

Title (en)

Method for manufacturing a fuel injector servo valve

Title (de)

Verfahren zur Herstellung eines Kraftstoffeinspritzservoventils

Title (fr)

Procédé de fabrication d'une servovalve d'injecteur de carburant

Publication

EP 2218903 B1 20110427 (EN)

Application

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Priority

EP 09425061 A 20090216

Abstract (en)

[origin: EP2218903A1] The manufacturing method regards a servo valve (5) of a fuel injector, wherein a bushing (41) is designed to slide on a fixed stem for opening/closing the servo valve (5) and carries an armature (17), which is free to slide axially on the bushing (41); according to the method, the bushing (41) is provided in such a way that it has a guide portion (61) and an adjacent terminal portion (71); after the armature (17) has been mounted on the guide portion (61), a ring (73) is fitted on the terminal portion (71) so that it is brought in contact upon the armature; the ring (73) is then welded to the terminal portion (71) with weld material along a circumference so that a sight welding is carried out without any need for angular positioning between the bushing (41) and the welding device.

IPC 8 full level

F02M 61/16 (2006.01); **F02M 63/00** (2006.01)

CPC (source: EP)

F02M 47/027 (2013.01); **F02M 61/168** (2013.01); **F02M 63/0015** (2013.01); **F02M 63/0021** (2013.01); **F02M 63/007** (2013.01); **F02M 63/0075** (2013.01); **F02M 63/008** (2013.01); **F02M 2200/8084** (2013.01); **F02M 2200/8092** (2013.01)

Cited by

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