

Title (en)

Process for producing rocker arms

Title (de)

Verfahren zum Herstellen von Kipphebeln

Title (fr)

Procédé pour la fabrication de leviers oscillants

Publication

**EP 0718410 B1 20010328 (EN)**

Application

**EP 94309203 A 19941209**

Priority

- EP 94309203 A 19941209
- JP 24959593 A 19931005

Abstract (en)

[origin: EP0718410A1] In producing a rocker arm (25, 26), the following steps are used: fabricating a rocker arm blank (79) which includes: a rocker arm body (77) having an aperture (36a) therein adapted to be converted to a hole (36) for the insertion of a shaft (24), and which blank (79) is made of a nitrided steel comprising specified amounts of C, Mn, Cr, Al, Si, P, S, Cu, Ni, one of Pb and Bi, and optionally Mo, and, as the balance, substantially Fe; and a slipper surface forming piece (41); subjecting the rocker arm blank (79) to a refining treatment to adjust its hardness; subjecting the apertures (36a) to reaming to form the shaft insertion holes (36); and subjecting the rocker arm blank (79) with the shaft insertion holes (36) formed therein to a nitriding treatment. Thus, it is possible to mass-produce rocker arms (25, 26) for an internal combustion engine, each of which has excellent mechanical properties. <IMAGE>

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