

Description

METHOD FOR THE PRODUCTION OF MAGNET CORES, MAGNET CORE AND INDUCTIVE COMPONENT WITH A MAGNET CORE

The invention relates to a method for the production of magnetic powder composite cores pressed from a mix of alloy powder and binder. It further relates to a magnet core produced from a mix of alloy powder and binder and to an inductive component with a magnet core of this type.

Magnet cores, which are for example used in switched power supplies as storage chokes or as choke cores on the system input side, have to have a low permeability which must not be changed significantly either by a varying AC modulation or by a constant magnetic field superimposed on the AC modulation. For such applications, ferrite cores with an air gap have proved useful for the currently preferred operating frequencies in the range of some ten to a hundred kHz, while magnetic powder composite cores are used for higher-rated equipment.

Depending on operating frequency, the required storage energy and available space, various alloys can be considered for the production of these metal powder composite cores. In the simplest case, pure iron powders are used, but if superior magnetic properties are required, FeAlSi-based crystalline alloys (SENDUST) or even NiFe-based alloys are preferred. The most recent developments favour the use of rapidly solidified amorphous or nanocrystalline iron-based alloys. Amorphous FeSiB-based alloys, in particular, appear to offer advantages compared to classical crystalline alloys owing to their high saturation inductance, their low particle thickness due to manufacturing methods and their high resistivity. Apart from the alloy itself, other factors such as a high packing density of the powder composite core are also highly relevant if the magnet core is to have a high storage energy or a high DC pre-loadability.

US 7,172,660 B2 discloses powder composite cores produced from a rapidly solidified amorphous iron-based alloy, wherein a particularly high packing density of

the magnet core is obtained by using a powder with a bimodal particle size distribution. The use of rapidly solidified amorphous alloys rather than crystalline alloys poses the problem that pressing at moderate temperatures does not result in a viscous flow of the powder particles, so that higher packing densities are difficult to obtain.

According to US 5,509,975 A, high packing densities can also be obtained by pressing the powder to form a magnet core at temperatures slightly below the crystallisation temperature of the alloy used. However, the magnet cores produced in this way have a relatively high relative permeability and are therefore not suitable for applications where a maximum storage energy is required.

In addition, the relative permeability of these magnet cores changes significantly, in particular in the range of low modulations with constant magnetic fields. This is due to the marked platelet shape of the powder particles produced by the comminution of rapidly solidified strip. As a result, the powder particles are in the pressing process oriented with their face normal in the pressing direction, and the starting permeability becomes extremely high, particular at a high packing density, followed by a marked reduction in relative permeability as constant magnetic field modulation increases. This effect is described analytically in F. Mazaleyrat et al.: "Permeability of soft magnetic composites from flakes of nanocrystalline ribbon", IEEE Transactions on Magnetics Vol. 38, 2002. This behaviour is undesirable in magnet cores used as storage chokes or as chokes for power factor correction (PFC chokes) in pulsed power supplies.

The present invention is therefore based on the problem of specifying a magnet core made from a powder of a rapidly solidified, amorphous iron-based alloy, which has both a high packing density and a highly linear permeability curve above a pre-magnetised constant field.

According to the invention, this problem is solved by the subject matter of the independent patent claims. Advantageous further developments of the invention form the subject matter of the dependent patent claims.

A magnet core according to the invention comprises a composite of platelet-shaped powder particles with the thickness D and a binder, wherein the particles have an amorphous volume matrix. In this amorphous volume matrix are, on the surface of the particles, embedded areas with a crystalline structure which have a thickness d of $0.04 * D \leq d \leq 0.25 * D$, preferably $0.08 * D \leq d \leq 0.2 * D$, and cover a proportion x of $x \geq 0.1$ of the surface of the particles. The symbol “*” denotes multiplication.

As a result, the generally amorphous particles have on their surface crystallised-on regions which do not necessarily form a continuous layer. As, according to the invention, this crystallisation can be obtained by a heat treatment of the magnet core after pressing, the crystals grow from the surface of the particles into the amorphous volume matrix.

According to a basic idea of the invention, the storage energy of a magnet core can be increased further by providing that the surfaces of the individual particles are partially crystallised by means of a special heat treatment. The surface crystallisation involves a volume shrinkage in the region of the surface which induces tensile stresses in the surface layer while inducing compressive stresses in the amorphous volume matrix of the particles. In combination with the high positive magnetostriction of FeSiB-based alloys, the compressive stresses in the volume matrix result in a magnetic preferred direction towards the face normal of the platelet-shaped particles. As a result of the fact that, while the powder is pressed, the powder platelets align themselves under compacting pressure such that the platelet plane lies at right angles to the pressing direction and therefore parallel to the subsequent magnetisation direction of the magnet core, the anisotropy caused by the stress-induced magnetic preferred direction leads to a magnetic preferred direction of the magnet core at right angles to its magnetisation direction. The result is a linearisation of the modulation-dependent permeability curve of the magnet core which exceeds the influence of the geometrical shear of the magnetic circuit via the air gaps between the individual particles.

From G. Herzer et al.: “Surface crystallisation in metallic glasses”, Journal of Magnetism and Magnetic Materials 62 (1986), 143-151, it is known that in soft magnetic strip a crystallising-on of the strip surfaces leads to a magnetic anisotropy of

the material. However, it has surprisingly been found that this effect can also be used in the production of powder composite cores. While it has up to now been thought that the influence of geometrical shear via the air gap predominates in powder composite cores, it was established that the surface crystallisation of the platelet-shaped particles in the magnet cores according to the invention results against all expectations in a further linearisation of the modulation-dependent permeability curve and thus to an improved suitability of the magnet cores for use as choke cores.

The term “platelet-shaped” in the present context describes particles which, for example as a result of being produced from strip or pieces of strip, essentially have two parallel main surfaces lying opposite each other and the thickness of which is significantly less than their dimension in the plane of the main surfaces. The platelet-shaped particles advantageously have an aspect ratio of at least 2. In one embodiment, the thickness D of the particles is $10\text{ }\mu\text{m} \leq D \leq 50\text{ }\mu\text{m}$, preferably $20\text{ }\mu\text{m} \leq D \leq 25\text{ }\mu\text{m}$. In contrast, the average particle diameter L in the plane of the main surfaces is preferably approximately $90\text{ }\mu\text{m}$.

In an advantageous embodiment, the alloy composition of the particles is $M_\alpha Y_\beta Z_\gamma$, wherein M is at least one element from the group including Fe, Ni and Co, wherein Y is at least one element from the group including B, C and P, wherein Z is at least one element from the group including Si, Al and Ge, and wherein α , β and γ are specified in atomic percent and meet the following conditions: $60 \leq \alpha \leq 85$; $5 \leq \beta \leq 20$; $0 \leq \gamma \leq 20$, wherein up to 10 atomic percent of the M component may be replaced by at least one element from the group including Ti, V, Cr, Mn, Cu, Zr, Nb, Mo, Ta and W and up to 10 atomic percent of the $(Y+Z)$ component may be replaced by at least one element from the group including In, Sn, Sb and Pb.

The platelet-shaped particles are advantageously provided with an electrically insulating coating on their surfaces to reduce eddy currents.

As a binder for the powder composite core, at least one material from the group including polyimides, phenolic resins, silicone resins and aqueous solutions of alkali or alkaline earth silicates is used.

At a DC superposition permeability $\Delta\mu$ of 80% of the starting superposition permeability of $\Delta\mu_0$, a DC preloadability B_0 of $B_0 \geq 0,24$ T can be obtained with the magnet core according to the invention. The magnet core according to the invention therefore has excellent storage properties. As a result, it can be used to advantage in an inductive component. Owing to its magnetic properties, it is particularly suitable for use as a choke for power factor correction, as a storage choke, as a filter choke or as a smoothing choke.

A method according to the invention for the production of a magnet core comprises at least the following steps: A powder of amorphous, platelet-shaped particles with the thickness D is prepared and pressed with a binder to produce a magnet core. The magnet core is then heat treated for a duration $t_{\text{anneal}} \geq 5$ h at a temperature T_{anneal} of $390^\circ\text{C} \leq T_{\text{anneal}} \leq 440^\circ\text{C}$ while areas with a crystalline structure embedded in the amorphous volume matrix are formed on the surface of the particles.

In an advantageous embodiment, heat treatment is continued until the areas with the crystalline structure have reached a thickness d of $0.04 * D \leq d \leq 0.25 * D$ in the volume matrix and cover a proportion x with $x \geq 0.1$ of the surface of the particles.

An alloy of the composition $M_\alpha Y_\beta Z_\gamma$ is advantageously used for the particles, wherein M is at least one element from the group including Fe, Ni and Co, wherein Y is at least one element from the group including B, C and P, wherein Z is at least one element from the group including Si, Al and Ge, and wherein α , β and γ are specified in atomic percent and meet the following conditions: $60 \leq \alpha \leq 85$; $5 \leq \beta \leq 20$; $0 \leq \gamma \leq 20$, wherein up to 10 atomic percent of the M component may be replaced by at least one element from the group including Ti, V, Cr, Mn, Cu, Zr, Nb, Mo, Ta and W and up to 10 atomic percent of the $(Y+Z)$ component may be replaced by at least one element from the group including In, Sn, Sb and Pb.

In one embodiment of the method, the powder is prepared from amorphous particles in the following process steps: An amorphous strip with a thickness D of $10 \mu\text{m} \leq D \leq 50 \mu\text{m}$, preferably $20 \mu\text{m} \leq D \leq 25 \mu\text{m}$ is produced in a rapid solidification process.

The amorphous strip is then pre-embrittled by heat treatment at a temperature $T_{\text{embrittle}}$, followed by the comminution of the strip to produce platelet-shaped particles.

The temperature $T_{\text{embrittle}}$ is advantageously $100^{\circ}\text{C} \leq T_{\text{embrittle}} \leq 400^{\circ}\text{C}$, preferably $200^{\circ}\text{C} \leq T_{\text{embrittle}} \leq 400^{\circ}\text{C}$.

In one embodiment of the method, the amorphous strip is comminuted at a grinding temperature T_{mill} of $-196^{\circ}\text{C} \leq T_{\text{mill}} \leq 100^{\circ}\text{C}$.

In one embodiment of the method, the particles are pickled in an aqueous or alcoholic solution and then dried before pressing in order to apply an electrically insulating coating.

As a binder, at least one material from the group including polyimides, phenolic resins, silicone resins and aqueous solutions of alkali or alkaline earth silicates is advantageously used. The particles may be coated with the binder before pressing, or the binder may be mixed with the powder before pressing.

The powder is pressed in a suitable tool, for example at a pressure between 1.5 and 3 GPa. After pressing, the magnet core may be heat treated for stress relaxation for a duration t_{relax} of approximately one hour at a temperature T_{relax} of approximately 400°C , but this stress relaxation may alternatively be carried out during the heat treatment for surface crystallisation according to the invention, so that there is no need for a separate heat treatment for stress relaxation. The heat treatments are advantageously carried out in an inert atmosphere.

In one embodiment of the method, processing additives such as lubricants are added to the particles and to the binder before pressing.

With the method according to the invention, magnet cores with a modification-dependent permeability curve which is more linear than in prior art can be produced by relatively simple means.

Embodiments of the invention are explained in greater detail below with reference to the accompanying figures.

Figure 1 is a diagrammatic representation of a magnet core according to the invention;

Figure 2 is a diagrammatic representation of the detailed structure of the magnet core made of platelet-shaped particles according to the invention;

Figure 3 is a diagrammatic cross-section through a section of an individual platelet-shaped particle;

Figure 4 is a diagrammatic cross-section through a section of an individual platelet-shaped particle;

Figure 5 shows the DC superposition permeability curve of magnet cores according to an embodiment of the invention; and

Figure 6 shows the DC preloadability curve B_0 for magnet cores according to Figure 5.

Identical components are identified by the same reference numbers in all figures.

The magnet core 1 according to Figure 1 is a powder composite core with magnetic properties which permit its use, for example in switched power supplies, as storage chokes or as choke cores on the system input side. The cylindrical magnet core 1 is designed as a toroidal core with a central hole 2 and is symmetrical with respect to its longitudinal axis 3. While the powder is pressed to form the magnet core 1, a force is applied in the direction of the longitudinal axis 3. The plane 4 identified by the vector n marks the plane of the direction of magnetisation in the use of the magnet core 1.

Figure 2 diagrammatically shows the platelet-shaped particles 5 of the magnet core 1 and their arrangement after pressing. The platelet-shaped particles 5 have two parallel main surfaces spaced from each other by the thickness D of the platelet-shaped particles 5. These main surfaces originally were the surfaces of a strip produced in a

rapid solidification process, which was comminuted to produce the platelet-shaped particles 5. The platelet-shaped particles 5 have an average platelet diameter of approximately 90 μm , which in the present context denotes the diameter L of the platelets in the plane of their main surfaces.

As a result of pressing with a pressure acting in the direction of the longitudinal axis 3, the platelet-shaped particles 5 are oriented substantially parallel to one another, as can be seen in Figure 2, their main surfaces being parallel to the plane 4 of the magnetisation direction of the magnet core 1.

Figure 3 is a diagrammatic cross-section through a platelet-shaped particle 5. The platelet-shaped particle 5 has a first main surface 6, a second main surface 7 and a volume matrix 8 with an amorphous structure. Areas 9 with a crystalline structure are embedded within the amorphous volume matrix 8. The areas 9 with the crystalline structure are grown into the volume matrix 8 from the first main surface 6 and from the second main surface 7 by means of a special heat treatment.

The areas 9 near the first main surface 6 have a thickness d_1 , and the areas 9 near the second main surface 7 have a thickness d_2 . In the embodiment shown in Figure 3, d_2 is greater than d_1 . This is due to the fact that the platelet-shaped particle 5 has been produced by comminuting a strip produced in a rapid solidification process, wherein the second main surface 7 corresponds to the side of the strip facing the rotating wheel. As a result, the material of the strip was subjected to different temperature gradients on its two main surfaces. This relationship is described in G. Herzer et al.: "Surface crystallisation in metallic glasses", Journal of Magnetism and Magnetic Materials 62 (1986), 143-151.

The relation $d_2 \neq d_1$ does not necessarily apply to the magnet core 1 according to the invention. The essential aspect is that the crystalline areas 9 have an average thickness d (which could be the mean value from d_2 and d_1 in the described embodiment) of at least 5% and at most a quarter of the thickness D of the platelet-shaped particle 5 and cover a proportion x of at least one tenth of the surfaces of the particle 5, i.e. essentially of the first main surface 6 and the second main surface 7.

In this case, the volume shrinkage at the surfaces of the platelet-shaped particles 5, which accompanies crystallisation, causes tensile stresses near the surface and compressive stresses in the volume matrix 8 of the platelet-shaped particles 5. This is illustrated diagrammatically in Figure 4. The platelet-shaped particle 5 can be divided into the near-surface crystallisation zones 10 with the thickness d and the amorphous volume matrix 8. Volume shrinkage and thus tensile stresses occur in the crystallisation zones 10, where the tensile stresses are indicated by arrows 11. The volume matrix, on the other hand, is subject to compressive stresses indicated by arrows 12.

According to a theory explained by Ok et al. in Physical Review Letters B, 23 (1981) 2257, this results in the crystallisation zones 10 in a magnetic anisotropy J parallel to the plane 4 of the subsequent magnetisation direction and in the volume matrix 8 in a magnetic anisotropy J at right angles to the subsequent magnetisation direction as indicated by arrows 13.

As the volume of the amorphous volume matrix 8 is significantly larger than that of the crystalline areas 9 as a rule, the influence of the anisotropy J at right angles to the plane 4 of the subsequent magnetisation direction predominates, and the parallel orientation of the platelet-shaped particles 5 during the pressing process results in a magnetic preferred direction at right angles to the magnetisation direction of the magnet core 1 and thus in a linearisation of the modulation-dependent permeability curve of the magnet core which exceeds the influence of the geometrical shear of the magnetic circuit.

Figures 5 and 6 show the results of measurements of magnetic variables in magnet cores produced in accordance with the invention.

For this purpose, an amorphous strip with a thickness of $23\text{ }\mu\text{m}$ was produced in a rapid solidification process from an alloy of the composition $\text{Fe}_{\text{Rest}}\text{Si}_9\text{B}_{12}$. To reduce its ductility and therefore to make it easier to comminute, this strip was subjected to a heat treatment lasting between half an hour and four hours in an inert atmosphere at a temperature between 250°C and 350°C . The duration and the temperature of the heat

treatment were determined by the required degree of embrittlement; typical values are a temperature of 320°C and a duration of one hour.

Following the heat treatment for embrittlement, the strip is comminuted using a suitable mill such as an impact mill or disc mill to produce a powder of platelet-shaped particles with an average grain size of 90 μm . The platelet-shaped particles are then provided with an electrically insulating oxalic or phosphate surface coating and coated with a heat-resistant binder selected from the group including polyimides, phenolic resins, silicone resins and aqueous solutions of alkali or alkaline earth silicates. The thus coated platelet-shaped particles are finally mixed with a high-pressure lubricant, which may for example be based on metallic soaps or suitable solid lubricants such as MoS_2 or BN.

The mixture prepared in this way is pressed in a pressing tool at pressures between 1.5 and 3 GPa to form a magnet core. The pressing process is followed by a final heat treatment for stress relaxation and for the formation of crystalline areas on the surface of the platelet-shaped particles, the heat treatment being performed in an inert atmosphere at a temperature between 390°C and 440°C for a duration of 5 to 64 hours.

Figure 5 shows the effect of surface crystallisation of the platelet-shaped particles on the DC superposition permeability curve $\Delta\mu$. The magnet core of curve A was produced in the manner described above, but the heat treatment for the surface crystallisation of the platelet-shaped articles was omitted and the magnet core was only subjected to one hour's heat treatment at 440°C for stress relaxation. This magnet core A therefore corresponds to magnet cores of prior art.

The magnet core of curve B was produced in accordance with the method according to the invention and heat-treated for 8 hours at 440°C. This magnet core therefore has crystallised areas on the particle surface. The magnet core of curve B' was likewise produced in accordance with the method according to the invention and heat-treated for 24 hours at 410°C. This longer heat treatment of the magnet core B' at a slightly lower temperature results in the compaction of the crystalline surface layer, i.e. the

proportion x increases without any significant increase in the thickness d of the crystalline areas. As Figure 5 shows, this leads to a further linearisation of the DC superposition permeability curve $\Delta\mu$. All magnet cores have a starting superposition permeability $\Delta\mu_0$ of approximately 60.

According to R Boll, “Weichmagnetische Werkstoffe” (Soft-magnetic Materials) (4th edition 1990), pages 114-115, the DC preloadability B_0 defined as $B_0 = \Delta\mu * \mu_0 * H_{DC}$, wherein $\Delta\mu$ is the DC superposition permeability of the magnet core, μ_0 is the magnetic field constant and H_{DC} is the DC field modification, is a suitable measure for the obtainable storage energy. The DC preloadability B_0 is particularly suitable for the direct comparison of the suitability of various materials for use in choke cores.

Figure 6 shows the increase of the DC preloadability B_0 for given relative DC superposition permeability values of the magnet cores which can be achieved with the production method according to the invention. For easier comparison, the curve A' was added for a magnet core made of a known FeAlSi alloy (Sendust). As Figure 6 shows, the magnet cores according to the invention can achieve a DC preloadability B_0 of $B_0 \geq 0,24$ T at a DC superposition permeability $\Delta\mu$ of 80% of the starting superposition permeability of $\Delta\mu_0$.

List of reference numbers

- 1 Magnet core
- 2 Central hole
- 3 Longitudinal axis
- 4 Plane of magnetisation
- 5 Platelet-shaped particle
- 6 First main surface
- 7 Second main surface
- 8 Volume matrix
- 9 Crystalline areas
- 10 Crystallisation zone
- 11 Arrow

12	Arrow
13	Arrow
D	Thickness of particles
d	Thickness of crystalline areas
d1	Thickness on first main surface
d2	Thickness on second main surface
L	Particle diameter
n	Normal vector

Claims

1. Magnet core (1) made of a composite of platelet-shaped particles (5) with a thickness D and a binder, wherein the particles (5) have an amorphous volume matrix (8) in the surface of which are embedded areas (9) with a crystalline structure which have a thickness d of $0.04 * D \leq d \leq 0.25 * D$ and cover a proportion x of $x \geq 0.1$ of the surface of the particles.
2. Magnet core according to claims 1,
wherein the thickness d is $0.08 * D \leq d \leq 0.2 * D$.
3. Magnet core (1) according to claim 1 or 2,
wherein the particles (5) have the alloy composition is $M_{\alpha}Y_{\beta}Z_{\gamma}$, wherein M is at least one element from the group including Fe, Ni and Co, wherein Y is at least one element from the group including B, C and P, wherein Z is at least one element from the group including Si, Al and Ge, and wherein α , β and γ are specified in atomic percent and meet the following conditions: $60 \leq \alpha \leq 85$; $5 \leq \beta \leq 20$; $0 \leq \gamma \leq 20$, wherein up to 10 atomic percent of the M component may be replaced by at least one element from the group including Ti, V, Cr, Mn, Cu, Zr, Nb, Mo, Ta and W and up to 10 atomic percent of the $(Y+Z)$ component may be replaced by at least one element from the group including In, Sn, Sb and Pb.
4. Magnet core (1) according to any of claims 1 to 3,
wherein the magnet core (1) has a DC preloadability B_0 of $B_0 \geq 0,24 \text{ T}$ at a DC superposition permeability $\Delta\mu$ of 80% of the starting superposition permeability of $\Delta\mu_0$.
5. Magnet core (1) according to any of claims 1 to 4,
wherein the particles (5) have an aspect ratio of at least 2.
6. Magnet core (1) according to any of claims 1 to 5,
wherein the thickness D of the particles (5) is $10 \mu\text{m} \leq D \leq 50 \mu\text{m}$.

7. Magnet core (1) according to any of claims 1 to 6,
wherein the thickness D of the particles (5) is $20\text{ }\mu\text{m} \leq D \leq 25\text{ }\mu\text{m}$.
8. Magnet core (1) according to any of claims 1 to 7,
wherein the particles (5) have an average particle diameter L of approximately $90\text{ }\mu\text{m}$ in the plane of their main surfaces (6, 7).
9. Magnet core (1) according to any of claims 1 to 8,
wherein the particles (5) are provided with an electrically insulating coating on their surfaces (6, 7).
10. Magnet core (1) according to any of claims 1 to 9,
wherein as a binder, at least one material from the group including polyimides, phenolic resins, silicone resins and aqueous solutions of alkali or alkaline earth silicates is selected.
11. Inductive component with a magnet core (1) according to any of claims 1 to 10.
12. Inductive component according to claim 11,
wherein the inductive component is a choke for power factor correction.
13. Inductive component according to claim 11,
wherein the inductive component is a storage choke.
14. Inductive component according to claim 11,
wherein the inductive component is a filter choke.
15. Inductive component according to claim 11,
wherein the inductive component is a smoothing choke.
16. Method for the production of a magnet core (1), comprising the following steps:

- the provision of a powder from amorphous platelet-shaped particles (5) of the thickness D;
- the pressing of the powder with a binder to produce a magnet core (1);
- the heat treatment of the magnet core (1) for a duration $t_{\text{anneal}} \geq 5 \text{ h}$ at a temperature T_{anneal} of $390^{\circ}\text{C} \leq T_{\text{anneal}} \leq 440^{\circ}\text{C}$ while areas (9) with a crystalline structure embedded in the amorphous volume matrix (8) are formed on the surface (6, 7) of the particles,

wherein the heat treatment is continued until the areas (9) with the crystalline structure have reached a thickness d of $0.04 * D \leq d \leq 0.25 * D$ in the volume matrix (8) and cover a proportion x of $x \geq 0.1$ of the surface (6, 7) of the particle (5).

17. Method according to claim 16,

wherein an alloy of the composition $M_{\alpha}Y_{\beta}Z_{\gamma}$ is used as an alloy for the particles (5), wherein M is at least one element from the group including Fe, Ni and Co, wherein Y is at least one element from the group including B, C and P, wherein Z is at least one element from the group including Si, Al and Ge, and wherein α , β and γ are specified in atomic percent and meet the following conditions: $60 \leq \alpha \leq 85$; $5 \leq \beta \leq 20$; $0 \leq \gamma \leq 20$, wherein up to 10 atomic percent of the M component may be replaced by at least one element from the group including Ti, V, Cr, Mn, Cu, Zr, Nb, Mo, Ta and W and up to 10 atomic percent of the (Y+Z) component may be replaced by at least one element from the group including In, Sn, Sb and Pb.

18. Method according to claims 16 or claim 17,

wherein the provision of the powder from amorphous particles (5) involves the following steps:

- the provision of an amorphous strip in a rapid solidification process with a thickness D of $10 \mu\text{m} \leq D \leq 50 \mu\text{m}$;
- the pre-embrittlement of the amorphous strip by means of heat treatment at a temperature $t_{\text{embrittle}}$;
- the comminution of the strip to produce platelet-shaped particles (5).

19. Method according to claim 17,
wherein the thickness D of $20\text{ }\mu\text{m} \leq D \leq 25\text{ }\mu\text{m}$.
20. Method according to claim 18 or 19,
wherein the temperature $t_{\text{embrittle}}$ is $100^{\circ}\text{C} \leq T_{\text{embrittle}} \leq 400^{\circ}\text{C}$.
21. Method according to any of claims 18 to 20,
wherein the temperature $t_{\text{embrittle}}$ is $200^{\circ}\text{C} \leq T_{\text{embrittle}} \leq 400^{\circ}\text{C}$.
22. Method according to any of claims 16 to 21,
wherein the amorphous strip is comminuted to an average particle diameter of $90\text{ }\mu\text{m}$.
23. Method according to any of claims 16 to 22,
wherein the amorphous strip is comminuted at a grinding temperature T_{mill} of $-196^{\circ}\text{C} \leq T_{\text{mill}} \leq 100^{\circ}\text{C}$.
24. Method according to any of claims 16 to 23,
wherein the particles (5) are pickled in an aqueous or alcoholic solution to apply an electrically insulating coating and then dried before pressing.
25. Method according to any of claims 16 to 24,
wherein as a binder, at least one material from the group including polyimides, phenolic resins, silicone resins and aqueous solutions of alkali or alkaline earth silicates is used.
26. Method according to any of claims 16 to 25,
wherein the particles (5) are coated with the binder before pressing.
27. Method according to any of claims 16 to 26,
wherein the pressing process is carried out at a pressure between 1.5 and 3 GPa.

28. Method according to any of claims 16 to 27,
wherein the pressing is followed by a heat treatment for a duration t_{relax} of
approximately one hour at a temperature T_{relax} of approximately 400°C for the
stress relaxation of the magnet core (1).
29. Method according to any of claims 16 to 28,
wherein processing additives such as lubricants are added to the particles (5)
and to the binder before pressing.
30. Method according to any of claims 16 to 29,
wherein the heat treatments are carried out in an inert atmosphere.