

Title (en)  
Method of manufacturing of spark plugs

Title (de)  
Verfahren zur Herstellung von Zündkerzen

Title (fr)  
Méthode de fabrication de bougies d'allumage

Publication  
**EP 1303014 B1 20041201 (DE)**

Application  
**EP 02019198 A 20020902**

Priority  
DE 10149630 A 20011009

Abstract (en)  
[origin: EP1303014A1] The tip (9) of a center electrode (1) is formed like a pyramid with a base diameter (d1). A ball (2) of noble metal with a specific diameter (d) is lodged on its face in a welding electrode (3), which is pressed onto the ball by liquefying the tip of the center electrode and by applying a defined welding force acting against it and defined welding parameters for liquefying the tip of the center electrode, the liquefied material of which flows partly round the ball. <??>After the liquefied material of the tip of the center electrode has solidified, the welding electrode is separated from the center electrode with the ball of noble metal that has been embedded. An Independent claim is also included for a spark plug produced by the method of the present invention.

IPC 1-7  
**H01T 21/02**

IPC 8 full level  
**F23Q 7/00** (2006.01); **H01T 21/02** (2006.01)

CPC (source: EP US)  
**H01T 21/02** (2013.01 - EP US)

Cited by  
CN113063162A

Designated contracting state (EPC)  
AT BE BG CH CY CZ DE DK EE ES FI FR GB GR IE IT LI LU MC NL PT SE SK TR

DOCDB simple family (publication)  
**EP 1303014 A1 20030416; EP 1303014 B1 20041201**; AT E284085 T1 20041215; DE 10149630 C1 20031009; DE 50201666 D1 20050105; ES 2229037 T3 20050416; JP 2003120931 A 20030423; US 2003085202 A1 20030508; US 6791246 B2 20040914

DOCDB simple family (application)  
**EP 02019198 A 20020902**; AT 02019198 T 20020902; DE 10149630 A 20011009; DE 50201666 T 20020902; ES 02019198 T 20020902; JP 2002294403 A 20021008; US 26704102 A 20021009