

Title (en)
Vehicle steering rack and method of manufacturing the rack

Title (de)
Zahnstange und Verfahren zu seiner Herstellung

Title (fr)
Crémaillère et procédé pour sa fabrication

Publication
EP 0897767 A1 19990224 (EN)

Application
EP 98115420 A 19980817

Priority
US 91858197 A 19970819

Abstract (en)
A steering rack (10) is manufactured in a method including an extruding step, a swaging step and a broaching step. The extruding step forms a continuous body of extruded material in the configuration of an elongated cylindrical tube (12) with a first uniform thickness (T1). The swaging step forms a flattened portion (40) of the tube (12) with a second uniform thickness (T2) substantially equal to the first uniform thickness (T1). The flattened portion (40) of the tube (12) has a flattened outer surface (52). The broaching step forms the rack teeth (60) in a row extending along the flattened portion (40) of the tube (12) by cutting away material at locations that are spaced apart along the flattened outer surface (52). <IMAGE>

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B21K 1/767 (2013.01); **B21K 1/768** (2013.01)

Citation (search report)

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- [A] PATENT ABSTRACTS OF JAPAN vol. 007, no. 230 (M - 249) 12 October 1983 (1983-10-12)

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