

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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Table of Contents Motor Manufacturing 17short Course

1. Understanding the eBook Motor Manufacturing 17short Course
 - The Rise of Digital Reading Motor Manufacturing 17short Course
 - Advantages of eBooks Over Traditional Books
2. Identifying Motor Manufacturing 17short Course
 - Exploring Different Genres
 - Considering Fiction vs. Non-Fiction
 - Determining Your Reading Goals
3. Choosing the Right eBook Platform
 - Popular eBook Platforms
 - Features to Look for in an Motor Manufacturing 17short Course
 - User-Friendly Interface
4. Exploring eBook Recommendations from Motor Manufacturing 17short Course
 - Personalized Recommendations
 - Motor Manufacturing 17short Course User Reviews and Ratings

- Motor Manufacturing 17short Course and Bestseller Lists
- 5. Accessing Motor Manufacturing 17short Course Free and Paid eBooks
 - Motor Manufacturing 17short Course Public Domain eBooks
 - Motor Manufacturing 17short Course eBook Subscription Services
 - Motor Manufacturing 17short Course Budget-Friendly Options
- 6. Navigating Motor Manufacturing 17short Course eBook Formats
 - ePub, PDF, MOBI, and More
 - Motor Manufacturing 17short Course Compatibility with Devices
 - Motor Manufacturing 17short Course Enhanced eBook Features
- 7. Enhancing Your Reading Experience
 - Adjustable Fonts and Text Sizes of Motor Manufacturing 17short Course
 - Highlighting and Note-Taking Motor Manufacturing 17short Course
 - Interactive Elements Motor Manufacturing 17short Course
- 8. Staying Engaged with Motor Manufacturing 17short Course
 - Joining Online Reading Communities
 - Participating in Virtual Book Clubs
 - Following Authors and Publishers Motor Manufacturing 17short Course
- 9. Balancing eBooks and Physical Books Motor Manufacturing 17short Course
 - Benefits of a Digital Library
 - Creating a Diverse Reading Collection Motor Manufacturing 17short Course
- 10. Overcoming Reading Challenges
 - Dealing with Digital Eye Strain
 - Minimizing Distractions
 - Managing Screen Time
- 11. Cultivating a Reading Routine Motor Manufacturing 17short Course
 - Setting Reading Goals Motor Manufacturing 17short Course
 - Carving Out Dedicated Reading Time
- 12. Sourcing Reliable Information of Motor Manufacturing 17short Course
 - Fact-Checking eBook Content of Motor Manufacturing 17short Course
 - Distinguishing Credible Sources

13. Promoting Lifelong Learning
 - Utilizing eBooks for Skill Development
 - Exploring Educational eBooks
14. Embracing eBook Trends
 - Integration of Multimedia Elements
 - Interactive and Gamified eBooks

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