

Title (en)
METHOD OF MANUFACTURING A MAGNETIC CIRCUIT FOR A VALVE

Title (de)
VERFAHREN ZUR HERSTELLUNG EINES MAGNETKREISES FÜR EIN VENTIL

Title (fr)
PROCEDE DE PRODUCTION D'UN CIRCUIT MAGNETIQUE POUR SOUPAPE

Publication
EP 0733162 B1 19981014 (DE)

Application
EP 95916562 A 19950413

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Abstract (en)
[origin: US5687468A] PCT No. PCT/DE95/00522 Sec. 371 Date Sep. 11, 1996 Sec. 102(e) Date Sep. 11, 1996 PCT Filed Apr. 13, 1995 PCT Pub. No. WO96/08647 PCT Pub. Date Mar. 21, 1996The process for manufacturing a magnetic circuit for a valve represents a particularly cost-effective version with minimized material use. For this purpose, a single-part valve housing has a groove, where a non-magnetic intermediate ring is placed. An axial pressing force is applied on the intermediate ring using a pressing tool, radially displacing the material of the intermediate ring and the valve housing. With a simple machining operation, valve house material is removed from an opening, so that the internal field and the valve jacket are spatially separated from the components obtained from the valve housing by the intermediate ring. The magnetic circuit thus manufactured is particularly well suited for fuel injection valves for fuel injection systems of internal combustion working with an externally ignited compressed mixture.

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