

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 2218904 B1 20110907 (EN)

Application

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Priority

EP 09425062 A 20090216

Abstract (en)

[origin: EP2218904A1] The manufacturing method regards a fuel injector servo valve (5), 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 is made in such a way that it has: a guide portion (61); a shoulder (62), fixed on one side of the guide portion (61) for axial resting of the armature; a flange (24) with an external diameter smaller than the internal diameter of the armature (17), for resting of a spring; an intermediate portion (71) between the flange (24) and the guide portion (61), and with an external diameter smaller than that of the flange (24); and a centring pin (12) for the spring (23). After fitting the armature (17) on the guide portion (61), causing it to pass around the flange (24), a fork (73) is slid in between the armature (17) and the flange (24) for stopping the armature (17) axially; the thickness of the fork (73) is chosen so as to leave a predefined freedom of axial movement for the armature (17) on the guide portion (61).

IPC 8 full level

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CPC (source: EP)

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Cited by

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