

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

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**American School (Lansing,
Ill.), American School of
Correspondence, Chicago**

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web was heißt ausdauertraining es gibt viele verschiedene formen der ausdauer unter ausdauertraining verstehen wir sportarten die vor allem das herz kreislauf system herausfordern die klassischen ausdauersportarten sind laufen schwimmen und rad fahren auch längere einheiten auf dem crosstrainer oder der rudermaschine fallen

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web deine leistung in den bereichen ga1 ga2 und wsa verbessert sich dadurch und du läufst schwimmst oder radelst schneller empfehlung 80 solltest du im ga1 und 20 im wsa bereich trainieren hier werden die größten effekte auf die verbesserung der ausdauerleistung erzielt

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web stellt man es richtig an und beachtet einige grundlegende regeln so kann ein gesunder mensch seine ausdauer schnell steigern aber nicht nur gesunde menschen sondern auch herz kreislauf patienten oder menschen in der rekonvaleszenz können ein sanftes ausdauertraining betreiben

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web effektives ausdauertraining so trainieren profis mit der passenden ernährung effektives ausdauertraining früher vs heute während früher oft die devise lautete ordentlich umfänge zu machen differenziert man heute zunächst um welche spezifische belastung in der jeweiligen sportart handelt es sich überhaupt

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web may 7 2014 entsprechendes ausdauertraining fördert nicht nur die leistungsfähigkeit sondern hat viele weitere gute seiten es schützt vor stress fördert die fettverbrennung ist stimmungsaufhellend und wirkt sich positiv auf das herz kreislauf system aus

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web ausdauer für einsteiger diese fehler sollten sie vermeiden wie sie als sporteinsteiger ihre ausdauer trainieren ohne den körper zu überfordern sporteinsteiger die ihre ausdauer trainieren möchten sollten mit dem training langsam starten

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web apr 26 2020 während radfahren zur arbeit oder 30 minuten joggen unbedenklich sind zählt bei intensiverem training

das richtige maß eine halbe stunde sport an vier bis fünf tagen pro woche gilt als gesund für ausdauersportler ist es ratsam pausen in den trainingsplan einzubauen

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web jan 28 2020 foto istock laufen fahrradfahren oder schwimmen ein ausdauertraining verbessert die körperliche fitness wer seine ausdauer aufbaut und sein training gezielt darauf auslegt tut seiner gesundheit gutes hier bekommst du die wichtigsten fakten und tipps zum thema