

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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Xiaolong Qi



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The Creamery Journal ,1925 *Bulletin* United States. Federal Board for Vocational Education,1932 Vocational Education Bulletin United States. Division of Vocational Education,1929 **Butter, Cheese, and Milk Products Journal** ,1927 **Horseless Age** ,1913 **Bulletin** Federal Board for Vocational Education,1929 **Ice Cream Trade Journal** ,1921 **17th WCEAM Proceedings** Georges Abdul-Nour,Minh Ngoc Dinh,Turuna Seecharan,Adolfo Crespo Márquez,Dragan Komljenovic,Joe Amadi-Echendu,Joseph Mathew,2024-09-30 17th WCEAM Proceedings provides a record of some of the intellectual discussions including keynote addresses research paper presentations panel debates and practical workshops that took place among the attendees and participants of the 17th World Congress on Engineering Asset Management WCEAM held from 18 20 October 2023 at the Sheraton Saigon Hotel and Towers Ho Chi Minh City Vietnam The events were organized by the International Society for Engineering Asset Management ISEAM and hosted by RMIT University Vietnam LLC RMIT VN Ho Chi Ming City The content of the book includes topics listed below under a general theme of Sustainable Management of Engineered Assets in a Post Covid World Industry 4 0 Digital Transformation Society 5 0 and beyond Sustainable asset investment acquisition operations maintenance and retirement strategies Production service transformation and product service systems Sustainable asset acquisition operations maintenance and retirement processes Modeling and simulation of acquisition operations maintenance and retirement processes Reliability and resilience engineering Applications of the Fourth Industrial Revolution 4IR technologies in EAM e g Digital Twins Cybersecurity issues in asset management Asset condition risk resilience and vulnerability assessments Asset management and decision support systems Applications of international and logical guidelines and standards in EAM Human dimensions and asset management performance Case studies of asset management in various industries and sectors This proceedings is an excellent resource for asset management practitioners researchers and academics as well as undergraduate and postgraduate students

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 Children's Bureau,1923 The Vocational Summary ,1918 *Machines of Youth* Gary S. Cross,2018-05-04 For American
 teenagers getting a driver s license has long been a watershed moment separating teens from their childish pasts as they
 accelerate toward the sweet sweet freedom of their futures With driver s license in hand teens are on the road to buying and
 driving and maybe even crashing their first car a machine which is home to many a teenage ritual being picked up for a first
 date parking at a scenic overlook or blasting the radio with a gaggle of friends in tow So important is this car ride into
 adulthood that automobile culture has become a stand in a shortcut to what millions of Americans remember about their
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 Gary S Cross details how an automobile obsession drove teen peer culture from the 1920s to the 1980s seducing budding
 adults with privacy freedom mobility and spontaneity Cross shows how the automobile redefined relationships between
 parents and teenage children becoming a rite of passage producing new courtship rituals and fueling the growth of
 numerous car subcultures Yet for teenagers today the lure of the automobile as a transition to adulthood is in decline
 Tinkerers are now sidelined by the advent of digital engine technology and premolded body construction while the attention
 of teenagers has been captured by iPhones video games and other digital technology And adults have become less tolerant of
 teens on the road restricting both cruising and access to drivers licenses Cars are certainly not going out of style Cross
 acknowledges but how upcoming generations use them may be changing He finds that while vibrant enthusiasm for them
 lives on cars may no longer be at the center of how American youth define themselves But for generations of Americans the
 modern teen experience was inextricably linked to this particularly American icon Vocational Summary ,1920 Ward's
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