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Isaacson

[11] **3,871,136**

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[54] **VIBRATORY APPARATUS WITH IMPROVED MOTOR ACTUATED DOOR MECHANISM FOR CLOSING THE DISCHARGE OUTLET**

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[52] **U.S. Cl.** **51/163**

[51] **Int. Cl.** **B24b 31/06**

[58] **Field of Search** 51/163

[56] **References Cited**

UNITED STATES PATENTS

3,296,429	4/1966	Ruppe	51/163 X
3,643,384	2/1972	Isaacson	51/163
3,685,213	8/1972	Rampe	51/163
3,694,968	10/1972	Isaacson	51/163

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[57] **ABSTRACT**

An open top tub or container is supported for vibration and is adapted to receive a workload of treating media and parts to be treated. The container is vibrated by variable power operated means and includes an end wall having an outlet for removing the workload from the container. The outlet is closed by a door member which is pivotally supported for movement between a closed position and a retracted open position in response to operation of a reversible electric motor. The motor drives an elongated screw which extends through a rotatable nut member connected to the door member. Preferably, the motor consists of a DC motor which has a permanently magnetized stator and may be continuously energized so that a continuously applied force holds the door member closed while the container and work load are vibrating. A water-tight seal is formed around the door by a resilient seal which contacts an outwardly projecting annular bead.

11 Claims, 5 Drawing Figures

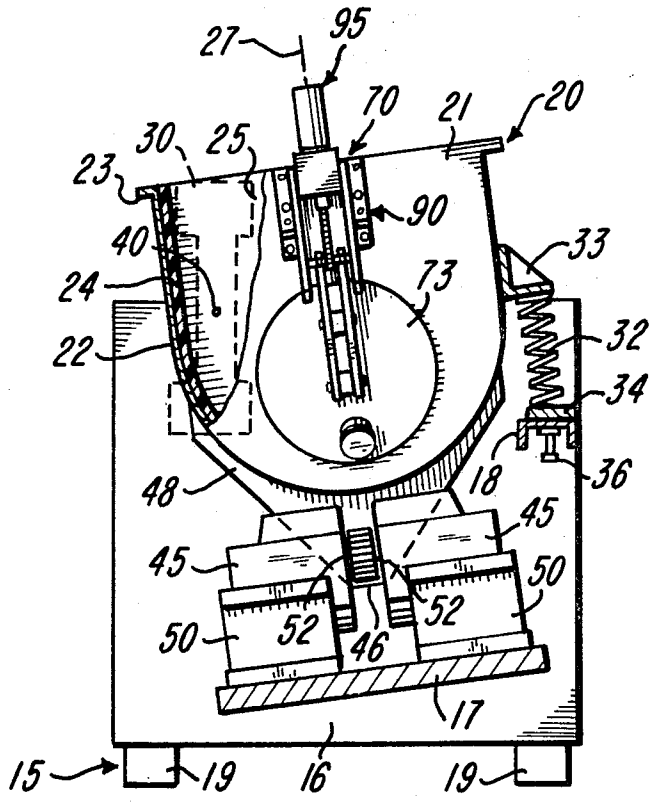


FIG-1

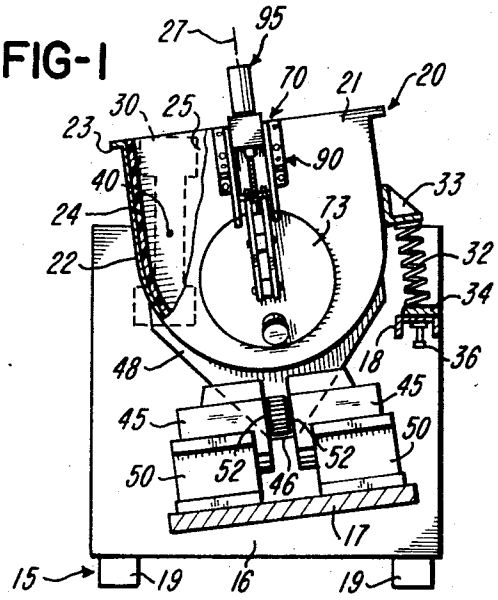


FIG-2

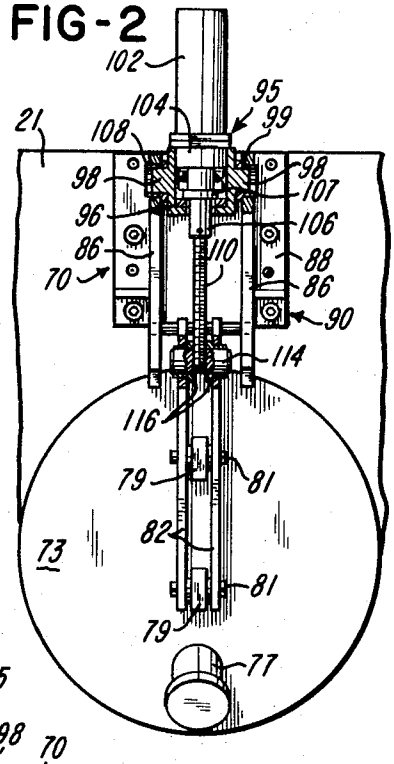


FIG-3

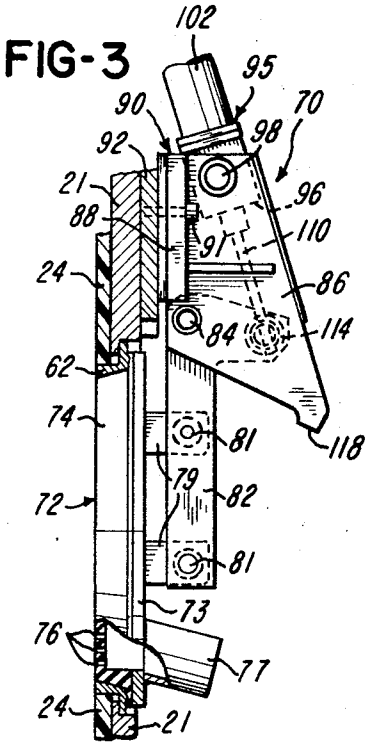


FIG-4

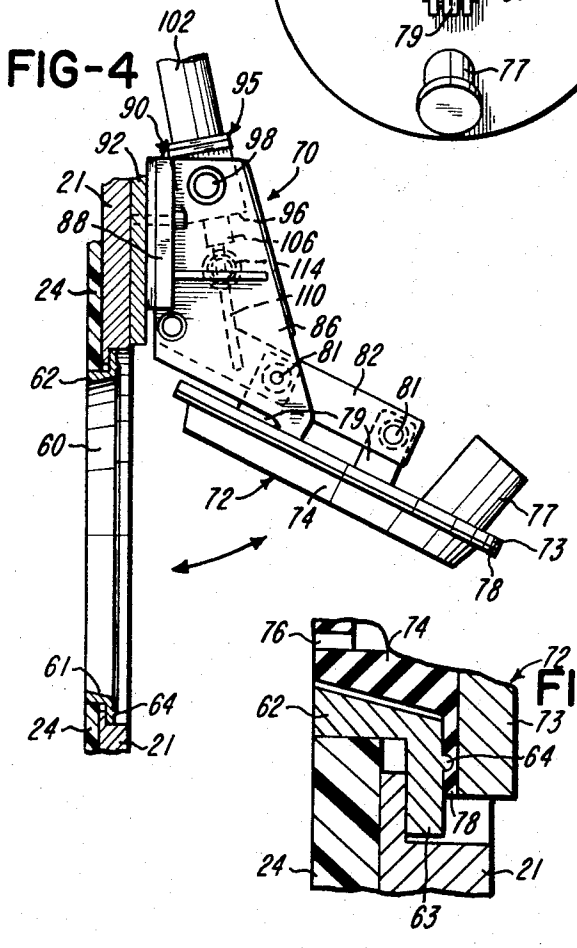


FIG-5

VIBRATORY APPARATUS WITH IMPROVED MOTOR ACTUATED DOOR MECHANISM FOR CLOSING THE DISCHARGE OUTLET

BACKGROUND OF THE INVENTION

In a vibratory machine or apparatus such as disclosed in Isaacson et al U.S. Pat. No. 3,173,664, it is common to provide a dischage outlet within one or both ends of the open top tub or container to provide for conveniently removing the workload of parts and media after the parts have been finished or treated. Usually, the discharge outlet is closed during the vibratory treating process by means of a door member which is located by a hand actuated toggle latch, for example, as disclosed in Isaacson et al., U.S. Pat. No. 3,643,384 which issued to the assignee of the present invention. Another means for opening and closing the door member is disclosed in Isaacson et al U.S. Pat. No. 3,694,968 which also issued to the assignee of the present invention. In this patent, the door opening and closing means consist of a fluid actuated rotary motor which moves a linkage system connected to the door.

Since the door member is usually supported by the adjacent end wall of the container, and the door member and its locking or actuating mechanism vibrate with the container, it is highly desirable to minimize the mass of the door and its actuating mechanism. It is also desirable for the door actuating mechanism to be rugged and durable in construction so that it can withstand the vibration for a substantial period of time, and also for the mechanism to be electrically actuated so that the operation of the door member between its closed and open positions can be automatically controlled in a simple manner from an electrical control box or panel. It has also been found important for the door actuating mechanism to provide for holding the door member in its closed position with a continuously applied force to prevent a leak from developing when the container and the door member are being vibrated during treatment of the parts.

SUMMARY OF THE INVENTION

The present invention is directed to an improved automatically operated door system for closing the discharge outlet of a vibratory machine which is used for treating a supply of parts. The door system provides all of the desirable features mentioned above and, in accordance with a preferred embodiment, incorporates a reversible D.C. motor and gear reducer unit which drives an elongated screw. The screw is threaded into a nut member which is supported by a set of arms secured to a circular door member. The arms also support the door member for pivotal movement between its closed and open positions. The D.C. motor incorporates a permanently magnetized stator and requires only a very small current so that the motor may be continuously energized to apply a constant force against the door member in its open and closed positions. This constant force minimizes relative vibration between the door member and the adjacent end wall of the container in the open position and between the door member and the discharge opening in its closed position to assure a fluid-tight seal between the door member and the container.

Other features and advantages of the invention will be apparent from the following description, the accompanying drawings and the appended claims.

BRIEF DESCRIPTION OF THE DRAWINGS

FIG. **1** is an end elevational view of a vibratory machine incorporating a door system constructed in accordance with the present invention, and with portions of the machine broken away to show internal construction;

FIG. **2** is an enlarged elevational view of the door system shown in FIG. **1**;

FIG. **3** is a side elevational view of the door with a portion shown in section, and illustrating the door system in its closed position;

FIG. **4** is a view similar to FIG. **3** and illustrating the door system in its open position; and

FIG. **5** is an enlarged fragmentary section of the door member in its closed position and showing the seal formed within the container.

DESCRIPTION OF THE PREFERRED EMBODIMENT

The vibratory machine or apparatus shown in the drawing generally includes a base frame **15** having parallel spaced vertical end walls **16** rigidly connected by cross members including a cross plate **17** and a channel member **18.** The frame **15** is mounted on resilient shock absorbing feet **19** located at the corners of the frame. An open top trough-like tub or container **20** is positioned between the end walls **16** of the frame **15** and includes parallel spaced vertical end walls **21** which are rigidly connected by an intermediate wall **22** having a U-shaped cross-sectional configuration. The container **20** has an outwardly projecting peripheral flange **23,** and the walls **21** and **22** are covered with a durable polyurethane lining **24** having ribs defining a corrugated inner surface.

The lined container walls **21** and **22** define an open top chamber **25** having a rectangular horizontal configuration and a U-shaped vertical configuration. The chamber **25** is adapted to receive a workload, for example, a media of ceramic chips or other abrasive materials and a suspended batch of parts which are to be surface finished such as by a deburring, polishing or descaling operation. The container **20** is positioned so that a longitudinal plane **27** extending through the center of the chamber **25,** is slightly inclined from a vertical plane.

The container **20** is supported on one side of the center plane **27** by a pair of I-shaped spring beams **30** which connect the end walls **21** of the container to the end walls **16** of the frame **15.** On the opposite side of the center plane **27,** the container **20** may be supported by a plurality of longitudinally spaced coil compression springs **32** which extend between the frame channel **18** and a longitudinally extending angle bracket **33** secured to the adjacent side of the intermediate wall **22** of the container. The lower end of each coil spring **32** seats on a fitting **34** supported by the upper end of a screw **36** which can be adjusted to vary the upward force exerted by the spring on the container **20.**

The spring beams **30** establish an effective pivot axis **40** for the container **20** and cooperate with the springs **32** to provide the container **20** with a predetermined resonant frequency of oscillation. This resonant frequency is in the neighborhood of and generally above

3,600 cycles per second when the apparatus is to be operated from 60 cycle power supply. After the load is placed within the container **20,** the coil springs **32,** when used, are adjusted so that the resonant frequency of the system including the container, load, spring beams and coil springs, is substantially 3,600 cycles per second.

The container **20** is preferably oscillated by power operated means including a pair of electromagnets **45** arranged in opposing relation on opposite sides of a bar-like armature **46** that is rigidly connected to the tub. The ends of the armature are rigidly connected to parallel spaced plates **48** which are secured to the intermediate wall **22** of the container **20.** Each magnet **45** is mounted on a bracket **50** which is slidably supported by the cross plate **17** and is laterally adjustable by a set of screws (not shown). Each magnet **45** is adjusted after the container is loaded to a predetermined value to form a predetermined uniform gap **52** between the armature **46** and each of the electromagnets **45** according to the desired amplitude of oscillation. When the actual load is placed within the container **20** and it is greater than the predetermined value, the armature **46** will move closer to the magnet **45** on the left (FIG. **1**). The coil springs **45** are then adjusted to return the armature to a position substantially centered between the magnets.

As shown in FIGS. **3** and **4,** one of the end walls **21** of the container **20** is provided with a circular discharge outlet **60** which is defined by a frusto-conical surface **61** of a rigid metal ring **62** having an outwardly projecting flange portion **63** rigidly secured to the end wall **21.** The flange portion **63** of the ring **62** includes an axially or outwardly projecting annular rib or bead **64.** In accordance with the present invention, the discharge of media and treated parts through the outlet **60** is controlled by a closure mechanism or door system **70** which includes a circular door member **72** incorporating a flat circular metal plate **73.**

The plate **73** carries a plug member **74** which is cast of urethane and has a frusto-conical outer surface adapted to extend adjacent the surface **61** when the door member **72** is in its closed position (FIG. **3**). The plug member **74** is provided with a series of small drainage holes **76** so that liquid may be removed from the chamber **25** through a conduit **77** projecting outwardly from the door plate **73.** The plug member **74** includes an outwardly projecting flange portion **78** (FIG. **5**) which is also secured to the plate **73** and engages the annular bead **64** when the door member **72** is closed. Instead of the bead **64** being formed as a part of flange **63** it may be made as a part of the plate **73.**

A pair of spaced lugs **79** (FIGS. **2** and **3**) project outwardly from the metal door plate **73** and are connected by a set of cross pins **81** to a pair of parallel spaced L-shaped arm members **82.** The arm members **82** are pivotally supported by a cross pin **84** which extends through parallel spaced members or plates **86** rigidly connected by a base plate **88.** The plates **86** and **88** cooperate to form a mounting bracket **90** which is rigidly secured by a set of screws **91** to a plate **92** mounted on the adjacent end wall **21** of the container **20.**

The parallel spaced bracket plates **86** also support a motor-gear reducer unit **95** which projects into a tubular housing **96** positioned between the plates **86.** The housing **96** includes a pair of diametrically opposed cylindrical trunions **98** which project outwardly into corresponding tubular bushings **99** retained within corresponding holes in the bracket plates **86.** The trunions **98** provide for pivotal movement of the motor-gear reducing unit **95** on an axis extending parallel to the adjacent end wall **21** of the container **20.**

Preferably, the unit **95** includes a direct current motor **102** which has a permanently magnetized stator and a relatively high shaft speed, for example, 4,000 r.p.m. The output shaft of the motor **102** drives a gear reducer **104** which provides a reduction of approximately 30 to 1. The output shaft of the gear reducer is splined and drives a tubular female splined coupling **106** having an outwardly projecting flange **107** which has an inner face engaging an anti-friction thrust bearing **108** confined within the housing **96.** The coupling **106** connects the output shaft of the gear reducer **104** to one end portion of an elongated screw **110.** Thus when the motor **102** is energized, the coupling **106** and screw **110** are driven at a speed of approximately 133 r.p.m.

The outer end portion of the screw **110** is threaded into a hole extending radially through a cylindrical nut member **114** which is rotatably supported by a set of bushings **116** confined within corresponding holes in the arm plates **82.** Thus when the electric motor **102** is actuated in one direction, it is effective to move the door member **72** towards its closed position (FIG. **3**) wherein the resilient flange portion **78** of the plug member **74** firmly engages the annular bead **64** and forms a positive fluid-tight seal between the door member **72** and the adjacent end wall **21** of the container **20.** When the motor **102** is operated in the opposite or reverse direction, the door member **72** is moved or pivoted to its open position (FIG. **4**) where the metal plate **74** firmly engages the stop surfaces **118** formed on the outer end portions of the bracket plates **86.** In its open position, the door member **72** provides for the discharge of the workload of treating media and treated parts from the tub chamber **25.** The treated parts are then separated from the treating media, for example, by a vibratory screen, and the media is returned to the chamber **25** for receiving the next batch of parts to be treated.

From the drawing and the above description, it is apparent that a vibratory machine or apparatus incorporating a closure mechanism or door system constructed in accordance with the invention, provides desirable features and advantages. One important feature is provided by the relative low mass of the motor-gear reducer unit **95** and the support bracket **90.** Since these components are supported directly by the vibratory tub or container **20** along with the door member **72,** their low mass reduces the electrical power required by the electromagnets **45** for vibrating or oscillating the assembly of the container **20** and the door system **70** and also maintains a minimum of relative vibration between the door member and its supporting structure.

Another important feature is provided by the small electrical power required to operate the reversible D.C. motor **102** for opening and closing the door member **72.** That is, because the small electrical power required by the motor **102,** the motor may be continuously energized in a stalled condition so that a continuing force is exerted on the door member **72** to hold the door member in its closed position while the container **20** is being vibrated. In addition, when the door member is moved to its open position (FIG. **4**), the motor **102** may

remain energized and in a stalled condition so that the door member **72** is held against the stop surfaces **118** with a continuously applied force and thereby avoid vibration of the door member **72** relative to the support bracket **90** and the container **20.** The direct electrical actuation of the reversible motor **102** also provides for conveniently automating the operation of the closure mechanism **70** so that it may be actuated from a remote control box or panel which also controls the batch supply of parts and the return of media to the container **20.** As a result, a completely automated cycle may be provided. It is also within the scope of the invention to position a small control switch on the door member **72** for sensing the pressure exerted by the door plate **73** and the resilient flange **78** against the flange **63** of the ring **62** when the door member is closed. When the pressure exceeded a predetermined value, the switch would de-energize the motor **102.**

While the form of vibratory apparatus herein described constitutes a preferred embodiment of the invention, it is to be understood that the invention is not limited to this precise form of apparatus, and that changes may be made therein without departing from the scope and spirit of the invention as defined in the appended claims.

The invention having thus been described, the following is claimed:

1. In vibratory apparatus including a frame, a container defining a chamber adapted to receive a load of media and parts to be vibrated, means mounted on said frame and supporting said container for vibration, power operated means for vibrating said container with sufficient force to effect generally orbital movement of the load within said chamber, and said container having a wall defining an outlet to provide for the discharge of treated parts from said chamber, an improved door system for said outlet, comprising a door member, means supporting said door member for movement between a closed position forming a closure for said outlet and an open position spaced from said outlet, a reversible electric motor drive unit having a rotary output shaft, means for moving said door member between said open and closed positions in response to rotation of said shaft and for holding said door member in said closed position in response to energization of said motor in a stalled condition.

2. Vibratory apparatus as defined in claim **1** wherein said motor drive unit comprises a gear reducer for driving said output shaft at a speed substantially lower than the speed of said motor, a screw member and a nut member connected to said door member, said screw member is connected to said shaft for rotation thereby, and said door member includes means for supporting said nut member.

3. Vibratory apparatus as defined in claim **1** wherein said motor drive unit comprises a direct current motor and a gear reducer mounted on said motor for driving said output shaft to miminize the mass of said motor drive unit.

4. Vibratory apparatus as defined in claim **1** wherein said motor drive unit is adapted to be continuously energized for continuously holding said door member towards said closed position to effect a positive fluid-tight seal between said door member and said wall of said container during vibration of said container.

5. Vibratory apparatus as defined in claim **1** including a bracket member mounted on said wall of said container and supporting said door member for pivotal movement between said open and closed positions, and means on said bracket member for supporting said motor drive unit for pivotal movement during movement of said door member between said open and closed positions.

6. Vibratory apparatus as defined in claim **5** wherein said bracket member includes means forming a stop surface for said door member in said open position, and said electric motor drive unit is effective to hold said door member firmly against said stop surface while said container is vibrating.

7. Vibratory apparatus as defined in claim **5** wherein said bracket member comprises a set of generally parallel spaced support members, said motor unit is positioned generally between said support members, and including an arm member secured to said door member and extending between said support members, and means on said support members for pivotally supporting said arm member.

8. Vibratory apparatus as defined in claim **2** wherein said means supporting said door member comprise a set of generally parallel spaced arm members secured to said door member, means mounted on said container and pivotally supporting said arm members, and said arm members support said nut member for rotation during movement of said door member between said open and closed positions.

9. Vibratory apparatus as defined in claim **1** including a resilient sealing member positioned between said door member and said wall of said container to form a fluid-tight seal therebetween, and means forming an outwardly projecting annular bead to produce concentrated sealing force against said sealing member when said door member is in said closed position.

10. In vibratory apparatus including a frame, a container defining a chamber adapted to receive a load of media and parts to be vibrated, means mounted on said frame and supporting said container for vibration, power operated means for vibrating said container with sufficient force to effect generally orbital movement of the load within said chamber, and said container having a wall defining an outlet to provide for the discharge of treated parts from said chamber, an improved door system for said outlet, comprising a door member, bracket means supporting said door member for pivotal movement between a closed position forming a closure for said outlet and an open position spaced from said outlet, a reversible electric motor and gear reducer unit supported by said bracket means and having a rotary output shaft, an elongated screw member connected to said shaft for rotation therewith, a nut member connected to said door member for movement therewith and recieving said screw member, said screw member being rotated within said nut member in response to energizing said motor to effect movement of said door member between said open and closed positions.

11. Vibratory apparatus as defined in claim **10** wherein said motor comprises a direct current motor having a permanently magnetized stator, and said motor is adapted to be continuously energized for continuously holding said door member towards said closed position to effect a positive fluid-tight seal between said door member and said wall of said container during vibration of said container.

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