

MOTOR MANUFACTURING 101 - SHORT COURSE

While the basic process for assembling small motor stators has changed little over the past 30 years, increased international competition has driven manufacturers to seek significant process improvements in their facilities. Although many subtle improvements in assembly processes are ongoing (i.e. Lean Manufacturing), equipment modernization also needs to be implemented in order to achieve maximum product quality and minimize labor costs. In addition, drastic changes in motor control technology, coupled with the reduction in the cost of microprocessors, has given birth to an entire range of variable speed motors which were not available 10 to 15 years ago.

This paper will discuss the steps involved with assembling a stator for a small electric motor. It will also cover some of the recent advancements in technology implemented in many facilities that improved stator quality while minimizing labor, production and material costs.

STATOR CORE ASSEMBLY

Lamination Selection

Lamination stacking is either performed by hand selecting (by weight or height) or by automatic stack selection. Although automatic stack selection minimizes operator intervention with the core build process, most machines still require frequent operator attention. If the lamination process is inconsistent, automatic selection holds little benefit over hand selecting.

Manual stack selection still remains the most popular method, since an operator can easily compensate when selecting laminations with problems like adhering laminations from heavy burrs, oil or annealing oxidation. To assure stack height accuracy with manually selected laminations, motor manufacturers are using electronic gauges mounted to the core securing machine.

Welding

Welding is a popular and widespread method for securing stator cores. New welding machines offer flexibility and reliability since many have eliminated the need for hydraulic operation.

Despite recent advancements in machine design, welding has a number of drawbacks since a welding machine requires manual loading of the laminations and a high level of maintenance. This maintenance activity (including torch tip adjustments, the monitoring of argon and the sharpening of torch rods) usually requires the attention of a skilled operator or technician. This is an additional concern to the electric motor design since stator core loss could occur by welding across the laminations.

Cleating



This process "V" rolls and then flattens a strip of soft steel down a dovetail slot on the O.D. of the stator laminations. The cleating strip steel is low cost and the process is fast. Cleating machines are extremely flexible and require little setup. Unlike welding, cleating still leaves the stator with

Motor Manufacturing 101 173 Short Course

Xiang Xie



Motor Manufacturing 101 173 Short Course:

This book delves into Motor Manufacturing 101 173 Short Course. Motor Manufacturing 101 173 Short Course is an essential topic that needs to be grasped by everyone, ranging from students and scholars to the general public. This book will furnish comprehensive and in-depth insights into Motor Manufacturing 101 173 Short Course, encompassing both the fundamentals and more intricate discussions.

1. The book is structured into several chapters, namely:
 - Chapter 1: Introduction to Motor Manufacturing 101 173 Short Course
 - Chapter 2: Essential Elements of Motor Manufacturing 101 173 Short Course
 - Chapter 3: Motor Manufacturing 101 173 Short Course in Everyday Life
 - Chapter 4: Motor Manufacturing 101 173 Short Course in Specific Contexts
 - Chapter 5: Conclusion
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 3. In chapter 2, this book will delve into the foundational concepts of Motor Manufacturing 101 173 Short Course. The second chapter will elucidate the essential principles that need to be understood to grasp Motor Manufacturing 101 173 Short Course in its entirety.
 4. In chapter 3, this book will examine the practical applications of Motor Manufacturing 101 173 Short Course in daily life. This chapter will showcase real-world examples of how Motor Manufacturing 101 173 Short Course can be effectively utilized in everyday scenarios.
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 6. In chapter 5, this book will draw a conclusion about Motor Manufacturing 101 173 Short Course. This chapter will summarize the key points that have been discussed throughout the book.
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