The present invention relates to a crossing frog with a moving point for very long railway switches incorporated in long welded rails, said crossing frog also comprising, in particular, a cradle in two elements, and to a process for producing such a crossing frog.

It is known that the increase in speed on railway tracks, which can now be as high as 270 km/h and will soon be 300 km/h, or even higher, has led to the creation of very long switches to allow very high speeds at deviations, of the order of 170 km/h to 220 km/h and even higher.

In these very long switches, the crossings are also very long and, at these speeds, it is known that it is preferable to use crossing frogs with a moving point, which are more comfortable than crossing frogs with a fixed point, in which the counter-rails cause return movements of the vehicle axles, which are difficult to tolerate.

Indeed, crossing frogs with a moving point have been constructed for many years, but current designs are not completely satisfactory.

Crossing frogs with a moving point generally comprise two fundamental elements:

- the cradle in which the moving point is fixed at the heel and in which it moves when manoeuvred;
- the moving point itself.

The cradle is necessarily composed of several elements because their respective length is limited by the current state of production methods. It is therefore necessary, for

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producing the desired construction, to manufacture several elements, then to join them to form the cradle. As it is impossible, for constructional reasons associated, in particular, with a lack of space, to produce this joint by conventional fish-plating which would hold the elements of the cradle at the interior and the exterior, C-shaped members placed at the exterior of the cradle elements are used to form the joint.

Such a joint is described in the publication RAIL INTERNATIONAL, vol. 18 No. 14, January 1983, pages 18, 20-25, Brussels BE; J. OECONOMOS. But such a joint does not have the qualities of fish-plating and, even less, the qualities of a weld and, however much care is taken when producing and joining these C-shaped parts, this joint will necessarily exhibit problems in strength in the long term.

Furthermore, the moving point, produced from machined and joined rails, is secured at its heel in one of the cradle elements in the manner of a bracket embedded in a wall.

Its flexibility therefore enables it to rest against one of the point elements of the cradle in the position at the right or at the left when it is manoeuvred by appropriate devices.

As these switches are incorporated in long welded rails, that is to say are connected to framing rails without expansion device, the fixing of the moving point has to ensure - apart from the role of embedding the bracket - that the compressive or tensile stresses of each long welded rail are transferred from the moving point onto the cradle.

In the conventional manner, such stresses are transferred by fish-plates stuck to the rail and to the frog.

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Now when a moulded embedding cradle element is used, the adhesion of the parts allowing the point to be secured in the cradle can obviously be produced on the moving point side where there is a rail form but cannot be produced on the cradle side as it has the form of a rigid box.

It is therefore necessary, to ensure that the stresses are transferred, to use a mechanical joint which has to be produced with high precision to reduce the clearances and to comply with the constraints for incorporation into long welded rails.

With current constructions, there are two mechanical adjustments which are difficult to make, are liable to deteriorate during service and thus have a detrimental effect on the service life of the product.

The general problem to be solved by the subject of the present invention is therefore to design and produce a crossing frog having a moving point in which the disadvantages associated with these two mechanical assemblies are overcome.

For this purpose, the present invention relates to a crossing frog having a moving point for very long railway switches incorporated in long welded rails, said crossing frog also comprising, in particular, a cradle in two elements, the crossing frog being characterised in that the two elements, of which one is made of moulded steel, and the other of non-moulded parts, are connected between themselves in a non-separable manner by welding or secured fish-plates, the two ends on the point side and the two ends on the heel side being shaped into a rail profile, but only the rail profile of the two ends on the point side effectively serving for rolling, the non-moulded element being made up mainly of parts produced integrally as rails and connected to the two ends on the heel side of the moulded part, but neither the rail profile of the two ends on the heel side nor the rail profile of the parts

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effectively serving as rolling surface, the moving point, for its part, being produced integrally as rails of which all the upper faces effectively serve as rolling surfaces.

The invention will be understood better by means of the following description which relates to a preferred embodiment which is given as a non-limiting example and is explained with reference to the accompanying schematic drawings, in which:

Figure 1 is a plan view of a crossing frog having a moving point, according to the invention, said point being located on the right;

Figure 2 is a front view in section along the line A-A in Figure 1;

Figure 3 is a front view in section along the line B-B in Figure 1;

Figure 4 is a front view in section along the line C-C in Figure 1;

Figure 5 is a plan view of the crossing frog shown in Figure 1, the point being located on the left and in which the two parts belonging to the non-moulded element and produced in rails are in the spread position;

Figure 6 is a front view, on an enlarged scale, of a method of connecting the moulded element to a part produced as a rail profile, belonging to the non-moulded element; and

Figure 7 is a front view in section on an enlarged scale along the line D-D in Figure 6.

According to the invention and as shown in Figures 1 to 5 of the accompanying drawings, the crossing frog with a moving point 1 for very long railway switches incorporated in long

welded rails also comprises, in particular, a cradle 2 in two elements 3 and 4, one 3 made of moulded steel, and the other 4 made of non-moulded parts. The two ends 3A and 3B on the point side and the two ends 3C and 3D on the heel side are shaped as a rail profile, but only the rail profile of the two ends 3A and 3B effectively serving for rolling, the non-moulded element 4 being mainly made up of parts 5 and 5′ produced integrally as rails and connected to the two ends 3C and 3D on the heel side of the moulded element 3, but neither the rail profile of the two ends 3C and 3D, nor the rail profile of the parts 5 and 5′ effectively serving as rolling surface, the moving point 1, for its part, being produced integrally as rails of which all the upper faces effectively serve as rolling surface.

According to the invention, the non-moulded element 4 is made up mainly of parts 5 and 5′ produced integrally as rails and connected by welding or by non-welded assembly at the two ends 3C and 3D on the heel side of the moulded element 3 (see Figures 1 and 5 of the accompanying drawings).

According to a characteristic of the invention, the moulded element 3 advantageously has all its upper faces shaped as a rolling track.

It should be noted that a process is known for assembling, by arc welding, crossing frogs produced from hard manganese-containing austenitic steel and rails produced from carbon steel by connecting them end to end by means of an intermediate part produced from austenitic steel having a low carbon content.

Therefore, according to a preferred characteristic of the invention, the moulded element 3 is of austenitic manganese steel, the moving point 1 and the parts 5 and 5′ being made up of carbon steel rails.

The arc welding of the ends 3A and 3B of the moulded

element 3 to the rolling rails 7 of the intermediate track of the branch can thus be carried out by this known process. An intermediate part produced from austenitic steel will therefore be inserted between the ends 3A and 3B of the moulded element 3 and the rolling rails 7.

According to a further characteristic of the invention and as shown in Figures 1 and 4 of the accompanying drawings, there are two rail profile parts 5 and 5' which are connected by glueing to the rails forming the moving point 1 by means of two cross members 8 and 8' having the profile of a fish-plate.

Consequently, the embedding at the heel of the moving point 1 produced by the cross members 8 and 8' glued, on the one hand, to the rails constituting the moving point 1 and, on the other hand, to the parts 5 and 5' of the non-moulded element 4 avoids the use of a mechanical joint and thus eliminates all the disadvantages associated with the use of such a joint, in particular the longitudinal clearances.

As shown in Figures 2 to 4 of the accompanying drawings, the parts 5 and 5' are attached to one another and the non-moulded element 4 is rigidified by means of plates 6.

The non-moulded element 4, made up of parts 5 and 5' fixed to the ends 3C and 3D of the moulded element 3 and rigidly connected by plates 6 therefore forms, with said moulded element 3, a cradle 2 of which the length is no longer limited by the casting constraints.

According to a further characteristic of the invention, the rails of parts 5 and 5' and of the moving point can advantageously have a height, for example, of 172 mm.

Furthermore, according to a first variation, each part 5

and 5' as well as the moving point 1 can advantageously be formed, for example, by a rail of profile UIC A 74. With regard to the moving point 1, such a switch rail allows significant vertical inertia to be imparted to it.

However, according to a second variation, each part 5 or 5' can advantageously be formed, for example, from a rail of profile UIC 60, and the moving point 1 from a switch rail of profile UIC A 74, also allowing significant vertical inertia to be imparted to it.

The present invention also relates to a process for producing a crossing frog having a moving point 1.

According to the invention and according to a first embodiment, the process for producing a crossing frog having a moving point essentially involves welding, on the point side, the moulded element 3 of the cradle 2 to the rolling rails 7 of the intermediate track of the branch and fixing on the moulded element 3 of the cradle 2 parts 5 and 5' belonging to the non-moulded element 4 of the cradle 2, then spreading said parts 5 and 5' from their starting position toward the exterior and holding them in the spread position, inserting the moving point 1 between these parts 5 and 5', releasing the parts 5 and 5' so that they return to their starting position, then fixing the parts 5 and 5' to the moving point inserted between them, rigidifying the non-moulded element 4 and, finally, welding, if necessary, the moving point 1 to the rolling rails 9 on the heel side.

The production process takes place mainly in the following manner.

The moulded element 3 of the cradle 2 is firstly welded, on the point side, to the rolling rails 7 of the intermediate track of the branch, and the two parts 5 and 5', produced as

rails, are each welded at one 5A, 5'A of its two ends to one of the two ends 3C and 3D, on the heel side, also of rail profile, of the moulded element 3. Each part 5 and 5' is formed by a rail, precisely to allow it to be welded to the two ends 3C and 3D, also of rail profile.

The moulded element 3 with its two parts 5 and 5' and its two welded rolling rails 7 is then placed on an assembly table.

As shown in Figure 5 of the accompanying drawings, the parts 5 and 5' are spread outward from their starting position, the parts 5 and 5' being flexible from the zone where they are welded to the moulded element 3.

The parts 5 and 5' are then held in the spread position (see Figure 5) and the moving point 1 is lowered and inserted in the cradle 2 formed by the elements 3 and 4, between the two parts 5 and 5' in the spread position. The moving point 1 is produced from welded and joined rails and has previously been provided with two embedding cross members 8 and 8' which are preferably fixed there by adhesion. The two parts 5 and 5' are then released so that they can be fixed to the cross members 8 and 8' of the moving point, preferably by glued fish-plating.

Plates 6 are then fixed beneath the non-moulded element 4 so as to connect the parts 5 and 5' and thus to rigidify the non-moulded element 4.

Finally, the crossing frog produced in this way is lowered from the assembly table again.

The two ends 1B and 1C of the moving point 1 remote from the pointed end 1A itself and shaped as a rolling track could subsequently, or possibly prior to assembly in situ, be

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welded to the rolling rails 9.

In situ, such a crossing frog could then be fixed to the sleepers and connected to the rails of the railway.

According to a further characteristic of the invention, the welding, on the one hand, of the two ends 3A and 3B of the moulded element 3 to the rolling rails 7 of the intermediate track of the branch and, on the other hand, of the two ends 5A, 5'A of the two parts 5 and 5' to the two ends 3C and 3D of the moulded element 3 is of the electric arc type.

As mentioned above, on the one hand, the ends 5A and 5'A of the parts 5 and 5' could be arc welded to the ends 3C and 3D of the moulded element 3 and, on the other hand, the ends 3A and 3B of the moulded element 3 to the rolling rails 7 of the intermediate track of the branch, by the known process. An intermediate part produced from austenitic steel would therefore be inserted, on the one hand, between the ends 5A and 5'A of the parts 5 and 5' and the ends 3C and 3D of the moulded element 3 and, on the other hand, between the ends 3A and 3B of the moulded element 3 and the rolling rails 7.

However, it is also known that the connection between two rails by welding has the main advantage of eliminating the presence of a joint, as this joint would impair the strength of the railway due to the impact of the wheels on the rolling surfaces of the rails. Now in the crossing frog forming the subject of the present invention, the two parts 5 and 5' belonging to the non-moulded element 4 of the cradle 2 and produced integrally as rails do not serve as a rolling surface. Under these conditions, the connection between these two parts 5 and 5' and the moulded element 3 of the cradle 2 can also be produced by a non-welded joint, but without having the disadvantage described above.

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Consequently, according to a variation of the process for producing the crossing frog having a moving point 1, the parts 5 and 5' belonging to the non-moulded element 4 of the cradle 2 are connected to the moulded element 3 of the cradle 2 by a non-welded joint.

According to a second embodiment, in the production process according to the invention, the operations involving fixing parts 5 and 5' belonging to the non-moulded element 4 of the cradle 2 to the moulded element 3 of the cradle 2, then spreading said parts 5 and 5' outward from their starting position and holding them in the spread position, inserting the moving point 1 between these parts 5 and 5', releasing the parts 5 and 5' so that they return to their starting position, then fixing the parts 5 and 5' to the moving point inserted between them and rigidifying the non-moulded element 4 are replaced by the following operations:

- fixing of the parts 5 and 5' to the moving point 1 so as to form the non-moulded element 4 of the cradle 2;
- rigidification of said non-moulded element 4;
- inter-connection, by means of a non-welded joint, of the two sub-assemblies thus formed, that is to say the one formed by the moulded element 3 welded to the rolling rails 7 and the one formed by the non-moulded element 4, itself formed by the parts 5 and 5' and the moving point 1.

Consequently, the rolling rails 7 of the intermediate track of the branch are firstly welded, on the point side, to the ends 3A and 3B of the moulded element 3 of the cradle 2. Welding is advantageously electric arc welding.

The moving point 1 is then placed on an assembly table and two embedding cross members 8 and 8' are fixed, preferably by glueing, on the moving point 1 produced from

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machined and joined rails. The parts 5 and 5' are then fixed to the cross members 8 and 8' of the moving point 1, preferably by glued fish-plates (the cross members 8 and 8' are formed by fish-plate profiles joined by welded bars; the fish-plate profiles are adhered, on the moving point side, to said point 1 and, on the non-moulded element 4 side, to the parts 5 and 5', and are then bolted).

Plates 6 are then fixed beneath the non-moulded element 4 so as to inter-connect the parts 5 and 5' and thus to rigidify the non-moulded element 4.

The non-moulded element 4 produced in this way is lowered from the assembly table.

The first sub-assembly, formed by the moulded element 3 welded to the rolling rails 7, is then placed on an assembly table. The second sub-assembly, formed by the non-moulded element 4, itself formed by the parts 5 and 5' and the moving point 1, is brought toward the first sub-assembly at this stage by vertical, then longitudinal transfer or longitudinal then vertical transfer so as to place the moulded element 3 of the cradle 2 end to end with the parts 5 and 5' of the non-moulded element 4 of the cradle 2.

The two rail profile ends 3C and 3D on the heel side of the moulded element 3 are then connected to the two respective ends 5A and 5'A of the two parts 5 produced as rails.

This joint, inter-connecting the two sub-assemblies, will be in the form of a bolted joint, preferably a glued fish-plate. This, as well as everything that follows, could also be valid in the variation of the first embodiment corresponding to the non-welded connection of the parts 5 and 5' to the moulded element 3.

The end 5A or 5'A of the parts 5 or 5' is consequently connected to the respective end 3C or 3D of the moulded element 3 by two fish-plates 10 joined by six bolts 11, three bolts 11 on the moulded element 3 side and three bolts 11 on the part 5 side (see Figure 6 of the accompanying drawings).

These fish-plates 10 (four in total) will be stuck in the fish-plating chambers by means of a glue constituted by a resin and a hardener which each form half of the composition of the glue. This may advantageously be the glue "KLEBER E26-05 METALON" produced by the company HENKEL. The KLEBER resin as well as the KLEBER hardener are thoroughly mixed prior to adhesion.

According to a further characteristic of the invention and as shown in Figure 7 of the accompanying drawings, a glass fibre cloth 12 is inserted between each fish-plate 10 and, on the one hand, the ends 5A, 5'A of the parts 5 and 5' and, on the other hand, the ends 3C and 3D of the moulded element 3.

The fish-plates 10 will preferably be sufficiently long for the adhesion surface, obtained from the KLEBER glue and the glass fibre cloth 12, to allow the tensile and compressive stresses caused by the variations in temperature to be transferred into the long welded rails.

Finally, the crossing frog produced in this way is lowered from the assembly table again.

The two ends 1B and 1C of the moving point 1 remote from the pointed end 1A itself and shaped as a rolling track can be welded subsequently or possibly prior to in situ assembly to the rolling rails 9.

In situ, such a crossing frog could thus be fixed to the sleepers and connected to the rails of the railway.

Obviously the invention is not limited to the embodiments described and illustrated in the accompanying drawings. Modifications are possible, in particular with regard to the constitution of the various elements or by substitution of equivalent methods, but without departing from the scope of protection of the invention defined by the claims.

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Claims

1. A crossing frog with moving point for very long railway switches incorporated in long welded rails also comprising, in particular, a cradle (2) in two elements (3 and 4), characterised in that the first element (3), made of moulded steel, and the second element (4), made of non-moulded parts, are connected between themselves in a non separable manner by welding or secured fish-plates, the two ends (3A and 3B) on the point side and the two ends (3C and 3D) on the heel side of the moulded element being shaped as a rail profile, but only the rail profile of the two ends (3A and 3B) on the point side effectively serving for rolling, the non-moulded element (4) being mainly made up of parts (5 and 5′) produced integrally as rails and connected to the two ends (3C and 3D) on the heel side of the moulded element (3), but neither the rail profile of the two ends (3C and 3D) on the heel side nor the rail profile of the parts (5 and 5′) effectively serving as rolling surface, the moving point (1), for its part, being produced integrally as rails of which all the upper faces effectively serve as rolling surface.

2. A crossing frog with moving point according to claim 1, characterised in that the moulded element (3) advantageously has all its upper faces shaped as a rail profile.

3. A crossing frog with moving point according to any one of claims 1 and 2, characterised in that there are two rail profile parts (5 and 5′) which are connected by glueing to the rails forming the moving point (1) by means of two fish-plate profile cross members (8 and 8′).

4. A crossing frog with moving point according to any one of claims 1 to 3, characterised in that the parts (5 and 5′) are interconnected and the non-moulded element (4) is rigidified by means of plates (6).

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5. A crossing frog with moving point according to any one of claims 1 to 4, characterised in that the moulded element (3) is of austenitic manganese steel, the moving point (1) and the parts (5 and 5′) being formed by carbon steel rails.

6. A crossing frog with moving point according to any one of claims 1 to 5, characterised in that the rails of parts (5 and 5′) and of the moving point (1) advantageously have a height of 172 mm.

7. A crossing frog with moving point according to any one of claims 1 to 6, characterised in that each part (5 and 5′) as well as the moving point (1) are advantageously formed from a rail of profile UIC A 74.

8. A crossing frog with moving point according to any one of claims 1 to 6, characterised in that each part (5 or 5′) is advantageously formed by a rail of profile UIC 60.

9. A crossing frog with moving point according to any of claims 1 to 6 or 8, characterised in that the moving point (1) is advantageously formed by a switch rail of profile UIC A 74, in order to impart significant vertical inertia to it.

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10. A process for producing a crossing frog with moving point (1) according to any one of claims 1 to 9 for very long railway switches incorporated in long welded rails, said crossing frog also comprising, in particular, a cradle (2) in two elements (3 and 4), one moulded and the other not moulded, the process being characterised in that it essentially involves welding, on the point side, the moulded element (3) of the cradle (2) to the rolling rails (7) of the intermediate track of the branch and fixing to the moulded element (3) of the cradle (2) parts (5 and 5') belonging to the non-moulded element (4) of the cradle (2), then spreading said parts (5 and 5') outward from their starting position and holding them in the spread position, inserting the moving point (1) between these parts (5 and 5'), releasing the parts (5 and 5') so that they return to their starting position, then fixing the parts (5 and 5') to the moving point inserted between them, rigidifying the non-moulded element (4) and, finally, welding, if necessary, the moving point (1) to the rolling rails (9) on the heel side.

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11. Production process according to claim 10, characterised in that it involves carrying out the following operations in succession:

- welding, on the point side, the two ends (3A and 3B) of the moulded element (3), shaped as a rail profile, to the rolling rails (7) of the intermediate track of the branch, and welding two parts (5 and 5') produced as rails, each at one (5A, 5'A) of its two ends to one of the two ends (3C and 3D) on the heel side, also as a rail profile, of the moulded element (3) ;
- placing the moulded element (3) with its two parts (5 and 5') and its two welded rolling rails (7) on an assembly table;
- spreading the parts (5 and 5') outward from their starting position, the parts (5 and 5') being flexible from the zone where they are welded to the moulded element (3);
- holding the parts (5 and 5') in the spread position;
- positioning the moving point (1), produced from machined and joined rails and previously provided with two embedding cross members (8 and 8') by insertion between the two parts (5 and 5') in the spread position;
- release of the two parts (5 and 5');
- fixing the parts (5 and 5') to the cross members (8 and 8') of the moving point (1);
- fixing plates (6) beneath the non-moulded element (4) so as to connect the parts (5 and 5') and thus to rigidify the non-moulded element (4);
- lowering of the crossing frog produced in this way from the assembly table;
- welding, if necessary, of the two ends (1B and 1C) of the moving point (1) remote from the pointed end (1A) itself and shaped as a rolling track to the rolling rails (9).

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12. A production process according to any one of claims 10 and 11, characterised in that the welding, on the one hand, of the two ends (3A and 3B) of the moulded element (3) to the rolling rails (7) of the intermediate track of the branch and, on the other hand, of the two ends (5A and 5'A) of the two parts (5 and 5') to the two ends (3C and 3D) of the moulded element (3) is of the electric arc type.

13. A production process according to claim 11, characterised in that the embedding cross members (8 and 8') are previously fixed to the moving point (1) by glueing.

14. A production process according to claim 11, characterised in that the parts (5 and 5') are fixed to the cross members (8 and 8') by glued fish-plating.

15. A production process according to claim 10, characterised in that the parts (5 and 5') belonging to the non-moulded element (4) of the cradle (2) are connected to the moulded element (3) of the cradle (2) by a non-welded joint.

16. A production process according to claim 15, characterised in that the parts (5 and 5') produced from rails are connected by a bolted joint, preferably in the form of a glued fish-plate, each at one (5A, 5'A) of its two ends to one of the two ends (3C and 3D) on the heel side, also as a rail profile, of the moulded element (3).

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17. A production process according to claim 10, modified in that the operations involving fixing parts (5 and 5') belonging to the non-moulded element (4) of the cradle (2)to the moulded element (3) of the cradle (2) then spreading said parts (5 and 5') outward from their starting position and holding them in the spread position, inserting the moving point (1) between these parts (5 and 5'), releasing the parts (5 and 5') so that they return to their starting position, then fixing the parts (5 and 5') to the moving point inserted between them and rigidifying the non-moulded element (4) are replaced by the following operations:

- fixing of the parts (5 and 5') to the moving point (1) so as to form the non-moulded element (4) of the cradle (2);
- rigidification of said non-moulded element (4);
- inter-connection, by means of a non-welded joint, of the two sub-assemblies thus formed, that is to say the one formed by the moulded element (3) welded to the rolling rails (7) and the one formed by the non-moulded element (4), itself formed by the parts (5 and 5') and the moving point (1).

18. A production process according to claim 17, characterised in that the welding of the two ends (3A and 3B) of the moulded element (3) to the rolling rails (7) of the intermediate track of the branch is of the electric arc type.

19. A production process according to claim 17, characterised in that the parts (5 and 5') are fixed to the moving point (1) by means of embedding cross members (8 and 8').

20. A production process according to claim 17, characterised in that the non-moulded element (4) of the cradle (2) is rigidified by means of plates (6).

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21. A production process according to claim 17, characterised in that the non-welded joint inter-connecting the two sub-assemblies is a bolted joint, preferably in the form of a glued fish-plate.

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22. A production process according to any one of claims 17 to 21, characterised in that it involves carrying out the following operations:

- welding, on the point side, the two ends (3A and 3B) of the moulded element (3) shaped as a rail profile to the rolling rails (7) of the intermediate track of the branch;
- placing the moving point (1) on an assembly table;
- fixing two embedding cross members (8 and 8′) on the moving point (1) produced from machined and joined rails;
- fixing the parts (5 and 5′) to the cross members (8 and 8′) of the moving point (1);
- fixing plates (6) beneath the non-moulded element (4) so as to inter-connect the parts (5 and 5′) and thus to rigidify the non-moulded element (4);
- lowering the non-moulded element (4) produced in this way from the assembly table;
- placing the sub-assembly formed by the moulded element (3) welded to the rolling rails (7) on an assembly table;
- vertical then longitudinal transfer, or vice versa, of the sub-assembly formed by the non-moulded element (4) fixed to the parts (5 and 5′) and to the moving point (1) toward the other sub-assembly formed by the moving element (3) welded to the rolling rails (7) so as to place them end to end;
- glued fish-plating of the two ends (3C and 3D) on the heel side as rail profile of the moulded element (3) to the two respective ends (5A and 5′A) of the two parts (5) produced as rails;
- lowering the crossing frog produced in this way from the assembly table;
- welding, if necessary, the two ends (1B and 1C) of the moving point (1) remote from the pointed end (1A) itself and shaped in a rolling track to the rolling rails (9).

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23. A production process according to claim 20, characterised in that the embedding cross members (8 and 8') are previously fixed to the moving point (1) by glueing.

24. A production process according to claim 22, characterised in that the parts (5 and 5') are fixed to the cross members (8 and 8') by glued fish plating.

25. A production process according to any one of claims 15, 16 and 22, characterised in that each end (5A or 5'A) of the parts (5 or 5') is connected to the respective end (3C or 3D) of the moulded element (3) by two fish-plates (10) joined by six bolts (11), three bolts (11) on the moulded element (3) side and three bolts (11) on the part (5) side.

26. A production process according to any one of claims 16 and 22, characterised in that the glue is formed by a resin and a hardener.

27. A production process according to claim 26, characterised in that the resin and the hardener each form half of the composition of the glue.

28. A production process according to any one of claims 25 to 27, characterised in that a glass fibre cloth (12) is inserted between each fish-plate (10) and, on the one hand, the ends (5A, 5'A) of the parts (5 and 5') and, on the other hand, the ends (3C and 3D) of the moulded element (3).

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