

CPC**COOPERATIVE PATENT CLASSIFICATION****B21D**

WORKING OR PROCESSING OF SHEET METAL OR METAL TUBES, RODS OR PROFILES WITHOUT ESSENTIALLY REMOVING MATERIAL; PUNCHING(operations of the kind involved in the manufacture of such products [B21B](#), [B21C](#); working or processing of wire [B21F](#); cutting or severing devices or machines in general [B26](#); presses in general [B30B](#))

NOTE

This subclass covers cutting or perforating of sheet metal or other stock material

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](#)

Guidance heading: Straightening; Restoring form; Bending; Corrugating; Flanging

B21D 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](#))

[B21D 1/02](#)

- . by rollers([B21D 1/06](#) takes precedence)

[B21D 1/05](#)

- . Stretching combined with rolling

[B21D 1/06](#)

- . Removing local distortions

[B21D 1/065](#)

- .. {by hammering}

[B21D 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](#) })

[B21D 1/10](#)

- .. of specific articles made from sheet metal, e.g. mudguards

[B21D 1/12](#)

- . Straightening vehicle body parts or bodies([B21D 1/14](#) takes precedence)

[B21D 1/14](#)

- . Straightening frame structures

[B21D 1/145](#)

- .. {Clamps therefor}

B21D 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](#) })

[B21D 3/005](#)

- . {by eccentric turning members}

[B21D 3/02](#)

- . by rollers

[B21D 3/04](#)

- .. arranged on axes skew to the path of the work

[B21D 3/045](#)

- ... {Workpiece feed channels therefor}

[B21D 3/05](#)

- .. arranged on axes rectangular to the path of the work

[B21D 3/06](#)

- .. arranged inclined to a revolving flier rolling frame

[B21D 3/08](#)

- .. which move in an orbit without rotating round the work

[B21D 3/10](#)

- . between rams and anvils or abutments

B21D 3/12	<ul style="list-style-type: none"> by stretching with or without twisting(by twisting only B21D 11/14)
B21D 3/14	<ul style="list-style-type: none"> Recontouring
B21D 3/16	<ul style="list-style-type: none"> of specific articles made from metal rods, tubes, or profiles, e.g. crankshafts, by specially adapted methods or means
B21D 5/00	Bending sheet metal along straight lines, e.g. to form simple curves (B21D 11/06 to B21D 11/18 take precedence; corrugating sheet metal B21D 13/00 ; as edge treatment B21D 19/00)
B21D 5/002	<ul style="list-style-type: none"> {Positioning devices}
B21D 5/004	<ul style="list-style-type: none"> {with program control}
B21D 5/006	<ul style="list-style-type: none"> {combined with measuring of bends}
B21D 5/008	<ul style="list-style-type: none"> {combined with heating or cooling of the bends}
B21D 5/01	<ul style="list-style-type: none"> between rams and anvils or abutments
B21D 5/015	<ul style="list-style-type: none"> .. {for making tubes}
B21D 5/02	<ul style="list-style-type: none"> on press brakes without making use of clamping means
B21D 5/0209	<ul style="list-style-type: none"> .. {Tools therefor}
B21D 5/0218	<ul style="list-style-type: none"> ... {Length adjustment of the punch}
B21D 5/0227	<ul style="list-style-type: none"> ... {Length adjustment of the die}
B21D 5/0236	<ul style="list-style-type: none"> ... {Tool clamping}
B21D 5/0245	<ul style="list-style-type: none"> {Fluid operated}
B21D 5/0254	<ul style="list-style-type: none"> ... {Tool exchanging}
B21D 5/0263	<ul style="list-style-type: none"> ... {Die with two oscillating halves}
B21D 5/0272	<ul style="list-style-type: none"> .. {Deflection compensating means}
B21D 5/0281	<ul style="list-style-type: none"> .. {Workpiece supporting devices}
B21D 5/029	<ul style="list-style-type: none"> .. {with shearing devices}
B21D 5/04	<ul style="list-style-type: none"> on brakes making use of clamping means on one side of the work
B21D 5/042	<ul style="list-style-type: none"> .. {With a rotational movement of the bending blade}
B21D 5/045	<ul style="list-style-type: none"> .. {With a wiping movement of the bending blade}
B21D 5/047	<ul style="list-style-type: none"> .. {Length adjustment of the clamping means}
B21D 5/06	<ul style="list-style-type: none"> by drawing procedure making use of dies or forming-rollers, e.g. making profiles
B21D 5/08	<ul style="list-style-type: none"> .. making use of forming-rollers(B21D 5/12 takes precedence)
B21D 5/083	<ul style="list-style-type: none"> ... {for obtaining profiles with changing cross-sectional configuration}
B21D 5/086	<ul style="list-style-type: none"> ... {for obtaining closed hollow profiles}
B21D 5/10	<ul style="list-style-type: none"> .. for making tubes
B21D 5/12	<ul style="list-style-type: none"> ... making use of forming-rollers
B21D 5/14	<ul style="list-style-type: none"> by passing between rollers(B21D 5/06 takes precedence)
B21D 5/143	<ul style="list-style-type: none"> .. {making use of a mandrel}
B21D 5/146	<ul style="list-style-type: none"> .. {one roll being covered with deformable material}
B21D 5/16	<ul style="list-style-type: none"> Folding; Pleating
B21D 7/00	Bending rods, profiles, or tubes (B21D 11/02 to B21D 11/18 take precedence; using mandrels or the like B21D 9/00)

- B21D 7/02 . over a stationary forming member; by use of a swinging forming member or abutment
- B21D 7/021 .. {Construction of forming members having more than one groove}
- B21D 7/022 . over a stationary forming member only
- B21D 7/0225 ... {using pulling members}
- B21D 7/024 . by a swinging forming member
- B21D 7/025 ... and pulling or pushing the ends of the work
- B21D 7/028 ... and altering the profile at the same time, e.g. forming bumpers
- B21D 7/03 . Apparatus with means to keep the profile in shape
- B21D 7/04 . over a movably-arranged forming member([B21D 7/02 takes precedence](#))
- B21D 7/06 . in press brakes or between rams and anvils or abutments; Pliers with forming dies
- B21D 7/063 .. {Pliers with forming dies}
- B21D 7/066 .. {combined with oscillating members}
- B21D 7/08 . by passing between rollers or through a curved die
- B21D 7/085 .. {by passing through a curved die}
- B21D 7/10 . by abutting members and flexible bending means, e.g. with chains, ropes
- B21D 7/12 . with programme control
- B21D 7/14 . combined with measuring of bends or lengths
- B21D 7/16 . Auxiliary equipment, e.g. for heating or cooling of bends
- B21D 7/162 .. {Heating equipment}
- B21D 7/165 .. {Cooling equipment}
- B21D 7/167 .. {Greasing}

B21D 9/00

Bending tubes using mandrels or the like([B21D 11/02 to B21D 11/18 take precedence](#))

- B21D 9/01 . the mandrel being flexible and engaging the entire tube length
- B21D 9/03 .. and built-up from loose elements, e.g. series of balls
- B21D 9/04 . the mandrel being rigid
- B21D 9/05 . co-operating with forming members
- B21D 9/055 .. {Construction of forming members having more than one groove}
- B21D 9/07 . with one or more swinging forming members engaging tube ends only
- B21D 9/073 ... {with one swinging forming member}
- B21D 9/076 ... {with more swinging forming members}
- B21D 9/08 . in press brakes or between rams and anvils or abutments; Pliers with forming dies
- B21D 9/085 .. {Pliers with forming dies}
- B21D 9/10 . by passing between rollers
- B21D 9/12 . by pushing over a curved mandrel; by pushing through a curved die
- B21D 9/125 .. {by pushing through a curved die}
- B21D 9/14 . Wrinkle-bending, i.e. bending by corrugating
- B21D 9/15 . using filling material of indefinite shape, e.g. sand, plastic material([filling of tubes with such material B21D 9/16](#))
- B21D 9/16 . Auxiliary equipment, e.g. machines for filling tubes with sand

B21D 9/165	.. {Machines for filling tubes with sand}
B21D 9/18	.. for heating or cooling of bends
B21D 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 to B21D 9/00 (corrugating or bending into wave form B21D 13/00 , B21D 15/00 ; flanging B21D 19/00); Twisting
B21D 11/02	. Bending by stretching or pulling over a die(working sheet metal of limited length by stretching B21D 25/00)
B21D 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)
B21D 11/07	.. Making serpentine-shaped articles by bending essentially in one plane
B21D 11/08	. Bending by altering the thickness of part of the cross-section of the work(B21D 11/06 takes precedence)
B21D 11/085	.. {by locally stretching or upsetting}
B21D 11/10	. Bending specially adapted to produce specific articles, e.g. leaf springs{(making or bending leaf springs B21D 53/886)}
B21D 11/12	.. the articles being reinforcements for concrete
B21D 11/125	... {Bending wire nets}
B21D 11/14	. Twisting
B21D 11/15	.. Reinforcing rods for concrete
B21D 11/16	.. Crankshafts
B21D 11/18	. Jogging
B21D 11/20	. Bending sheet metal, not otherwise provided for
B21D 11/203	.. {Round bending}
B21D 11/206	.. {Curving corrugated sheets}
B21D 11/22	. Auxiliary equipment, e.g. positioning devices
B21D 13/00	Corrugating sheet metal, rods or profiles; Bending sheet metal, rods or profiles into wave form(tubes B21D 15/00)
B21D 13/02	. by pressing
B21D 13/04	. by rolling
B21D 13/045	.. {the corrugations being parallel to the feeding movement}
B21D 13/06	. by drawing
B21D 13/08	. by combined methods
B21D 13/10	. into a peculiar profiling shape
B21D 15/00	Corrugating tubes(wrinkle-bending using mandrels or the like B21D 9/14)
B21D 15/02	. longitudinally
B21D 15/03	.. by applying fluid pressure
B21D 15/04	. transversely, e.g. helically
B21D 15/06	.. annularly{(with thinning B21C 37/205)}
B21D 15/10	.. by applying fluid pressure

B21D 15/105 . . . {by applying elastic material}

B21D 15/12 . Bending tubes into wave form

B21D 17/00 Forming single grooves in sheet metal or tubular or hollow articles

B21D 17/02 . by pressing([grooving or notching of bolts, studs, or the like B21K 1/54](#))

B21D 17/025 . . {by pressing tubes axially}

B21D 17/04 . by rolling

B21D 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](#))

B21D 19/005 . {Edge deburring or smoothing}

B21D 19/02 . by continuously-acting tools moving along the edge([edge-curling B21D 19/12](#))

B21D 19/04 . . shaped as rollers

B21D 19/043 . . . {for flanging edges of plates}

B21D 19/046 . . . {for flanging edges of tubular products}

B21D 19/06 . . . working inwardly

B21D 19/08 . by single or successive action of pressing tools, e.g. vice jaws

B21D 19/082 . . {for making negative angles}

B21D 19/084 . . . {with linear cams, e.g. aerial cams}

B21D 19/086 . . . {with rotary cams}

B21D 19/088 . . {for flanging holes}

B21D 19/10 . . working inwardly

B21D 19/12 . Edge-curling

B21D 19/14 . . Reinforcing edges, e.g. armouring same

B21D 19/16 . Reverse flanging of tube ends

B21D 21/00 Combined processes according to methods covered by groups [B21D 1/00](#) to [B21D 19/00](#)

Guidance heading: Stamping, Spinning, Deep-drawing; Working sheet metal of limited length by stretching; Punching

B21D 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](#))

B21D 22/02 . Stamping using rigid devices or tools

B21D 22/022 . . {by heating the blank or stamping associated with heat treatment([C21D](#) takes precedence)}

B21D 22/025 . . {for tubular articles}

B21D 22/027 . . {for flattening the ends of corrugated sheets}

B21D 22/04 . . for dimpling([combined with perforating B21D 28/24](#))

B21D 22/06 . . having relatively-movable die parts

B21D 22/08 . . with die parts on rotating carriers

B21D 22/10 . Stamping using yieldable or resilient pads

B21D 22/105	.. {of tubular products}
B21D 22/12	.. using enclosed flexible chambers
B21D 22/125	... {of tubular products}
B21D 22/14	. Spinning
B21D 22/16	.. over shaping mandrels or formers
B21D 22/18	.. using tools guided to produce the required profile
B21D 22/185	... {making bombed objects}
B21D 22/20	. Deep-drawing(special deep-drawing arrangements in, or in connection with, presses B21D 24/00)
B21D 22/201	.. {Work-pieces; preparation of the work-pieces, e.g. lubricating, coating}
B21D 22/203	.. {of compound articles}
B21D 22/205	.. {Hydro-mechanical deep-drawing}
B21D 22/206	.. {articles from a strip in several steps, the articles being coherent with the strip during the operation}
B21D 22/208	.. {by heating the blank or deep-drawing associated with heat treatment(C21D takes precedence)}
B21D 22/21	.. without fixing the border of the blank
B21D 22/22	.. with devices for holding the edge of the blanks(B21D 22/24 to B21D 22/30 take precedence; shaping over a die without external former B21D 11/02)
B21D 22/225	... {with members for radially pushing the blanks}
B21D 22/24	.. involving two drawing operations having effects in opposite directions with respect to the blank
B21D 22/26	.. for making peculiarly, e.g. irregularly, shaped articles
B21D 22/28	.. of cylindrical articles using consecutive dies
B21D 22/283	... {with ram and dies aligning means}
B21D 22/286	... {with lubricating or cooling means}
B21D 22/30	.. to finish articles formed by deep-drawing
B21D 24/00	Special deep-drawing arrangements in, or in connection with, presses
B21D 24/005	. {Multi-stage presses}
B21D 24/02	. Die-cushions
B21D 24/04	. Blank holders; Mounting means therefor
B21D 24/06	.. Mechanically spring-loaded blank holders
B21D 24/08	.. Pneumatically or hydraulically loaded blank holders
B21D 24/10	. Devices controlling or operating blank holders independently, or in conjunction with dies
B21D 24/12	.. mechanically
B21D 24/14	.. pneumatically or hydraulically
B21D 24/16	. Additional equipment in association with the tools e.g. for shearing, for trimming
B21D 25/00	Working sheet metal of limited length by stretching, e.g. for straightening
B21D 25/02	. by pulling over a die

- B21D 25/04
 - . Clamping arrangements
- B21D 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](#))
- B21D 26/02
 - . by applying fluid pressure
- B21D 26/021
 - .. Deforming sheet bodies
- B21D 26/023
 - ... including an additional treatment performed by fluid pressure, e.g. perforating
- B21D 26/025
 - ... Means for controlling the clamping or opening of the moulds
- B21D 26/027
 - ... Means for controlling fluid parameters, e.g. pressure or temperature
- B21D 26/029
 - ... Closing or sealing means
- B21D 26/031
 - ... Mould construction([B21D 26/025](#) - [B21D 26/029](#) take precedence)
- B21D 26/033
 - .. Deforming tubular bodies([corrugating tubes by applying fluid pressure B21D 15/03](#) , [B21D 15/10](#))
- B21D 26/035
 - ... including an additional treatment performed by fluid pressure, e.g. perforating
- B21D 26/037
 - ... Forming branched tubes
- B21D 26/039
 - ... Means for controlling the clamping or opening of the moulds
- B21D 26/041
 - ... Means for controlling fluid parameters, e.g. pressure or temperature
- B21D 26/043
 - ... Means for controlling the axial pusher
- B21D 26/045
 - ... Closing or sealing means
- B21D 26/047
 - ... Mould construction([B21D 26/037](#) - [B21D 26/045](#) take precedence)
- B21D 26/049
 - ... Deforming bodies having a closed end
- B21D 26/051
 - ... Deforming double-walled bodies
- B21D 26/053
 - .. characterised by the material of the blanks
- B21D 26/055
 - ... Blanks having super-plastic properties
- B21D 26/057
 - ... Tailored blanks
- B21D 26/059
 - ... Layered blanks
- B21D 26/06
 - .. by shock waves
- B21D 26/08
 - ... generated by explosives, e.g. chemical explosives
- B21D 26/10
 - ... generated by evaporation, e.g. of wire, of liquids
- B21D 26/12
 - ... initiated by spark discharge
- B21D 26/14
 - . applying magnetic forces
- B21D 28/00**

Shaping by press-cutting; Perforating
- B21D 28/002
 - . {Drive of the tools([B21D 28/007](#) and [B21D 28/20](#) take precedence)}
- B21D 28/005
 - .. {Adjustment of the punch stroke for compensating wear}
- B21D 28/007
 - . {Explosive cutting or perforating}
- B21D 28/02
 - . Punching blanks or articles with or without obtaining scrap([cutting nails or pins from strips or sheet material B21G 3/26](#)); Notching
- B21D 28/04
 - .. Centering the work; Positioning the tools
- B21D 28/06
 - .. Making more than one part out of the same blank; Scrapless working
- B21D 28/08
 - ... Zig-zag sequence working

- B21D 28/10 . . Incompletely punching in such a manner that the parts are still coherent with the work
- B21D 28/12 . . Punching using rotatable carriers
- B21D 28/125 . . . {with multi-tools}
- B21D 28/14 . . Dies(ejecting or stripping-off devices arranged in punching machines or tools [B21D 45/00](#))
- B21D 28/145 . . . {with means for slug retention, e.g. a groove}
- B21D 28/16 . . Shoulder or burr prevention{, e.g. fine-blanking}
- B21D 28/18 . . Yieldable, e.g. rubber, punching pads
- B21D 28/20 . . Applications of drives{for reducing noise or wear}
- B21D 28/22 . . Notching the peripheries of circular blanks, e.g. laminations for dynamo-electric machines
- B21D 28/24 . Perforating, i.e. punching holes
- B21D 28/243 . . {in profiles}
- B21D 28/246 . . {Selection of punches}
- B21D 28/26 . . in sheets or flat parts
- B21D 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}
- B21D 28/28 . . in tubes or other hollow bodies
- B21D 28/285 . . . {punching outwards}
- B21D 28/30 . . in annular parts, e.g. rims
- B21D 28/32 . . in other articles of special shape
- B21D 28/325 . . . {using cam or wedge mechanisms, e.g. aerial cams}
- B21D 28/34 . . Perforating tools; Die holders
- B21D 28/343 . . . {Draw punches}
- B21D 28/346 . . . {length adjustable perforating tools}
- B21D 28/36 . . using rotatable work or tool holders
- B21D 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](#))**
- B21D 31/005 . . {Incremental shaping or bending, e.g. stepwise moving a shaping tool along the surface of the workpiece([B21D 22/14](#) takes precedence)}
- B21D 31/02 . . Stabbing or piercing, e.g. for making sieves(dimpling [B21D 22/04](#) ; perforating by punching [B21D 28/24](#))
- B21D 31/04 . . Expanding other than provided for in groups [B21D 1/00](#) to [B21D 28/00](#) , e.g. for making expanded metal ([B21D 47/00](#) takes precedence; enlarging tube ends [B21D 41/02](#))
- B21D 31/043 . . {Making use of slitting discs or punch cutters}
- B21D 31/046 . . {making use of rotating cutters}
- B21D 31/06 . . Deforming sheet metal, tubes or profiles by sequential impacts, e.g. hammering, beating, peen forming([forging hammers](#) [B21J 7/00](#))

B21D 33/00	Special measures in connection with working metal foils, e.g. gold foils(cutting or perforating of metal foil analogous to paper B26)
B21D 35/00	Combined processes according to{or processes combined with} methods covered by groups B21D 1/00 to B21D 31/00 (B21D 21/00 takes precedence)
B21D 35/001	. {Shaping combined with punching, e.g. stamping and perforating}
B21D 35/002	. { Processes combined with methods covered by groups B21D 1/00 to B21D 31/00 }
B21D 35/003	.. {Simultaneous forming, e.g. making more than one part per stroke(B21D 26/06 takes precedence)}
B21D 35/005	.. {characterized by the material of the blank or the workpiece(B21D 26/053 takes precedence)}
B21D 35/006	... {Blanks having varying thickness, e.g. tailored blanks}
B21D 35/007	... {Layered blanks(B21D 22/203 takes precedence; joining superposed plates B21D 39/031 , B21D 39/034 , B21D 39/035)}
B21D 35/008	.. {involving vibration, e.g. ultrasonic}
B21D 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)
B21D 37/01	. Selection of materials
B21D 37/02	. Die constructions enabling assembly of the die parts in different ways(B21D 37/06 takes precedence)
B21D 37/04	. Movable or exchangeable mountings for tools
B21D 37/06	.. Pivotaly-arranged tools, e.g. disengageable(die sets with dies pivoted to one another B21D 37/12)
B21D 37/08	. Dies with different parts for several steps in a process
B21D 37/10	. Die sets; Pillar guides
B21D 37/12	.. Particular guiding equipment,{e.g. pliers}; Special arrangements for interconnection or co-operation of dies
B21D 37/14	. Particular arrangements for handling and holding in place complete dies
B21D 37/142	.. {Spotting presses}
B21D 37/145	.. {Die storage magazines}
B21D 37/147	.. {Tool exchange carts}
B21D 37/16	. Heating or cooling
B21D 37/18	. Lubricating,{e.g. lubricating tool and workpiece simultaneously(lubricating workpieces for deep-drawing B21D 22/201)}
B21D 37/20	. Making tools by operations not covered by a single other subclass
B21D 37/205	.. {Making cutting tools}
B21D 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
B21D 39/02	. of sheet metal by folding, e.g. connecting edges of a sheet to form a cylinder
B21D 39/021	.. {for panels, e.g. vehicle doors}

B21D 39/023	... {using rollers}
B21D 39/025	.. {Hand tools}
B21D 39/026	.. {Reinforcing the connection by locally deforming}
B21D 39/028	.. {Reinforcing the connection otherwise than by deforming, e.g. welding}
B21D 39/03	. of sheet metal otherwise than by folding
B21D 39/031	.. {Joining superposed plates by locally deforming without slitting or piercing}
B21D 39/032	... {by fitting a projecting part integral with one plate in a hole of the other plate}
B21D 39/034	.. {Joining superposed plates by piercing}
B21D 39/035	.. {Joining superposed plates by slitting}
B21D 39/037	.. {Interlocking butt joints}
B21D 39/038	.. {Perpendicular plate connections}
B21D 39/04	. of tubes with tubes; of tubes with rods{(crimped pipe joints as such F16L 13/14)}
B21D 39/042	.. {using explosives(by explosive welding B23K 20/08)}
B21D 39/044	.. {perpendicular}
B21D 39/046	.. {Connecting tubes to tube-like fittings}
B21D 39/048	.. {using presses for radially crimping tubular elements}
B21D 39/06	. of tubes in openings, e.g. rolling-in
B21D 39/063	.. {for assembling ladders}
B21D 39/066	.. {using explosives}
B21D 39/08	. Tube expanders
B21D 39/10	.. with rollers for expanding only
B21D 39/12	.. with rollers for expanding and flanging
B21D 39/14	.. with balls
B21D 39/16	.. with torque limiting devices
B21D 39/18	.. Rollers of special shape
B21D 39/20	.. with mandrels, e.g. expandable
B21D 39/203	... {expandable by fluid or elastic material}
B21D 39/206 {by axially compressing the elastic material}

B21D 41/00 **Application of procedures in order to alter the diameter of tube ends([B21D 39/00](#) takes precedence; { plastic tubes [B29C 57/08](#) })**

B21D 41/02	. Enlarging
B21D 41/021	.. {by means of tube-flaring hand tools}
B21D 41/023	... {comprising rolling elements}
B21D 41/025	.. {by means of impact-type swaging hand tools}
B21D 41/026	.. {by means of mandrels}
B21D 41/028	... {expandable mandrels}
B21D 41/04	. Reducing; Closing
B21D 41/045	.. {Closing}

B21D 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)
B21D 43/003	. {Positioning devices(B21D 28/04 and B21D 28/265 take precedence; stops B21D 43/26 ; centering moving strips B21D 43/023)}
B21D 43/006	. {Feeding elongated articles, such as tubes, bars, or profiles}
B21D 43/02	. Advancing work in relation to the stroke of the die or tool
B21D 43/021	.. {Control or correction devices in association with moving strips}
B21D 43/022	... {Loop-control}
B21D 43/023	... {Centering devices, e.g. edge guiding}
B21D 43/025	.. {Fault detection, e.g. misfeed detection}
B21D 43/026	.. { Combination of two or more feeding devices provided for in B21D 43/04 to B21D 43/18 }
B21D 43/027	.. {Combined feeding and ejecting devices}
B21D 43/028	.. {Tools travelling with material, e.g. flying punching machines}
B21D 43/04	.. by means in mechanical engagement with the work
B21D 43/05	... specially adapted for multi-stage presses{(B21D 43/145 takes precedence)}
B21D 43/052 {Devices having a cross bar}
B21D 43/055 {Devices comprising a pair of longitudinally and laterally movable parallel transfer bars}
B21D 43/057 {Devices for exchanging transfer bars or grippers; Idle stages, e.g. exchangeable}
B21D 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
B21D 43/08	... by rollers{(B21D 43/145 takes precedence)}
B21D 43/09 by one or more pairs of rollers for feeding sheet or strip material
B21D 43/10	... by grippers{(B21D 43/055 , B21D 43/057 , B21D 43/145 take precedence)}
B21D 43/105 {Manipulators, i.e. mechanical arms carrying a gripper element having several degrees of freedom}
B21D 43/11 for feeding sheet or strip material
B21D 43/12	... by chains or belts{(B21D 43/145 takes precedence)}
B21D 43/13	... by linearly moving tables
B21D 43/14	... by turning devices, e.g. turn-tables
B21D 43/145 {Turnover devices, i.e. by turning about a substantially horizontal axis}
B21D 43/16	.. by gravity, e.g. chutes
B21D 43/18	.. by means in pneumatic or magnetic engagement with the work
B21D 43/20	. Storage arrangements; Piling or unpling(in general B65G , { B65H })
B21D 43/22	.. Devices for piling sheets
B21D 43/24	.. Devices for removing sheets from a stack
B21D 43/26	. Stops

- B21D 43/28 . Associations of cutting devices therewith
- B21D 43/282 . . {Discharging crop ends or the like}
- B21D 43/285 . . {Devices for handling elongated articles, e.g. bars, tubes or profiles([B21D 43/282](#) , [B21D 43/287](#) take precedence)}
- B21D 43/287 . . {Devices for handling sheet or strip material([B21D 43/282](#) takes precedence)}

B21D 45/00 Ejecting or stripping-off devices arranged in machines or tools dealt with in this subclass

- B21D 45/003 . {in punching machines or punching tools}
- B21D 45/006 . . {Stripping-off devices}
- B21D 45/02 . Ejecting devices
- B21D 45/04 . . interrelated with motion of tool
- B21D 45/06 . Stripping-off devices
- B21D 45/065 . . {for deep-drawn cans; e.g. using stripping fingers}
- B21D 45/08 . . interrelated with motion of tool
- B21D 45/10 . Combined ejecting and stripping-off devices

Guidance heading: 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

B21D 47/00 Making rigid structural elements or units, e.g. honeycomb structures

- B21D 47/005 . {Making gratings}
- B21D 47/01 . beams or pillars
- B21D 47/02 . . by expanding
- B21D 47/04 . composite sheet metal profiles

B21D 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](#))

- B21D 49/005 . {Hollow objects}

B21D 51/00 Making hollow objects(from thick-walled or non uniform tubes [B21K 21/00](#))

- B21D 51/02 . characterised by the structure of the objects{([B21D 51/26](#) takes precedence)}

NOTE

Making hollow objects characterised both by their structure and by their use is classified only in group [B21D 51/16](#)

- B21D 51/04 . . built-up objects, e.g. objects with rigidly-attached bottom or cover
- B21D 51/06 . . folded objects
- B21D 51/08 . . ball-shaped objects
- B21D 51/10 . . conically or cylindrically shaped objects
- B21D 51/12 . . objects with corrugated walls

B21D 51/14	..	Flattening hollow objects for transport or storage; Re-forming same(making tubes from doubled flat material B21C 37/14)
B21D 51/16	.	characterised by the use of the objects(making heat exchangers B21D 53/02)
B21D 51/18	..	vessels, e.g. tubs, vats, tanks, sinks, or the like
B21D 51/20	...	barrels
B21D 51/22	...	pots, e.g. for cooking
B21D 51/24	..	high-pressure containers, e.g. boilers, bottles
B21D 51/26	..	cans or tins; Closing same in a permanent manner(making outlet arrangements B21D 51/38 ; welding or soldering B23K)
B21D 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) }
B21D 51/2615	...	{Edge treatment of cans or tins}
B21D 51/2623	{Curling}
B21D 51/263	{Flanging}
B21D 51/2638	{Necking}
B21D 51/2646	...	{Of particular non cylindrical shape, e.g. conical, rectangular, polygonal, bulged}
B21D 51/2653	...	{Methods or machines for closing cans by applying caps or bottoms}
B21D 51/2661	{Sealing or closing means therefor}
B21D 51/2669	...	{Transforming the shape of formed can bodies; Forming can bodies from flattened tubular blanks; Flattening can bodies}
B21D 51/2676	...	{Cans or tins having longitudinal or helical seams}
B21D 51/2684	...	{Cans or tins having circumferential side seams}
B21D 51/2692	...	{Manipulating, e.g. feeding and positioning devices; Control systems}
B21D 51/28	...	Folding the longitudinal seam
B21D 51/30	...	Folding the circumferential seam
B21D 51/32	by rolling
B21D 51/34	by pressing
B21D 51/36	..	collapsible or like thin-walled tubes, e.g. for toothpaste
B21D 51/365	...	{ involving fixing closure members to the tubes, e.g. nozzles }
B21D 51/38	..	Making inlet or outlet arrangements of cans, tins, baths, bottles, or other vessels; Making can ends; Making closures
B21D 51/383	...	{ scoring lines, tear strips or pulling tabs }
B21D 51/386	{ on the side-wall of containers }
B21D 51/40	...	Making outlet openings, e.g. bung holes
B21D 51/42	Making or attaching spouts
B21D 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)
B21D 51/443	{ easily removable closures, e.g. by means of tear strips }
B21D 51/446	{Feeding or removal of material}
B21D 51/46	Placing sealings or sealing material{(moulding plastic sealing material into closure members B29C 70/80)}
B21D 51/48	Making crown caps

B21D 51/50 Making screw caps
B21D 51/52	.. boxes, cigarette cases, or the like
B21D 51/54	.. cartridge cases, e.g. for ammunition, for letter carriers in pneumatic-tube plants
B21D 53/00	Making other particular articles (making wire fabrics B21F ; making chains or chain parts B21L)
B21D 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)
B21D 53/022	.. {Making the fins}
B21D 53/025	... {Louvered fins}
B21D 53/027	.. {by helically or spirally winding elongated elements}
B21D 53/04	.. of sheet metal
B21D 53/045	... {by inflating partially united plates}
B21D 53/06	.. of metal tubes
B21D 53/08	.. of both metal tubes and sheet metal(connecting tubes in openings B21D 39/06)
B21D 53/085	... {with fins places on zig-zag tubes or parallel tubes}
B21D 53/10	. parts of bearings; sleeves; valve seats or the like
B21D 53/12	.. cages for bearings
B21D 53/14	. belts, e.g. machine-gun belts
B21D 53/16	. rings, e.g. barrel hoops
B21D 53/18	.. of hollow or C-shaped cross-section, e.g. for curtains, for eyelets
B21D 53/20	.. washers, e.g. for sealing
B21D 53/22	... with means for preventing rotation
B21D 53/24	. nuts or like thread-engaging members
B21D 53/26	. wheels or the like
B21D 53/261	.. {pulleys}
B21D 53/262	.. {with inscriptions or the like, e.g. printing wheels}
B21D 53/264	.. {wheels out of a single piece(B21D 53/261 takes precedence)}
B21D 53/265	.. {parts of wheels(B21D 53/28 , B21D 53/30 take precedence)}
B21D 53/267	.. {blower wheels, i.e. wheels provided with fan elements}
B21D 53/268	.. {wheels having spokes}
B21D 53/28	.. gear wheels
B21D 53/30	.. wheel rims
B21D 53/32	.. wheel covers
B21D 53/34	.. brake drums
B21D 53/36	. clips, clamps, or like fastening or attaching devices, e.g. for electric installation
B21D 53/38	. locksmith`s goods, e.g. handles
B21D 53/40	.. hinges, e.g. door hinge plates
B21D 53/42	.. keys{(making keys by combined operations B23P 15/005)}
B21D 53/44	. fancy goods, e.g. jewellery products
B21D 53/46	. haberdashery, e.g. buckles, combs; pronged fasteners, e.g. staples

B21D 53/48	.. buttons, e.g. press-buttons, snap fasteners
B21D 53/50	.. metal slide-fastener parts
B21D 53/52	... fastener elements; Attaching such elements so far as this procedure is combined with the process for making the elements
B21D 53/54	... slides
B21D 53/56	... stops
B21D 53/58	. end-pieces for laces or ropes
B21D 53/60	. cutlery wares; garden tools or the like
B21D 53/62	.. spoons; table forks
B21D 53/64	.. knives; scissors; cutting blades(B21D 53/72 takes precedence; handle portions B21D 53/70)
B21D 53/642	... {scissors}
B21D 53/645	... {safety razor blades}
B21D 53/647	... {mower blades}
B21D 53/66	.. spades; shovels(handle portions B21D 53/70)
B21D 53/68	.. rakes, garden forks, or the like(handle portions B21D 53/70)
B21D 53/70	.. handle portions(B21D 53/72 takes precedence)
B21D 53/72	.. sickles; scythes
B21D 53/74	. frames for openings, e.g. for windows, doors, handbags
B21D 53/745	.. {Joining mitred profiles comprising punching the profiles on a corner-angle connecting piece}
B21D 53/76	. writing or drawing instruments, e.g. writing pens, erasing pens
B21D 53/78	. propeller blades; turbine blades
B21D 53/80	. dustproof covers; safety covers
B21D 53/82	. perforated music sheets; pattern sheets, e.g. for control purposes, stencils
B21D 53/84	. other parts for engines, e.g. connecting-rods
B21D 53/845	.. {Making camshafts}
B21D 53/86	. other parts for bicycles or motorcycles
B21D 53/88	. other parts for vehicles, e.g. cowlings, mudguards
B21D 53/883	.. {reflectors}
B21D 53/886	.. {leaf springs}
B21D 53/90	.. axle-housings
B21D 53/92	. other parts for aircraft
B21D 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)