

Title (en)

Method for the manufacture of a commutator and apparatus for implementing the method.

Title (de)

Verfahren zur Herstellung eines Kommutators und Vorrichtung zur Durchführung des Verfahrens.

Title (fr)

Méthode de fabrication d'un collecteur et appareil pour exécuter la méthode.

Publication

**EP 0524393 B1 19951115 (DE)**

Application

**EP 92108343 A 19920518**

Priority

DE 4124386 A 19910723

Abstract (en)

[origin: EP0524393A2] During the manufacture of a commutator whose segments which form the brush running surface have, in the region of their one end, in each case one connecting element, which is constructed integrally with said end and projects radially, for the connection of the conductor of a rotor winding, subject to the formation of a new rear surface (13) on the segment (1), which rear surface (13) is offset towards the segment foot, the material which is present between the original rear surface and the new rear surface (13) is displaced in the segment longitudinal direction with respect to that region in which the connecting element (10) is to be formed, and is collected there to form a connecting element (10). The apparatus for carrying out this method has a peg (11) for supporting the one end of the segment ring which is assembled from the segments (1), and a hollow-cylindrical stamp (7, 8) which has an inwardly open annular groove (9) between a first section (7), whose internal diameter is matched to the diameter of the peg (11), and a second section (8), whose internal diameter is matched to that of the cylinder which is defined by the new rear surface. <IMAGE>

IPC 1-7

**H01R 39/32**; **H01R 43/08**

IPC 8 full level

**H01R 39/32** (2006.01); **H01R 43/06** (2006.01); **H01R 43/08** (2006.01)

CPC (source: EP)

**H01R 43/06** (2013.01)

Designated contracting state (EPC)

DE FR GB IT SE

DOCDB simple family (publication)

**DE 4124386 C1 19921022**; DE 59204318 D1 19951221; EP 0524393 A2 19930127; EP 0524393 A3 19930707; EP 0524393 B1 19951115

DOCDB simple family (application)

**DE 4124386 A 19910723**; DE 59204318 T 19920518; EP 92108343 A 19920518