

Title (en)

METHOD FOR PRODUCING A BEARING DEVICE FOR A FIXED BEARING OF A STEERING GEAR OF A MOTOR VEHICLE

Title (de)

VERFAHREN ZUR HERSTELLUNG EINER LAGERVORRICHTUNG FÜR EIN FESTLAGER EINES LENKGETRIEBES EINES KRAFTFAHRZEUGS

Title (fr)

PROCÉDÉ DE FABRICATION D'UN DISPOSITIF DE ROULEMENT POUR UN PALIER FIXE D'UN MÉCANISME DE DIRECTION D'UN VÉHICULE AUTOMOBILE

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Abstract (en)

[origin: WO2019096470A1] The invention relates to a method for producing bearing device (9) for a fixed bearing of a steering gear of a motor vehicle, wherein the bearing device (9) comprises a rotary bearing (11), which comprises an inner race (13), which is intended to receive a pinion shaft of the steering gear, and an outer race (14), which is received in a bearing sleeve (15), and a pivot ring (16), which has an outer ring (18) and an inner ring (17) which are pivotably connected to one another via one or more torsion bars, the inner ring (17) being arranged within the bearing sleeve (15) and the outer ring (18) intended to support the bearing device (9) in a housing of the steering gear being arranged outside the bearing sleeve (15). In accordance with the invention at least the outer race (14) of the rotary bearing (11) and the inner ring (17) of the pivot ring (16) are positioned within the bearing sleeve (15) between two axial stops (20) of the bearing sleeve (15), and the bearing sleeve (15) is then melted in a portion (28) of its longitudinal extent and is solidified again. A reduction in the length of the bearing sleeve (15) is achieved through the twofold change in the physical state from solid to liquid and then from liquid to solid as a result of melting and re-solidification, by means of which reduction the components already arranged between the stops (20) are contacted or braced against one another, whereby any play in the arrangement of these components within the bearing sleeve (15) can be eliminated, which prevents an undesirable development of noise during operation of a steering gear comprising a bearing device (9) of this kind.

IPC 8 full level

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