

Title (en)  
RACK BAR MANUFACTURING METHOD

Title (de)  
ZAHNSTANGENHERSTELLUNGSVERFAHREN

Title (fr)  
PROCÉDÉ DE FABRICATION D'UNE BARRE DE CRÉMAILLÈRE

Publication  
**EP 3694659 B1 20230712 (EN)**

Application  
**EP 18796138 A 20181010**

Priority  
• JP 2017196921 A 20171010  
• JP 2018037807 W 20181010

Abstract (en)  
[origin: WO2019074022A1] A rack bar (14) is manufactured by sequentially inserting a plurality of mandrels into a hollow shaft member with a teeth forming die being pressed against an external surface of a teeth base portion of the shaft member, such that the size of the mandrel in the height direction is increased in a stepwise manner and such that the size of the pressing portion of the mandrel in the width direction is reduced in a stepwise manner. The manufactured rack bar (14) has a first worked surface (15) and a second worked surface (16), both formed on an internal surface of the teeth base portion in a recessed manner and extending in the axial direction. The second worked surface is formed at a central portion of the first worked surface with respect to a tooth-width direction.

IPC 8 full level  
**B21K 1/76** (2006.01)

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