

Title (en)

Method for manufacturing an open/close element for balanced servo valves of a fuel injector.

Title (de)

Verfahren zur Herstellung eines Öffnen/Schliessen-Elements für ausgeglichene Servoventile von Kraftstoffeinspritzdüsen

Title (fr)

Procédé pour la fabrication d'un élément d'ouverture/fermeture pour servovalves équilibrées d'un injecteur de carburant

Publication

**EP 2218902 B1 20110413 (EN)**

Application

**EP 09425058 A 20090216**

Priority

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Abstract (en)

[origin: EP2218902A1] The manufacturing method regards an open/close element for balanced servo valves (5) of a fuel injector, wherein the open/close element (47) is fixed with respect to a bushing (41) designed to move for a certain travel for opening/closing the servo valve (5). The anchor (17) is axially movable for a travel greater than the travel of the open/close element (47) under the control of an electric actuator (15). The method comprises a step in which the bushing (41) is provided with a guide portion (61) designed to engage a hole (59) of the anchor (17) for a relative displacement with respect to the bushing (41), and a step in which an intermediate body (12a) is provided for supporting a spring (23) acting on the bushing (41); the intermediate body comprises a flange (24) and a connection pin (63). Then the anchor (17) is fitted on the guide portion (61), and the intermediate body (12a) is inserted into a seat (40a) in the bushing (41), with the flange (24) in contact with an end edge (66) thereof, and finally the intermediate body (12a) is welded to the guide portion (61) of the bushing (41) along a circumference (69) of continuous contact so that a continuous weld is obtained without any need for phasing with the welding device (70).

IPC 8 full level

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CPC (source: EP)

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Cited by

EP2846033A1; FR3010148A1; WO2015165625A1; WO2013076034A1

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