

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](#)

WARNING

In this subclass non-limiting references (in the sense of paragraph 39 of the Guide to the IPC) may still be displayed in the scheme.

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	22/12	. . using enclosed flexible chambers
13/045	. . {the corrugations being parallel to the feeding movement}	22/125	. . . {of tubular products}
13/06	. by drawing	22/14	. Spinning
13/08	. by combined methods	22/16	. . over shaping mandrels or formers
13/10	. into a peculiar profiling shape	22/18	. . using tools guided to produce the required profile
15/00	Corrugating tubes (wrinkle-bending using mandrels or the like B21D 9/14)	22/185	. . . {making bombed objects}
15/02	. longitudinally	22/20	. Deep-drawing (special deep-drawing arrangements in, or in connection with, presses B21D 24/00)
15/03	. . by applying fluid pressure	22/201	. . {Work-pieces; preparation of the work-pieces, e.g. lubricating, coating}
15/04	. transversely, e.g. helically	22/203	. . {of compound articles}
15/06	. . annularly {(with thinning B21C 37/205)}	22/205	. . {Hydro-mechanical deep-drawing}
15/10	. . by applying fluid pressure	22/206	. . {articles from a strip in several steps, the articles being coherent with the strip during the operation}
15/105	. . . {by applying elastic material}	22/208	. . {by heating the blank or deep-drawing associated with heat treatment (C21D takes precedence)}
15/12	. Bending tubes into wave form	22/21	. . without fixing the border of the blank
17/00	Forming single grooves in sheet metal or tubular or hollow articles	22/22	. . with devices for holding the edge of the blanks (B21D 22/24 - B21D 22/30 take precedence; shaping over a die without external former B21D 11/02)
17/02	. by pressing (grooving or notching of bolts, studs, or the like B21K 1/54)	22/225	. . . {with members for radially pushing the blanks}
17/025	. . {by pressing tubes axially}	22/24	. . involving two drawing operations having effects in opposite directions with respect to the blank
17/04	. by rolling	22/26	. . for making peculiarly, e.g. irregularly, shaped articles
19/00	Flanging or other edge treatment, e.g. of tubes (connecting by making use of folds B21D 39/00; flaring-out tube ends B21D 41/02)	22/28	. . of cylindrical articles using consecutive dies
19/005	. {Edge deburring or smoothing}	22/283	. . . {with ram and dies aligning means}
19/02	. by continuously-acting tools moving along the edge (edge-curling B21D 19/12)	22/286	. . . {with lubricating or cooling means}
19/04	. . shaped as rollers	22/30	. . to finish articles formed by deep-drawing
19/043	. . . {for flanging edges of plates}	24/00	Special deep-drawing arrangements in, or in connection with, presses
19/046	. . . {for flanging edges of tubular products}	24/005	. {Multi-stage presses}
19/06	. . . working inwardly	24/02	. Die-cushions
19/08	. by single or successive action of pressing tools, e.g. vice jaws	24/04	. Blank holders; Mounting means therefor
19/082	. . {for making negative angles}	24/06	. . Mechanically spring-loaded blank holders
19/084	. . . {with linear cams, e.g. aerial cams}	24/08	. . Pneumatically or hydraulically loaded blank holders
19/086	. . . {with rotary cams}	24/10	. Devices controlling or operating blank holders independently, or in conjunction with dies
19/088	. . {for flanging holes}	24/12	. . mechanically
19/10	. . working inwardly	24/14	. . pneumatically or hydraulically
19/12	. Edge-curling	24/16	. Additional equipment in association with the tools, e.g. for shearing, for trimming
19/14	. . Reinforcing edges, e.g. armouring same	25/00	Working sheet metal of limited length by stretching, e.g. for straightening
19/16	. Reverse flanging of tube ends	25/02	. by pulling over a die
21/00	Combined processes according to methods covered by groups B21D 1/00 - B21D 19/00	25/04	. Clamping arrangements
<u>Stamping, Spinning, Deep-drawing; Working sheet metal of limited length by stretching; Punching</u>		26/00	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 B21D 22/10)
22/00	Shaping without cutting, by stamping, spinning, or deep-drawing (otherwise than using rigid devices or tools or yieldable or resilient pads B21D 26/00)	26/02	. by applying fluid pressure
22/02	. Stamping using rigid devices or tools	26/021	. . Deforming sheet bodies
22/022	. . {by heating the blank or stamping associated with heat treatment (C21D takes precedence)}	26/023	. . . including an additional treatment performed by fluid pressure, e.g. perforating
22/025	. . {for tubular articles}	26/025	. . . Means for controlling the clamping or opening of the moulds
22/027	. . {for flattening the ends of corrugated sheets}	26/027	. . . Means for controlling fluid parameters, e.g. pressure or temperature
22/04	. . for dimpling (combined with perforating B21D 28/24)		
22/06	. . having relatively-movable die parts		
22/08	. . with die parts on rotating carriers		
22/10	. Stamping using yieldable or resilient pads		
22/105	. . {of tubular products}		

- 26/029 . . . Closing or sealing means
- 26/031 . . . Mould construction
([B21D 26/025](#) - [B21D 26/029](#) take precedence)
- 26/033 . . Deforming tubular bodies ([corrugating tubes by applying fluid pressure B21D 15/03, B21D 15/10](#))
- 26/035 . . . including an additional treatment performed by fluid pressure, e.g. perforating
- 26/037 . . . Forming branched tubes
- 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
- 37/142 . . {Spotting presses}
- 37/145 . . {Die storage magazines}
- 37/147 . . {Tool exchange carts}
- 37/16 . Heating or cooling
- 37/18 . Lubricating {, e.g. lubricating tool and workpiece simultaneously ([lubricating workpieces for deep-drawing B21D 22/201](#))}
- 37/20 . Making tools by operations not covered by a single other subclass
- 37/205 . . {Making cutting tools}
- 39/00 Application of procedures in order to connect objects or parts, e.g. coating with sheet metal otherwise than by plating ({joining mitred profiles [B21D 53/745](#); } riveting [B21J](#); uniting components by forging or pressing to form integral members [B21K 25/00](#); welding [B23K](#); press-fitting, force-fitting, or shrinking in general [B23P 11/00](#), [B21D 19/00](#); by adhesives [F16B 11/00](#) {; Connections as such [F16L](#), [F16B](#)}); Tube expanders**
- 39/02 . of sheet metal by folding, e.g. connecting edges of a sheet to form a cylinder
- 39/021 . . {for panels, e.g. vehicle doors}
- 39/023 . . . {using rollers}
- 39/025 . . {Hand tools}
- 39/026 . . {Reinforcing the connection by locally deforming}
- 39/028 . . {Reinforcing the connection otherwise than by deforming, e.g. welding}
- 39/03 . of sheet metal otherwise than by folding
- 39/031 . . {Joining superposed plates by locally deforming without slitting or piercing}
- 39/032 . . . {by fitting a projecting part integral with one plate in a hole of the other plate}
- 39/034 . . {Joining superposed plates by piercing}
- 39/035 . . {Joining superposed plates by slitting}
- 39/037 . . {Interlocking butt joints}
- 39/038 . . {Perpendicular plate connections}
- 39/04 . of tubes with tubes; of tubes with rods {([crimped pipe joints as such \[F16L 13/14\]\(#\)](#))}
- 39/042 . . {using explosives ([by explosive welding \[B23K 20/08\]\(#\)](#))}
- 39/044 . . {perpendicular}
- 39/046 . . {Connecting tubes to tube-like fittings}
- 39/048 . . {using presses for radially crimping tubular elements}
- 39/06 . of tubes in openings, e.g. rolling-in
- 39/063 . . {for assembling ladders}
- 39/066 . . {using explosives}
- 39/08 . Tube expanders
- 39/10 . . with rollers for expanding only
- 39/12 . . with rollers for expanding and flanging
- 39/14 . . with balls
- 39/16 . . with torque limiting devices
- 39/18 . . Rollers of special shape
- 39/20 . . with mandrels, e.g. expandable
- 39/203 . . . {expandable by fluid or elastic material}
- 39/206 {by axially compressing the elastic material}
- 41/00 Application of procedures in order to alter the diameter of tube ends ([B21D 39/00 takes precedence](#) {; plastic tubes [B29C 57/08](#))}**
- 41/02 . Enlarging
- 41/021 . . {by means of tube-flaring hand tools}
- 41/023 . . . {comprising rolling elements}
- 41/025 . . {by means of impact-type swaging hand tools}
- 41/026 . . {by means of mandrels}
- 41/028 . . . {expandable mandrels}
- 41/04 . Reducing; Closing
- 41/045 . . {Closing}
- 43/00 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, see the relevant group for the tool](#))**
- 43/003 . {Positioning devices ([B21D 28/04](#) and [B21D 28/265](#) take precedence; stops [B21D 43/26](#); centering moving strips [B21D 43/023](#))}
- 43/006 . {Feeding elongated articles, such as tubes, bars, or profiles}
- 43/02 . Advancing work in relation to the stroke of the die or tool
- 43/021 . . {Control or correction devices in association with moving strips}
- 43/022 . . . {Loop-control}
- 43/023 . . . {Centering devices, e.g. edge guiding}
- 43/025 . . {Fault detection, e.g. misfeed detection}
- 43/026 . . {Combination of two or more feeding devices provided for in [B21D 43/04](#) - [B21D 43/18](#)}
- 43/027 . . {Combined feeding and ejecting devices}
- 43/028 . . {Tools travelling with material, e.g. flying punching machines}
- 43/04 . . by means in mechanical engagement with the work
- 43/05 . . . specially adapted for multi-stage presses {([B21D 43/145 takes precedence](#))}
- 43/052 {Devices having a cross bar}
- 43/055 {Devices comprising a pair of longitudinally and laterally movable parallel transfer bars}
- 43/057 {Devices for exchanging transfer bars or grippers; Idle stages, e.g. exchangeable}
- 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
- 43/08 . . . by rollers {([B21D 43/145 takes precedence](#))}
- 43/09 by one or more pairs of rollers for feeding sheet or strip material
- 43/10 . . . by grippers {([B21D 43/055](#), [B21D 43/057](#), [B21D 43/145 take precedence](#))}

43/105 {Manipulators, i.e. mechanical arms carrying a gripper element having several degrees of freedom}	51/04	. . built-up objects, e.g. objects with rigidly-attached bottom or cover
43/11 for feeding sheet or strip material	51/06	. . folded objects
43/12	. . . by chains or belts { (B21D 43/145 takes precedence) }	51/08	. . ball-shaped objects
43/13	. . . by linearly moving tables	51/10	. . conically or cylindrically shaped objects
43/14	. . . by turning devices, e.g. turn-tables	51/12	. . objects with corrugated walls
43/145 {Turnover devices, i.e. by turning about a substantially horizontal axis}	51/14	. . Flattening hollow objects for transport or storage; Re-forming same (making tubes from doubled flat material B21C 37/14)
43/16	. . by gravity, e.g. chutes	51/16	. characterised by the use of the objects (making heat exchangers B21D 53/02)
43/18	. . by means in pneumatic or magnetic engagement with the work	51/18	. . vessels, e.g. tubs, vats, tanks, sinks, or the like
43/20	. Storage arrangements; Piling or unpiling (in general B65G, {B65H})	51/20	. . . barrels
43/22	. . Devices for piling sheets	51/22	. . . pots, e.g. for cooking
43/24	. . Devices for removing sheets from a stack	51/24	. . high-pressure containers, e.g. boilers, bottles
43/26	. Stops	51/26	. . cans or tins; Closing same in a permanent manner (making outlet arrangements B21D 51/38; welding or soldering B23K)
43/28	. Associations of cutting devices therewith	51/2607	. . . {Locally embossing the walls of formed can bodies (B44B 5/00, B44C 1/24, B44C 3/085 take precedence; bulging B21D 51/2646)}
43/282	. . {Discharging crop ends or the like}	51/2615	. . . {Edge treatment of cans or tins}
43/285	. . {Devices for handling elongated articles, e.g. bars, tubes or profiles (B21D 43/282, B21D 43/287 take precedence)}	51/2623 {Curling}
43/287	. . {Devices for handling sheet or strip material (B21D 43/282 takes precedence)}	51/263 {Flanging}
45/00	Ejecting or stripping-off devices arranged in machines or tools dealt with in this subclass	51/2638 {Necking}
45/003	. {in punching machines or punching tools}	51/2646	. . . {Of particular non cylindrical shape, e.g. conical, rectangular, polygonal, bulged}
45/006	. . {Stripping-off devices}	51/2653	. . . {Methods or machines for closing cans by applying caps or bottoms}
45/02	. Ejecting devices	51/2661 {Sealing or closing means therefor}
45/04	. . interrelated with motion of tool	51/2669	. . . {Transforming the shape of formed can bodies; Forming can bodies from flattened tubular blanks; Flattening can bodies}
45/06	. Stripping-off devices	51/2676	. . . {Cans or tins having longitudinal or helical seams}
45/065	. . {for deep-drawn cans, e.g. using stripping fingers}	51/2684	. . . {Cans or tins having circumferential side seams}
45/08	. . interrelated with motion of tool	51/2692	. . . {Manipulating, e.g. feeding and positioning devices; Control systems}
45/10	. Combined ejecting and stripping-off devices	51/28	. . . Folding the longitudinal seam
<u>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</u>		51/30	. . . Folding the circumferential seam
47/00	Making rigid structural elements or units, e.g. honeycomb structures	51/32 by rolling
47/005	. {Making gratings}	51/34 by pressing
47/01	. beams or pillars	51/36	. . collapsible or like thin-walled tubes, e.g. for toothpaste
47/02	. . by expanding	51/365	. . . {involving fixing closure members to the tubes, e.g. nozzles}
47/04	. composite sheet metal profiles	51/38	. . Making inlet or outlet arrangements of cans, tins, baths, bottles, or other vessels; Making can ends; Making closures
49/00	Sheathing or stiffening objects (by winding wire or tape thereon B65H 54/00, B65H 81/00; specially adapted for manufacturing conductors or cables H01B 13/26)	51/383	. . . {scoring lines, tear strips or pulling tabs}
49/005	. {Hollow objects}	51/386 {on the side-wall of containers}
51/00	Making hollow objects (from thick-walled or non uniform tubes B21K 21/00)	51/40	. . . Making outlet openings, e.g. bung holes
51/02	. characterised by the structure of the objects {(B21D 51/26 takes precedence)}	51/42 Making or attaching spouts
	NOTE	51/44	. . . Making closures, e.g. caps (folded of thin metal foils in the way of making paper caps B31D 5/00; making closures in conjunction with applying same B67B)
	Making hollow objects characterised both by their structure and by their use is classified only in group B21D 51/16	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 {(moulding plastic sealing material into closure members B29C 70/80)}	53/52	. . . fastener elements; Attaching such elements so far as this procedure is combined with the process for making the elements
51/48 Making crown caps	53/54	. . . slides
51/50 Making screw caps	53/56	. . . stops
51/52	. . boxes, cigarette cases, or the like	53/58	. end-pieces for laces or ropes
51/54	. . cartridge cases, e.g. for ammunition, for letter carriers in pneumatic-tube plants	53/60	. cutlery wares; garden tools or the like
53/00	Making other particular articles (making wire fabrics B21F; making chains or chain parts B21L)	53/62	. . spoons; table forks
53/02	. heat exchangers {or parts thereof}, e.g. radiators, condensers {fins, headers} (making finned or ribbed tubes by fixing strip material or the like to tubes B21C 37/22)	53/64	. . knives; scissors; cutting blades (B21D 53/72 takes precedence; handle portions B21D 53/70)
53/022	. . {Making the fins}	53/642	. . . {scissors}
53/025	. . . {Louvered fins}	53/645	. . . {safety razor blades}
53/027	. . {by helically or spirally winding elongated elements}	53/647	. . . {mower blades}
53/04	. . of sheet metal	53/66	. . spades; shovels (handle portions B21D 53/70)
53/045	. . . {by inflating partially united plates}	53/68	. . rakes, garden forks, or the like (handle portions B21D 53/70)
53/06	. . of metal tubes	53/70	. . handle portions (B21D 53/72 takes precedence)
53/08	. . of both metal tubes and sheet metal (connecting tubes in openings B21D 39/06)	53/72	. . sickles; scythes
53/085	. . . {with fins places on zig-zag tubes or parallel tubes}	53/74	. frames for openings, e.g. for windows, doors, handbags
53/10	. parts of bearings; sleeves; valve seats or the like	53/745	. . {Joining mitred profiles comprising punching the profiles on a corner-angle connecting piece}
53/12	. . cages for bearings	53/76	. writing or drawing instruments, e.g. writing pens, erasing pens
53/14	. belts, e.g. machine-gun belts	53/78	. propeller blades; turbine blades
53/16	. rings, e.g. barrel hoops	53/80	. dustproof covers; safety covers
53/18	. . of hollow or C-shaped cross-section, e.g. for curtains, for eyelets	53/82	. perforated music sheets; pattern sheets, e.g. for control purposes, stencils
53/20	. . washers, e.g. for sealing	53/84	. other parts for engines, e.g. connecting-rods
53/22	. . . with means for preventing rotation	53/845	. . {Making camshafts}
53/24	. nuts or like thread-engaging members	53/86	. other parts for bicycles or motorcycles
53/26	. wheels or the like	53/88	. other parts for vehicles, e.g. cowlings, mudguards
53/261	. . {pulleys}	53/883	. . {reflectors}
53/262	. . {with inscriptions or the like, e.g. printing wheels}	53/886	. . {leaf springs}
53/264	. . {wheels out of a single piece (B21D 53/261 takes precedence)}	53/90	. . axle-housings
53/265	. . {parts of wheels (B21D 53/28 , B21D 53/30 take precedence)}	53/92	. other parts for aircraft
53/267	. . {blower wheels, i.e. wheels provided with fan elements}	55/00	Safety devices protecting the machine or the operator, specially adapted for apparatus or machines dealt with in this subclass (for presses in general B30B; safety devices in general F16P)
53/268	. . {wheels having spokes}		
53/28	. . gear wheels		
53/30	. . wheel rims		
53/32	. . wheel covers		
53/34	. . brake drums		
53/36	. clips, clamps, or like fastening or attaching devices, e.g. for electric installation		
53/38	. locksmith's goods, e.g. handles		
53/40	. . hinges, e.g. door hinge plates		
53/42	. . keys {(making keys by combined operations B23P 15/005)}		
53/44	. fancy goods, e.g. jewellery products		
53/46	. haberdashery, e.g. buckles, combs; pronged fasteners, e.g. staples		
53/48	. . buttons, e.g. press-buttons, snap fasteners		
53/50	. . metal slide-fastener parts		