

# CPC COOPERATIVE PATENT CLASSIFICATION

## B PERFORMING OPERATIONS; TRANSPORTING

(NOTES omitted)

### SHAPING

## B21 MECHANICAL METAL-WORKING WITHOUT ESSENTIALLY REMOVING MATERIAL; PUNCHING METAL

(NOTES omitted)

## B21C MANUFACTURE OF METAL SHEETS, WIRE, RODS, TUBES OR PROFILES, OTHERWISE THAN BY ROLLING; AUXILIARY OPERATIONS USED IN CONNECTION WITH METAL-WORKING WITHOUT ESSENTIALLY REMOVING MATERIAL

### 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.

### Metal drawing

		1/28	. . . Carriages; Connections of grippers thereto; Grippers
<b>1/00</b>	<b>Manufacture of metal sheets, metal wire, metal rods, metal tubes by drawing</b>	1/30	. . . Drives, e.g. carriage-traversing mechanisms; Driving elements, e.g. drawing chains; Controlling the drive {(endlessly revolving chain systems for metal coiling: <a href="#">B21C 47/3458</a> )}
1/003	. {Drawing materials of special alloys so far as the composition of the alloy requires or permits special drawing methods or sequences}		
1/006	. {using vibratory energy}	1/305	. . . . {Linear motor pulling devices}
1/02	. Drawing metal wire or like flexible metallic material by drawing machines or apparatus in which the drawing action is effected by drums	1/32	. . Feeding or discharging the material or mandrels
1/04	. . with two or more dies operating in series	1/34	. . Guiding or supporting the material or mandrels
1/06	. . . in which the material slips on the drums	<b>3/00</b>	<b>Profiling tools for metal drawing; Combinations of dies and mandrels</b>
1/08	. . . in which the material does not slip on the drums	3/02	. Dies; Selection of material therefor; Cleaning thereof
1/10	. . . . with accumulation of material between consecutively-arranged dies	3/025	. . {comprising diamond parts}
1/12	. . Regulating or controlling speed of drawing drums, e.g. to influence tension; Drives; Stop or relief mechanisms	3/04	. . with non-adjustable section ( <a href="#">B21C 3/08</a> takes precedence)
1/14	. . Drums, e.g. capstans; Connection of grippers thereto; Grippers specially adapted for drawing machines or apparatus of the drum type; Couplings specially adapted for these drums	3/06	. . with adjustable section ( <a href="#">B21C 3/08</a> takes precedence)
1/16	. Metal drawing by machines or apparatus in which the drawing action is effected by other means than drums, e.g. by a longitudinally-moved carriage pulling or pushing the work or stock for making metal sheets, bars, or tubes	3/08	. . with section defined by rollers, balls, or the like
1/18	. . from stock of limited length ( <a href="#">B21C 1/22</a> takes precedence)	3/10	. . with hydraulic forces acting immediately on work
1/20	. . from stock of essentially unlimited length ( <a href="#">B21C 1/22</a> takes precedence)	3/12	. . Die holders; Rotating dies
1/22	. . specially adapted for making tubular articles (bending sheet metal into tubular form by drawing <a href="#">B21D 5/10</a> )	3/14	. . . Die holders combined with devices for guiding the drawing material or combined with devices for cooling heating, or lubricating
1/24	. . . by means of mandrels	3/16	. Mandrels; Mounting or adjusting same
1/26	. . . . Push-bench drawing	3/18	. Making tools by operations not covered by a single other subclass; Repairing
1/27	. . Carriages; Drives	<b>5/00</b>	<b>Pointing; Push-pointing</b>
		5/003	. {of hollow material, e.g. tube}
		5/006	. {of solid material, e.g. wire or profiles}
		<b>9/00</b>	<b>Cooling, heating or lubricating drawing material (<a href="#">B21C 3/14</a> takes precedence)</b>
		9/005	. {Cold application of the lubricant (when combined with heating steps <a href="#">B21C 9/00</a> )}
		9/02	. Selection of compositions therefor

<b>19/00</b>	<b>Devices for straightening wire or like work combined with or specially adapted for use in connection with drawing or winding machines or apparatus</b>	23/32	<ul style="list-style-type: none"> <li>• Lubrication of metal being extruded or of dies, or the like, e.g. physical state of lubricant, location where lubricant is applied</li> </ul>
<b><u>Metal extruding</u></b>			
<b>23/00</b>	<b>Extruding metal; Impact extrusion</b>	<b>25/00</b>	<b>Profiling tools for metal extruding</b>
23/001	<ul style="list-style-type: none"> <li>• {to improve the material properties, e.g. lateral extrusion}</li> </ul>	25/02	<ul style="list-style-type: none"> <li>• Dies</li> </ul>
23/002	<ul style="list-style-type: none"> <li>• {Extruding materials of special alloys so far as the composition of the alloy requires or permits special extruding methods of sequences}</li> </ul>	25/025	<ul style="list-style-type: none"> <li>• . {Selection of materials therefor}</li> </ul>
23/004	<ul style="list-style-type: none"> <li>• {using vibratory energy}</li> </ul>	25/04	<ul style="list-style-type: none"> <li>• Mandrels</li> </ul>
23/005	<ul style="list-style-type: none"> <li>• {Continuous extrusion starting from solid state material (B21C 23/008 takes precedence)}</li> </ul>	25/06	<ul style="list-style-type: none"> <li>• Press heads, dies, or mandrels for coating work</li> </ul>
23/007	<ul style="list-style-type: none"> <li>• {Hydrostatic extrusion}</li> </ul>	25/08	<ul style="list-style-type: none"> <li>• Dies or mandrels with section variable during extruding, e.g. for making tapered work; Controlling variation</li> </ul>
23/008	<ul style="list-style-type: none"> <li>• . {Continuous extrusion}</li> </ul>	25/10	<ul style="list-style-type: none"> <li>• Making tools by operations not covered by a single other subclass</li> </ul>
23/01	<ul style="list-style-type: none"> <li>• starting from material of particular form or shape, e.g. mechanically pre-treated (B21C 23/22 takes precedence)</li> </ul>	<b>26/00</b>	<b>Rams or plungers; Discs therefor</b>
23/02	<ul style="list-style-type: none"> <li>• Making uncoated products</li> </ul>	<b>27/00</b>	<b>Containers for metal to be extruded (B21C 29/02 takes precedence)</b>
23/03	<ul style="list-style-type: none"> <li>• . by both direct and backward extrusion</li> </ul>	27/02	<ul style="list-style-type: none"> <li>• for making coated work</li> </ul>
23/035	<ul style="list-style-type: none"> <li>• . . {Making products of generally elongated shape}</li> </ul>	27/04	<ul style="list-style-type: none"> <li>• Venting metal-container chamber</li> </ul>
23/04	<ul style="list-style-type: none"> <li>• . by direct extrusion</li> </ul>	<b>29/00</b>	<b>Cooling or heating work or parts of the extrusion press; {Gas treatment of work}</b>
23/06	<ul style="list-style-type: none"> <li>• . . Making sheets</li> </ul>	29/003	<ul style="list-style-type: none"> <li>• {Cooling or heating of work}</li> </ul>
23/08	<ul style="list-style-type: none"> <li>• . . Making wire, bars, tubes</li> </ul>	29/006	<ul style="list-style-type: none"> <li>• {Gas treatment of work, e.g. to prevent oxidation or to create surface effects}</li> </ul>
23/085	<ul style="list-style-type: none"> <li>• . . . {Making tubes (B21C 23/10 take precedence)}</li> </ul>	29/02	<ul style="list-style-type: none"> <li>• {Cooling or heating} of containers for metal to be extruded</li> </ul>
23/10	<ul style="list-style-type: none"> <li>• . . . Making finned tubes</li> </ul>	29/04	<ul style="list-style-type: none"> <li>• {Cooling or heating} of press heads, dies or mandrels</li> </ul>
23/12	<ul style="list-style-type: none"> <li>• . . . Extruding bent tubes or rods</li> </ul>	<b>31/00</b>	<b>Control devices, e.g. for regulating the pressing speed or temperature of metal (B21C 25/08 takes precedence); Measuring devices, e.g. for temperature of metal, combined with or specially adapted for use in connection with extrusion presses</b>
23/14	<ul style="list-style-type: none"> <li>• . . Making other products</li> </ul>	<b>33/00</b>	<b>Feeding extrusion presses with metal to be extruded {; Loading the dummy block}</b>
23/142	<ul style="list-style-type: none"> <li>• . . . {Making profiles}</li> </ul>	33/002	<ul style="list-style-type: none"> <li>• {Encapsulated billet (manufacturing wires or fine wires B21C 37/045, B21C 37/047)}</li> </ul>
23/145	<ul style="list-style-type: none"> <li>• . . . . {Interlocking profiles}</li> </ul>	33/004	<ul style="list-style-type: none"> <li>• {Composite billet}</li> </ul>
23/147	<ul style="list-style-type: none"> <li>• . . . . {Making drill blanks (making twist-drills B23P 15/32)}</li> </ul>	33/006	<ul style="list-style-type: none"> <li>• {Consecutive billets, e.g. billet profiles allowing air expulsion or bonding of billets}</li> </ul>
23/16	<ul style="list-style-type: none"> <li>• . . . Making turbo blades or propellers</li> </ul>	33/008	<ul style="list-style-type: none"> <li>• {Scalping billets, e.g. for removing oxide layers prior or during extrusion}</li> </ul>
23/18	<ul style="list-style-type: none"> <li>• . by impact extrusion</li> </ul>	33/02	<ul style="list-style-type: none"> <li>• the metal being in liquid form</li> </ul>
23/183	<ul style="list-style-type: none"> <li>• . . {by forward extrusion}</li> </ul>	<b>35/00</b>	<b>Removing work or waste from extruding presses; Drawing-off extruded work (in connection with the extruding of bent tubes or rods B21C 23/12); Cleaning dies, ducts, containers, or mandrels</b>
23/186	<ul style="list-style-type: none"> <li>• . . {by backward extrusion}</li> </ul>	35/02	<ul style="list-style-type: none"> <li>• Removing or drawing-off work {(linear motor pulling devices B21C 1/305)}</li> </ul>
23/20	<ul style="list-style-type: none"> <li>• . by backward extrusion</li> </ul>	35/023	<ul style="list-style-type: none"> <li>• . {Work treatment directly following extrusion, e.g. further deformation or surface treatment (B21C 35/03 takes precedence; gas treatment B21C 29/006)}</li> </ul>
23/205	<ul style="list-style-type: none"> <li>• . . {Making products of generally elongated shape}</li> </ul>	35/026	<ul style="list-style-type: none"> <li>• . . {Removing sections from the extruded work, e.g. removing a strip to create an open profile}</li> </ul>
23/21	<ul style="list-style-type: none"> <li>• Presses specially adapted for extruding metal</li> </ul>	35/03	<ul style="list-style-type: none"> <li>• . Straightening the work</li> </ul>
23/211	<ul style="list-style-type: none"> <li>• . {Press driving devices}</li> </ul>	35/04	<ul style="list-style-type: none"> <li>• Cutting-off or removing waste</li> </ul>
23/212	<ul style="list-style-type: none"> <li>• . {Details (B21C 23/217, B21C 23/218 take precedence)}</li> </ul>	35/06	<ul style="list-style-type: none"> <li>• Cleaning dies, ducts, containers or mandrels</li> </ul>
23/214	<ul style="list-style-type: none"> <li>• . . {Devices for changing die or container}</li> </ul>		
23/215	<ul style="list-style-type: none"> <li>• . . {Devices for positioning or centering press components, e.g. die or container}</li> </ul>		
23/217	<ul style="list-style-type: none"> <li>• . {Tube extrusion presses (B21C 23/218 takes precedence)}</li> </ul>		
23/218	<ul style="list-style-type: none"> <li>• . {Indirect extrusion presses}</li> </ul>		
23/22	<ul style="list-style-type: none"> <li>• Making metal-coated products; Making products from two or more metals</li> </ul>		
23/24	<ul style="list-style-type: none"> <li>• . Covering indefinite lengths of metal or non-metal material with a metal coating</li> </ul>		
23/26	<ul style="list-style-type: none"> <li>• . . Applying metal coats to cables, e.g. to insulated electric cables</li> </ul>		
23/28	<ul style="list-style-type: none"> <li>• . . . on intermittently-operating extrusion presses</li> </ul>		
23/30	<ul style="list-style-type: none"> <li>• . . . on continuously-operating extrusion presses</li> </ul>		

<b>37/00</b>	<b>Manufacture of metal sheets, bars, wire, tubes or like semi-manufactured products, not otherwise provided for; Manufacture of tubes of special shape</b>	37/127	. . . {Tube treating or manipulating combined with or specially adapted for use in connection with tube making machines, e.g. drawing-off devices, cutting-off}
37/02	. of sheets	37/128	. . . {Control or regulating devices}
37/04	. of bars or wire {(wire-like electrical connectors in or for semiconductor devices H01L 24/42)}	37/14	. . Making tubes from double flat material
37/042	. . {Manufacture of coated wire or bars}	37/15	. . Making tubes of special shape; Making tube fittings {(B21C 37/0803, B21C 37/104, B21C 37/124, take precedence)}
37/045	. . {Manufacture of wire or bars with particular section or properties}	37/151	. . . {Making tubes with multiple passages}
37/047	. . {of fine wires}	37/152	. . . {Making rifle and gunbarrels}
37/06	. of tubes or metal hoses; Combined procedures for making tubes, e.g. for making multi-wall tubes	37/153	. . . . {Making tubes with inner- and/or outer guides}
37/065	. . {starting from a specific blank, e.g. tailored blank}	37/154	. . . {Making multi-wall tubes}
37/08	. . Making tubes with welded or soldered seams {(with helically arranged seams B21C 37/122)}	37/155	. . . {Making tubes with non circular section (B21C 37/151, B21C 37/154 take precedence)}
37/0803	. . . {the tubes having a special shape, e.g. polygonal tubes}	37/156	. . . {Making tubes with wall irregularities (B21C 37/20, B21C 37/22 take precedence)}
37/0807	. . . {Tube treating or manipulating combined with, or specially adapted for use in connection with tube making machines, e.g. drawing-off devices, cutting-off}	37/157	. . . . {Perforations}
37/0811	. . . . {removing or treating the weld bead}	37/158	. . . . {Protrusions, e.g. dimples}
37/0815	. . . {without continuous longitudinal movement of the sheet during the bending operation}	37/16	. . . Making tubes with varying diameter in longitudinal direction
37/0818	. . . {Manufacture of tubes by drawing of strip material through dies}	37/18	. . . . conical tubes
37/0822	. . . {Guiding or aligning the edges of the bent sheet}	37/185	. . . . {starting from sheet material}
37/0826	. . . {Preparing the edges of the metal sheet with the aim of having some effect on the weld}	37/20	. . . Making helical or similar guides in or on tubes without removing material, e.g. by drawing same over mandrels, by pushing same through dies ; Making tubes with angled walls, ribbed tubes and tubes with decorated walls}
37/083	. . . Supply, or operations combined with supply, of strip material	37/202	. . . . {with guides parallel to the tube axis}
37/087	. . . using rods or strips of soldering material	37/205	. . . . {with annular guides}
37/09	. . . of coated strip material ; Making multi-wall tubes}	37/207	. . . . {with helical guides}
37/10	. . Making tubes with riveted seams {or with non-welded and non-soldered seams}	37/22	. . . Making finned or ribbed tubes by fixing strip or like material to tubes
37/101	. . . {Making of the seams}	37/225	. . . . {longitudinally-ribbed tubes}
37/102	. . . {of coated strip material (making multi-wall tubes)}	37/24	. . . . annularly-ribbed tubes
37/104	. . . {the tubes having a special shape, e.g. polygonal tubes}	37/26	. . . . helically-ribbed tubes
37/105	. . . {Supply, or operations combined with supply, of strip material}	37/28	. . . Making tube fittings for connecting pipes, e.g. U-pieces
37/107	. . . {Tube treating or manipulating combined with or specially adapted for use in connection with tube-making machines, e.g. drawing-off devices, cutting-off}	37/283	. . . . {Making U-pieces (B21C 37/286 takes precedence)}
37/108	. . . {without continuous longitudinal movement of the sheet during the bending operation}	37/286	. . . . {starting from sheet material}
37/12	. . Making tubes or metal hoses with helically arranged seams	37/29	. . . . Making branched pieces, e.g. T-pieces
37/121	. . . {with non-welded and non-soldered seams}	37/292	. . . . . {Forming collars by drawing or pushing a rigid forming tool through an opening in the tube wall}
37/122	. . . {with welded or soldered seams}	37/294	. . . . . {Forming collars by compressing a fluid or a yieldable or resilient mass in the tube}
37/123	. . . {of coated strip material; Making multi-wall tubes}	37/296	. . . . . {Making branched pieces starting from strip material; Making branched tubes by securing a secondary tube in an opening in the undeformed wall of a principal tube}
37/124	. . . {the tubes having a special shape, e.g. with corrugated wall, flexible tubes}	37/298	. . . . . {Forming collars by flow-drilling (flow drilling B21J 5/066)}
37/125	. . . . {curved section, e.g. elbow}	37/30	. . Finishing tubes, e.g. sizing, burnishing
37/126	. . . {Supply, or operations combined with supply, of strip material}	<b>43/00</b>	<b>Devices for cleaning metal products combined with or specially adapted for use with machines or apparatus provided for in this subclass</b>
		43/02	. combined with or specially adapted for use in connection with drawing or winding machines or apparatus
		43/04	. . Devices for de-scaling wire or like flexible work

**Auxiliary operation used in connection with metal working without essentially removing material****45/00 Separating mandrels from work or vice versa****47/00 Winding-up, coiling or winding-off metal wire, metal band or other flexible metal material characterised by features relevant to metal processing only (coiling wire into particular forms [B21F 3/00](#))**

- 47/003 . {Regulation of tension or speed; Braking}
- 47/006 . {winding-up or winding-off several parallel metal bands}
- 47/02 . Winding-up or coiling
- 47/04 . . on or in reels or drums, without using a moving guide
- 47/045 . . . {in rotating drums}
- 47/06 . . . with loaded rollers, bolts, or equivalent means holding the material on the reel or drum
- 47/063 . . . . {with pressure rollers only}
- 47/066 . . . . {with belt wrappers only}
- 47/08 . . without making use of a reel or drum, the first turn being formed by a stationary guide
- 47/10 . . by means of a moving guide
- 47/12 . . . the guide moving parallel to the axis of the coil ([B21C 47/14](#) takes precedence)
- 47/14 . . . by means of a rotating guide, e.g. laying the material around a stationary reel or drum
- 47/143 . . . . {the guide being a tube}
- 47/146 . . . . {Controlling or influencing the laying pattern of the coils}
- 47/16 . Unwinding or uncoiling
- 47/18 . . from reels or drums
- 47/20 . . . the unreeled material moving transversely to the tangent line of the drum, e.g. axially, radially
- 47/22 . . Unwinding coils without reels or drums
- 47/24 . Transferring coils to or from winding apparatus or to or from operative position therein; Preventing uncoiling during transfer
- 47/242 . . {Devices for swinging the coil from horizontal to vertical, or vice versa}
- 47/245 . . {Devices for the replacement of full reels by empty reels or vice versa, without considerable loss of time}
- 47/247 . . {Joining wire or band ends}
- 47/26 . Special arrangements with regard to simultaneous or subsequent treatment of the material
- 47/262 . . {Treatment of a wire, while in the form of overlapping non-concentric rings}
- 47/265 . . {"helicofil" systems}
- 47/267 . . {Scrap treatment}
- 47/28 . Drums or other coil-holders
- 47/30 . . expandable or contractible
- 47/32 . Tongs or gripping means specially adapted for reeling operations
- 47/323 . . {Slits or pincers on the cylindrical wall of a reel or bobbin, adapted to grip the end of the material being wound}
- 47/326 . . {Devices for pressing the end of the material being wound against the cylindrical wall of the reel or bobbin}
- 47/34 . Feeding or guiding devices not specially adapted to a particular type of apparatus

- 47/3408 . . {for monitoring the lateral position of the material}
- 47/3416 . . . {with lateral edge contact}
- 47/3425 . . . {without lateral edge contact}
- 47/3433 . . {for guiding the leading end of the material, e.g. from or to a coiler}
- 47/3441 . . . {Diverting the leading end, e.g. from main flow to a coiling device}
- 47/345 . . {for monitoring the tension or advance of the material}
- 47/3458 . . . {Endlessly revolving chain systems ([metal drawing B21C 1/30](#))}
- 47/3466 . . {by using specific means}
- 47/3475 . . . {Fluid pressure or vacuum}
- 47/3483 . . . {Magnetic field}
- 47/3491 . . . {Brushes}

**49/00 Devices for temporarily accumulating material****51/00 Measuring, gauging, indicating, counting, or marking devices specially adapted for use in the production or manipulation of material in accordance with subclasses [B21B](#) - [B21F](#)**

- 51/005 . {Marking devices}

**99/00 Subject matter not provided for in other groups of this subclass**