

Title (en)
METHOD OF MANUFACTURING THE MAGNETIC CORE OF A SOLENOID-ACTUATED DEVICE

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EP 0133885 B1 19861203 (DE)

Application
EP 84106904 A 19840616

Priority
DE 3323886 A 19830702

Abstract (en)
[origin: EP0133885A1] 1. Process for the production of the magnet body of a lifting magnet, consisting of a housing which receives the magnet coil and which is constructed of a magnetizable material, and of an armature guide tube, which is disposed coaxially in the housing and which is constructed of a magnetizable material, the guide tube having a separating joint constructed of a non-magnetizable material, characterized by the following process steps : a) in one end face of the housing, which is present in the first instance as a block-shaped blank, an axial blind bore is produced, which has a depth corresponding to the position of the separating joint and the internal diameter of which is at least equal to the external diameter of the guide tube ; b) a non-magnetizable ring in the form of the separating joint and, subsequent thereto in an axial direction, a tube piece constructed of a magnetizable material, are inserted into the blind bore, the external diameter of the ring and of the tube piece being substantially equal to the internal diameter of the blind bore, and the internal diameter of the ring and of the tube piece being equal to the internal diameter of the guide tube or preferably smaller than the latter ; c) the ring is soldered at one of its axial end faces to the base of the blind bore and at its other axial end face to the tube piece ; d) the blind bore is extended with the internal diameter of the guide tube to the axial length of the latter, the internal diameters of the tube piece and of the ring being enlarged, if appropriate, on the internal diameter of the guide tube ; e) in the end face of the housing on which the armature guide tube bore is visible, an annular space to receive the magnet coil is produced, which annular space is coaxial with the blind bore and has an internal diameter equal to the external diameter of the guide tube and a depth corresponding to the axial rear end of the magnet coil.

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Cited by
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