

Title (en)

Method for producing a component with a hardened surface

Title (de)

Verfahren zum Herstellen eines Bauteils mit gehärteter Oberfläche

Title (fr)

Procédé de fabrication d'un composant doté d'une surface durcie

Publication

EP 2065107 B1 20110907 (DE)

Application

EP 08017161 A 20080930

Priority

- DE 102007055345 A 20071119
- DE 102007059229 A 20071207

Abstract (en)

[origin: EP2065107A1] The method for the production of functional elements such as clock housing and housing cover, housing base, a latchkey or a crown, with hardened surface for wrist watch, comprises producing a blank of the functional elements as sintered body by sintering under use of stainless steel as sintered material and carrying out a carbon diffusion for arriving carbon atom to form a diffusion zone or diffusion layer on the surface of the blank, in the presence of carbonates in a salt bath at below 300[deg] C. The blank is treated for the carbon diffusion in a protective gas atmosphere. The method for the production of functional elements such as clock housing, and housing cover, housing base, a latchkey or a crown, with hardened surface for wrist watch, comprises producing a blank of the functional elements as sintered body by sintering under use of stainless steel as sintered material and carrying out a carbon diffusion for arriving carbon atom to form a diffusion zone or diffusion layer on the surface of the blank, in the presence of carbonates in a salt bath at below 300[deg] C. The blank is treated for the carbon diffusion in a protective gas atmosphere at a temperature over room temperature and is impregnated after the carbon diffusion, with a hardening plastic material closing the pores of the blank. The blank is manufactured with a density of 6.8-7.25 kg/dm³ and with a pore size of 0.1-0.5 µm. The carbon diffusion is carried out over a period of 5-6 days in a carbon containing protective gas atmosphere. The surface of the blank is chemically and/or mechanically processed for exposing the pores before the carbon diffusion. A hard material or hard metal coating is subjected on the functional elements for increasing the wear resistance.

IPC 8 full level

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Cited by

CN108546902A; EP3009896A1; EP2757423A1; CN103941572A; US10214831B2; US9182742B2; US9389587B2; EP2757423B1

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