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EUROPEAN PATENT APPLICATION

21 Application number: 89309783.2

51 Int. Cl.⁵: H01R 43/06, H01R 39/04

22 Date of filing: 26.09.89

30 Priority: 26.09.88 GB 8822555

43 Date of publication of application:
04.04.90 Bulletin 90/14

84 Designated Contracting States:
DE ES FR GB IT

88 Date of deferred publication of the search report:
14.11.90 Bulletin 90/46

71 Applicant: JOHNSON ELECTRIC S.A.
125 Rue du Progrès
La Chaux-de-Fonds(CH)

72 Inventor: Strobl, Georg
26 Belleview Drive, 19/F Repulse Bay Garden
Repulse Bay Hong Kong(HK)

74 Representative: Luckhurst, Anthony Henry
William et al
MARKS & CLERK 57-60 Lincoln's Inn Fields
London WC2A 3LS(GB)

54 Assembled commutator.

57 An assembled commutator comprises a cylindrical base 1 and a plurality of segments 3 glued on the base. To secure the segments on the base a loop 11, formed by stamping out a tang 10, is urged over a boss 12 on the end of the base. A tongue 6 is

inserted in a recess 7 at the other end of the base, as is known in the art. The loop 11 pulls the segment down onto the base and also prevents circumferential movement.

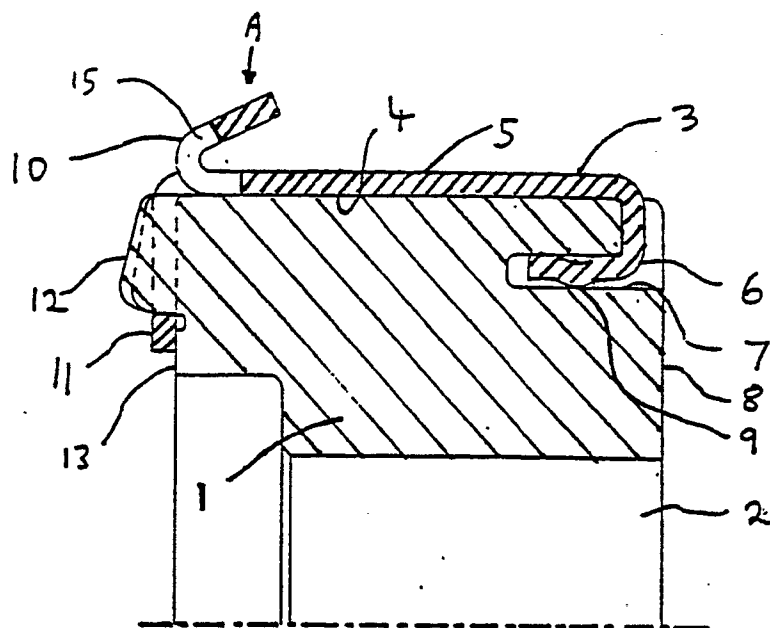


FIG 2



DOCUMENTS CONSIDERED TO BE RELEVANT					
Category	Citation of document with indication, where appropriate, of relevant passages	Relevant to claim	CLASSIFICATION OF THE APPLICATION (Int. Cl.5)		
Y	US-A-2256321 (R.G. MC CUSKER) * page 1, left-hand column, line 39 - right-hand column, line 42; figures 5, 11 * ---	1	H01R43/06 H01R39/04		
Y	US-A-1410914 (I. FOREST, H. HARTZELL) * page 1, left-hand column, line 52 - page 2, left-hand column, line 26; figure 3 * ---	1			
A	FR-A-1436805 (JAMMET) ---				
A	DE-A-2510597 (GEO. L. SCOTT & CO. LTD.) -----				
			TECHNICAL FIELDS SEARCHED (Int. Cl.5)		
			H01R H02K		
The present search report has been drawn up for all claims					
Place of search THE HAGUE		Date of completion of the search 17 SEPTEMBER 1990	Examiner CRIQUI J.J.		
<table><tr><td>CATEGORY OF CITED DOCUMENTS X : particularly relevant if taken alone Y : particularly relevant if combined with another document of the same category A : technological background O : non-written disclosure P : intermediate document</td><td>T : theory or principle underlying the invention E : earlier patent document, but published on, or after the filing date D : document cited in the application L : document cited for other reasons & : member of the same patent family, corresponding document</td></tr></table>				CATEGORY OF CITED DOCUMENTS X : particularly relevant if taken alone Y : particularly relevant if combined with another document of the same category A : technological background O : non-written disclosure P : intermediate document	T : theory or principle underlying the invention E : earlier patent document, but published on, or after the filing date D : document cited in the application L : document cited for other reasons & : member of the same patent family, corresponding document
CATEGORY OF CITED DOCUMENTS X : particularly relevant if taken alone Y : particularly relevant if combined with another document of the same category A : technological background O : non-written disclosure P : intermediate document	T : theory or principle underlying the invention E : earlier patent document, but published on, or after the filing date D : document cited in the application L : document cited for other reasons & : member of the same patent family, corresponding document				