e.g. honeycomb structures</b>		
47/005	• {Making gratings}		
47/01	• beams or pillars		
47/02	• • by expanding		
47/04	• composite sheet metal profiles		
<b>49/00</b>	<b>Sheathing or stiffening objects (<a href="#">by winding wire or tape thereon B65H 54/00, B65H 81/00; specially adapted for manufacturing conductors or cables H01B 13/26</a>)</b>		
49/005	• {Hollow objects}		
<b>51/00</b>	<b>Making hollow objects (<a href="#">from thick-walled or non uniform tubes B21K 21/00</a>)</b>		
51/02	• characterised by the structure of the objects ( <a href="#">{B21D 51/26 takes precedence}</a> )		
	<b>NOTE</b>		
	Making hollow objects characterised both by their structure and by their use is classified only in group <a href="#">B21D 51/16</a>		
51/04	• • built-up objects, e.g. objects with rigidly-attached bottom or cover		
51/06	• • folded objects		
51/08	• • ball-shaped objects		
51/10	• • conically or cylindrically shaped objects		
51/12	• • objects with corrugated walls		
51/14	• • Flattening hollow objects for transport or storage; Re-forming same ( <a href="#">making tubes from doubled flat material B21C 37/14</a> )		
51/16	• characterised by the use of the objects ( <a href="#">making heat exchangers B21D 53/02</a> )		
51/18	• • vessels, e.g. tubs, vats, tanks, sinks, or the like		
51/20	• • • barrels		
51/22	• • • pots, e.g. for cooking		

- B21D45/00,...

- |  |  |
|--|--|
| <ul style="list-style-type: none"> <li>53/027 . . {by helically or spirally winding elongated elements}</li> <li>53/04 . . of sheet metal</li> <li>53/045 . . . {by inflating partially united plates}</li> <li>53/06 . . of metal tubes</li> <li>53/08 . . of both metal tubes and sheet metal (connecting tubes in openings <a href="#">B21D 39/06</a>)</li> <li>53/085 . . . {with fins placed on zig-zag tubes or parallel tubes}</li> <li>53/10 . parts of bearings; sleeves; valve seats or the like</li> <li>53/12 . . cages for bearings</li> <li>53/14 . belts, e.g. machine-gun belts</li> <li>53/16 . rings, e.g. barrel hoops</li> <li>53/18 . . of hollow or C-shaped cross-section, e.g. for curtains, for eyelets</li> <li>53/20 . . washers, e.g. for sealing</li> <li>53/22 . . . with means for preventing rotation</li> <li>53/24 . nuts or like thread-engaging members</li> <li>53/26 . wheels or the like</li> <li>53/261 . . {pulleys}</li> <li>53/262 . . {with inscriptions or the like, e.g. printing wheels}</li> <li>53/264 . . {wheels out of a single piece (<a href="#">B21D 53/261</a> takes precedence)}</li> <li>53/265 . . {parts of wheels (<a href="#">B21D 53/28</a>, <a href="#">B21D 53/30</a> take precedence)}</li> <li>53/267 . . {blower wheels, i.e. wheels provided with fan elements}</li> <li>53/268 . . {wheels having spokes}</li> <li>53/28 . . gear wheels</li> <li>53/30 . . wheel rims</li> <li>53/32 . . wheel covers</li> <li>53/34 . . brake drums</li> <li>53/36 . clips, clamps, or like fastening or attaching devices, e.g. for electric installation</li> <li>53/38 . locksmith's goods, e.g. handles</li> <li>53/40 . . hinges, e.g. door hinge plates</li> <li>53/42 . . keys {(making keys by combined operations <a href="#">B23P 15/005</a>)}</li> <li>53/44 . fancy goods, e.g. jewellery products</li> <li>53/46 . haberdashery, e.g. buckles, combs; pronged fasteners, e.g. staples</li> <li>53/48 . . buttons, e.g. press-buttons, snap fasteners</li> <li>53/50 . . metal slide-fastener parts</li> <li>53/52 . . . fastener elements; Attaching such elements so far as this procedure is combined with the process for making the elements</li> <li>53/54 . . . slides</li> <li>53/56 . . . stops</li> <li>53/58 . end-pieces for laces or ropes</li> <li>53/60 . cutlery wares; garden tools or the like</li> <li>53/62 . . spoons; table forks</li> <li>53/64 . . knives; scissors; cutting blades (<a href="#">B21D 53/72</a> takes precedence; handle portions <a href="#">B21D 53/70</a>)</li> <li>53/642 . . . {scissors}</li> <li>53/645 . . . {safety razor blades}</li> <li>53/647 . . . {mower blades}</li> <li>53/66 . . spades; shovels (handle portions <a href="#">B21D 53/70</a>)</li> <li>53/68 . . rakes, garden forks, or the like (handle portions <a href="#">B21D 53/70</a>)</li> <li>53/70 . . handle portions (<a href="#">B21D 53/72</a> takes precedence)</li> <li>53/72 . . sickles; scythes</li> </ul> | <ul style="list-style-type: none"> <li>53/74 . frames for openings, e.g. for windows, doors, handbags</li> <li>53/745 . . {Joining mitred profiles comprising punching the profiles on a corner-angle connecting piece}</li> <li>53/76 . writing or drawing instruments, e.g. writing pens, erasing pens</li> <li>53/78 . propeller blades; turbine blades</li> <li>53/80 . dustproof covers; safety covers</li> <li>53/82 . perforated music sheets; pattern sheets, e.g. for control purposes, stencils</li> <li>53/84 . other parts for engines, e.g. connecting-rods</li> <li>53/845 . . {Making camshafts}</li> <li>53/86 . other parts for bicycles or motorcycles</li> <li>53/88 . other parts for vehicles, e.g. cowlings, mudguards</li> <li>53/883 . . {reflectors}</li> <li>53/886 . . {leaf springs}</li> <li>53/90 . . axle-housings</li> <li>53/92 . other parts for aircraft</li> <li><b>55/00</b> <b>Safety devices protecting the machine or the operator, specially adapted for apparatus or machines dealt with in this subclass (for presses in general <a href="#">B30B</a>; safety devices in general <a href="#">F16P</a>)</b></li> </ul> |
|--|--|