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(54) Title: METHOD FOR ASSEMBLING A ROTOR WITH PERMANENT MAGNETS, HOLDER APPLIED THEREBY, AND ROTOR OBTAINED BY SUCH A METHOD

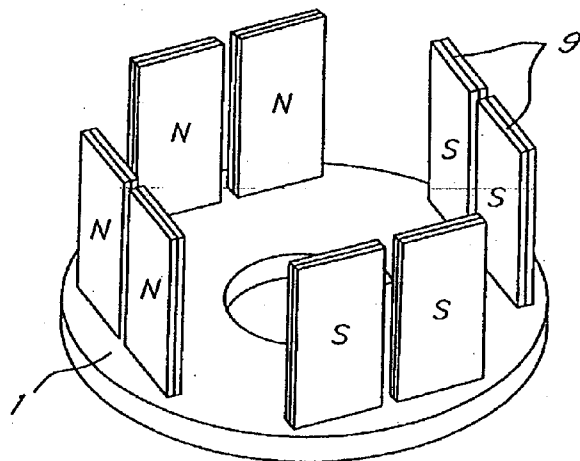


Fig. 4

(57) Abstract: Method for assembling a rotor (18) with permanent magnets (9 or 17), characterized in that it comprises the following steps of: introducing the magnets (9 or 17) in recesses (4) of a non-ferromagnetic holder (3); combining the holder (3) and the permanent magnets (9 or 17) with a non-ferromagnetic support plate (1 or 16); attaching the permanent magnets (9 or 17) to the support plate (1 or 16); and removing the holder (3) and providing lamellae (13) over the permanent magnets attached to the support plate (1 or 16).



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Method for assembling a rotor with permanent magnets, holder applied thereby, and rotor obtained by such a method.

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The present invention relates to a method for assembling a rotor with permanent magnets, a holder applied thereby, and a rotor obtained by such a method.

10 More specifically, the invention is intended for assembling such a rotor for use in interior permanent magnet motors (IPM).

In standard induction motors the rotor is composed of
15 ferromagnetic lamellae, which are held together by a cage, usually made by injection moulding.

Motors with a laminated rotor are also known, whereby permanent magnets are positioned in ferromagnetic lamellae,
20 and which motors, as result thereof, do not have a cage and require another way of compressing and holding the lamellae together.

It is known that when assembling this last type of motor
25 the lamellae are first joined together in a stack and are mutually attached, for which different methods are already known.

For instance, it is possible to punch the lamellae to each
30 other, or even to attach them to each other by means of rivets or welded joints.

A disadvantage of this method is that the local connections between the isolated lamellae result in a reduced performance of the motor, since they have a negative influence on the iron losses induced by the magnetic field.

A possible solution is the use of adhesives to connect these lamellae to each other. A disadvantage is that when sticking the lamellae together by means of adhesives, this method is expensive and sensitive to temperature.

Another disadvantage is that it is difficult to introduce the permanent magnets in recesses provided for this purpose in the lamellae that are already joined together. The permanent magnets exert high forces on the ferromagnetic lamellae and on the other magnets already positioned in place as a result of which they do not remain automatically on their position.

Another disadvantage of the lamellae that have already been joined is the possibility to make mistakes by mounting the magnets in an incorrect orientation in the recesses provided for this purpose, more specifically with the north-south direction of the magnets opposite to the intended north-south direction.

It is known that this incorrect orientation can be avoided by mounting the magnets in non-magnetised state in the rotor and magnetize them afterwards, together with the whole rotor, but this way of magnetising has the disadvantage of involving a high energy requirement.

The present invention aims to offer a solution to one or more of the above-mentioned and/or other disadvantages, by providing a method for assembling a rotor with permanent magnets, which method comprises the following steps:

- introducing the magnets into recesses of a non-ferromagnetic holder;
- assembling the holder and the permanent magnets with a non-ferromagnetic support plate;
- 10 - attaching the permanent magnets to the support plate; and
- removing the holder and providing lamellae over the permanent magnets attached to the support plate.

15 According to a preferred characteristic of the invention this method comprises the following steps:

- assembling two support plates with permanent magnets attached thereto,
- introducing a rotor axis through a first support plate;
- 20 - stacking lamellae over said rotor axis to cover said magnets completely;
- further building the stack with additional lamellae which could contain the magnets of the second support plate, by moving this second support plate over the rotor axis with its permanent magnets directed towards
- 25 the first support plate; and
- attaching the two support plates to the rotor axis.

Preferably, attachment of the two support plates is achieved by axially compressing the two support plates with the lamellae situated in between, and blocking the support

30

plates on the rotor axis in axial direction.

For example, the two support plates can be axially compressed on the rotor axis by way of a circlip, a safety ring, a bolt, a clamp ring or another clamping part.

An advantage of this method is that the lamellae are compressed by the aforementioned support plates, without having made any connection between one lamella and another, which is favourable to the good working of the motor.

Another advantage of this method is that the lamellae are firmly anchored, and are not moveable, which is not only favorable for the good working of the motor, but also prevents annoying noises would be produced.

Preferably, during the assembly according to the method of the invention, the support plates, the lamellae and the rotor axis are aligned, preferably in the direction of rotation around the rotation axis.

Preferably the support plates and the lamellae are provided with a passage for a rotor axis, which passage is provided with a recess that fits over a keyway which extends along the axial direction of the rotor axis, such that the support plates and the lamellae are held in a non-rotatable and axially aligned position.

Preferably, the attachment of the permanent magnets to the non-ferromagnetic support plate according to the method is done by glueing, whereby the adhesive can be an adhesive

that hardens as under influence of applied pressure.

Preferably, the support plate is placed on a ferromagnetic underground during assembly in order to exert a pressure
5 between the permanent magnets and the support plate due to the magnetic attraction of the permanent magnets on the ferromagnetic underground, during attachment of the magnets to the support plate by means of glueing.

10 Preferably, the non-ferromagnetic holder is provided with at least one magnet that, in case of incorrect introduction of the permanent magnets of the rotor in the holder, is able to repel or stop the concerning permanent magnet in axial direction.

15 Preferably, the aforementioned magnet of the holder is positioned opposite to a recess in the holder for a permanent magnet of the rotor, and this at a distance from the entry of the aforementioned recess along which the
20 permanent magnet of the rotor is introduced into the holder.

An advantage of this method is that incorrect introduction of permanent magnets is prevented during assembling a
25 rotor.

In order to show more clearly the aspects of the invention, a preferred embodiment of a method according to the invention for assembling a rotor with permanent magnets is
30 described hereunder, with reference to the accompanying drawings, by way of example without having any limiting

character, in which:

- figure 1 represents schematically and in perspective view a non-ferromagnetic support plate and holder according to the invention;
- figure 2 represents a view according to arrow F2 of the holder in figure 1;
- figure 3 represents the positioning of permanent magnets on the support plate in the holder;
- figure 4 represents a support plate to which are attached permanent magnets according to the invention;
- figure 5 represents the assembly of figure 4 on a rotor axis;
- figure 6 represents the assembly of ferromagnetic lamellae on the rotor axis of figure 5;
- figure 7 represents the assembly of a second support plate to which permanent magnets are attached, to the rotor axis but now in an opposite manner;
- figure 8 represents the assembled rotor according to the invention.

Figure 1 shows a non-ferromagnetic support plate 1 which in this example is disc-shaped and demonstrates a preferably centrally located, through, round hole, as well as a recess 2 that in this case consists of a notch in the circumferential wall of the said central hole.

On the aforementioned support plate 1 a non-ferromagnetic holder 3 can be placed, whereby in this case said holder 3 shows also a disc-shape and whereby this holder 3 is provided with recesses 4 extending in the axial direction

and which, in this case, continue through the entire thickness of the holder 3, and with recesses 5 which, in this case, only continue up to the half of the depth of the holder.

5

As represented in figure 2 the exits 6 of the recesses 4 through the holder 3 are visible on one axial end of the holder 3, which exits 6 are widened towards the end plane of the concerning axial end.

10

The concerning end plane is also provided with a keyway 7 which together with a disc-shaped protuberance 8 on this end plane fits as a key to the central hole with the recess 2 of the support plate 1 from figure 1.

15

Figure 3 represents the positioning of permanent magnets 9 that fit into the recesses 4 provided for this purpose in the holder 3, and the position of magnets 10 in the recesses 5 of half depth provided to that end.

20

Each permanent magnet 9 is provided with a magnetic south plane, designated by the letter S, and with a magnetic north plane, designated by the letter N. The smaller magnets 10 also have a S and a N side.

25

In figure 4 a support plate 1 is represented to which all permanent magnets 9 are attached in the desired position.

Figure 5 shows the assembly of a support plate 1 with
30 permanent magnets 6 on a rotor axis 11 provided with a keyway 12 cooperating with the recess 2 of the support

plate 1.

Figure 6 shows the stacking of the ferromagnetic lamellae 13 onto a rotor axis 11 provided with a keyway 12, whereby the ferromagnetic lamellae 13 are provided with a recess 14 fitting over the keyway 12 of the rotor axis 11, and with recesses 15 which fit around the permanent magnets 9.

Figure 7 shows the assembly of a second support plate 16 to which permanent magnets 17 are attached by moving this second plate 16 over the rotor axis in the opposite direction from the first support plate 1.

Figure 8 represents a rotor 18 as assembled according to the invention, limited by a upper support plate 16, and a lower support plate 1, in between which stacked lamellae 13 are situated, which lamellae 13 are compressed by both support plates 1 and 16 under influence of a circlip 19.

The method for assembling an electromagnetic rotor is very easy and as follows.

The disc-shaped support plate 1, from a non-ferromagnetic material, is positioned on top of a ferromagnetic surface and the upper side is sprayed with activator for an adhesive.

The holder 3, also from a non-ferromagnetic material such as aluminium, is positioned on top of the support plate 1 whereby the holder 3 by means of a disc-shaped protuberance 8, provided with a keyway 7, fits like a key in the central

hole of the support plate 1 which is provided with a fitting recess 2 for the keyway 7, such that a correct positioning is obtained.

- 5 The smaller magnets 10 are introduced in the half recesses 5 that are provided to that end and anchored, which only continue till half of the depth of the holder 3.

The larger permanent magnets 9 are provided with a layer of
10 adhesive on their lower side and each one is moved into the recesses 4 continuing through the whole thickness of the holder 3 provided to that end, whereby the permanent magnet 9 is attracted by the magnetisable platform, whereupon the support plate 1 is resting, and is shifted till against the
15 support plate 1, whereby the adhesion is initiated by the pressure of the magnetic attraction as a result of the contact of the activator and the adhesive.

This movement can only be successful if the orientation of
20 the introduced permanent magnet 9 is appropriate. If not, the permanent magnet 9 will be repelled by the small magnet 5 towards the upper surface, so as to prevent that permanent magnets 9 can be mounted in the rotor in the incorrect magnetic orientation.

25

The adhesive solely hardens at the contact surface between permanent magnet 9 and the support plate 1. The recesses, in which the permanent magnets fit into the holder, are locally widened at the bottom 6, such that any potential
30 excess of adhesive will find its way out, however without hardening. By introducing lamellae 13 in a further step,

10

the excess of adhesive will be distributed over the entire lamella 13, whereby it is prevented that the surface of the lamella 13 would not be perfectly joined to the surface of the support plate 1.

5

After all permanent magnets 9 have been introduced and the adhesive has hardened, the holder 3 is removed, and the method will be repeated once more for a second support plate 16.

10

The assembly of the rotor is continued by moving the first support plate 1 with fixed permanent magnets 9 along the rotor axis 11, whereby the keyway 12 on the rotor axis 11 allows the correct positioning by means of the
15 corresponding recess 2 in the first support plate 1.

Subsequently, all lamellae 13 are shifted on the axis, whereby the keyway 12 on the rotor axis 11 again enables a correct positioning of the lamellae 13.

20

Finally, the second support plate 16, provided with attached permanent magnets 17, is shifted along the rotor axis 11, however in the opposite sense, such that the attached permanent magnets 17 now point downwards.

25

In this way a rotor is obtained that is provided with permanent magnets 9 and 17 that are enclosed by a stack of lamellae 13, which stack is limited by an upper and a lower support plate, 1 and 16, that are compressed by an
30 attachment means, such as a circlip 18 or the like, whereby the lamellae 13 make good contact, but without being

connected to each other.

Obviously, the attachment means can also consist of a screw bolt or a heat-shrink tubing placed on the rotor axis, or
5 of another mechanic attachment means.

It is also obvious that the permanent magnets can also be attached to the support plates by other means than by adhesives.

10

Furthermore, it is obvious that the method is not limited to the interconnection of two identical support plates provided with permanent magnets, but that also just one, or more than two support plates with permanent magnets can be
15 used for the assembly of a rotor according to the invention.

The present invention is by no means limited to the embodiment as described by way of example and as shown in
20 the figures, however a method according to the invention for assembling a rotor with permanent magnets, a holder applied thereby and a rotor obtained by such a method, can be realized according to different variants without departing from the scope of the invention.

Claims.

1.- Method for assembling a rotor (18) with permanent
5 magnets (9 or 17), characterized in that it comprises the following steps of:

- introducing the magnets (9 or 17) into recesses (4) of a non-ferromagnetic holder (3);
- combining the holder (3) and the permanent magnets
10 (9 or 17) with a non-ferromagnetic support plate (1 or 16);
- attaching the permanent magnets (9 or 17) to the support plate (1 or 16); and
- removing the holder (3) and providing lamellae (13)
15 over the permanent magnets attached to the support plate (1 or 16).

2.- Method according to claim 1, characterized in that it comprises the following steps of:

- 20 - assembling two support plates (1 and 16) to which permanent magnets (9 and 17) are attached;
- introducing a rotor axis through a first support plate (1);
- stacking lamellae (13) around said rotor axis in
25 order to cover said magnets (9) completely;
- further stacking additional lamellae (13) which possibly comprise the magnets (17) of the second support plate (16) by shifting this second support plate (16) along the rotor axis (11) with its
30 permanent magnets (17) directed towards the first support plate (1); and

- attaching the two support plates (1 and 16) to the rotor axis (11).

3.- Method according to claim 2, characterized in that the attachment of the two support plates (1 and 16) is realized by axially compressing the two support plates (1 and 16) with the lamellae (13) situated in between, and by blocking the support plates (1 and 16) on the rotor axis (11) in axial direction.

10

4.- Method according to claim 3, characterized in that the axial compressing of the two support plates (1 and 16) on the rotor axis (11) is realized by way of a circlip (19), a snap ring, a bolt, a clamp ring or another clamping part.

15

5.- Method according to claim 1, characterized in that during the assembly the support plates (1 and 16), the lamellae (13), and the rotor axis (11) are aligned to each other around the rotation axis along the direction of rotation.

20

6.- Method according to claim 5, characterized in that the support plates (1 and 16) and the lamellae (13) are provided with a hole for a rotor axis (11), which hole is provided with a recess (2) which fits over a keyway (12) extending along the axial direction of the rotor axis (11), such that the support plates (1, 16), and the lamellae (13) are held in a non-rotatable and axially aligned position.

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7.- Method according to claim 1, characterized in that the attachment of the permanent magnets (9 or 17) on the non-

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ferromagnetic support plate (1 or 16) is realized by way of gluing.

8.- Method according to claim 7, characterized in that the
5 adhesive for attachment of the permanent magnets (9 or 17) is an adhesive which hardens under influence of applied pressure.

9.- Method according to claim 8, characterized in that
10 during assembling the support plate (1 or 16) is positioned on a ferromagnetic underground, in order to apply a pressure between the permanent magnets (9 or 17) and the support plate (1 or 16) through magnetic attraction of the permanent magnets (9 or 17) on the ferromagnetic
15 underground, during the attachment of the magnets to the support plate by gluing.

10.- Method according to claim 1, characterized in that the non-ferromagnetic holder (3) is provided with at least one
20 magnet which will, in case of an incorrect introduction of the permanent magnets (9 or 17) of the rotor (18) in the holder (3), repel or stop in axial direction the concerning permanent magnet.

25 11.- Method according to claim 10, characterized in that said magnet of the holder (3) is positioned opposite a recess in the holder (3) for a permanent magnet (9 or 17) of the rotor (18) and this at a distance from the entry of said recess (4) along which the permanent magnet (9 or 17)
30 of the rotor is introduced into the holder (3).

12.- Holder which can be applied in a method according to one of the preceding claims, characterized in that the holder (3) consists of a non-ferromagnetic material, and is provided with recesses for holding the permanent magnets (9 or 17) in a desired position with respect to the support plate (1 or 16) during attachment of the permanent magnets (9 and/or 17) to the support plates (1 and/or 16).

13.- Holder according to claim 12, characterized in that the holder (3) comprises additional recesses (5) for providing one or more magnets (10) that are able to prevent the incorrect magnetic orientation of the permanent magnets (9 or 17) when being inserted into the holder (3).

14.- Rotor realized by using a method according to one of the claims 1 tot 11.

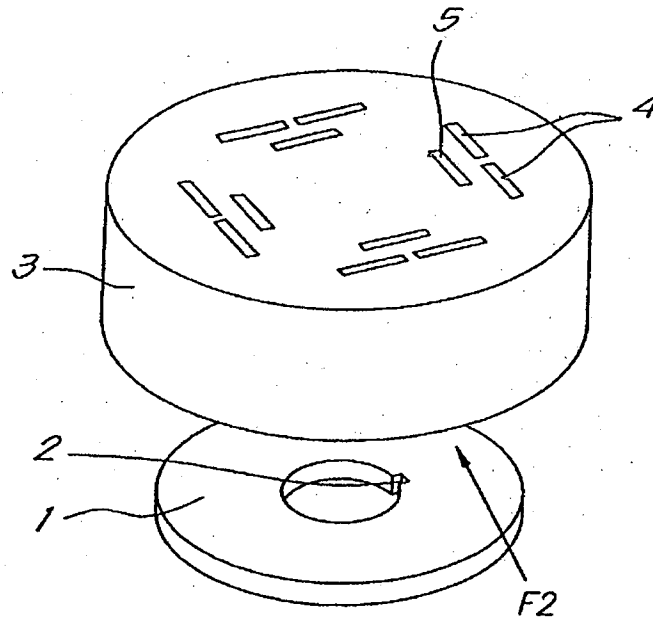


Fig. 1

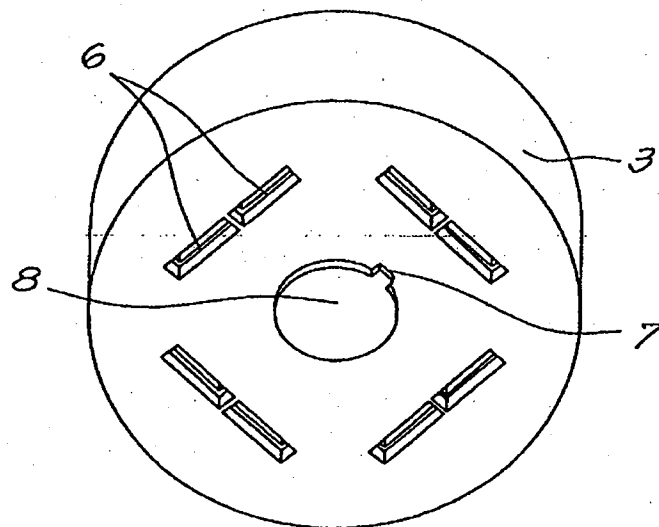


Fig. 2

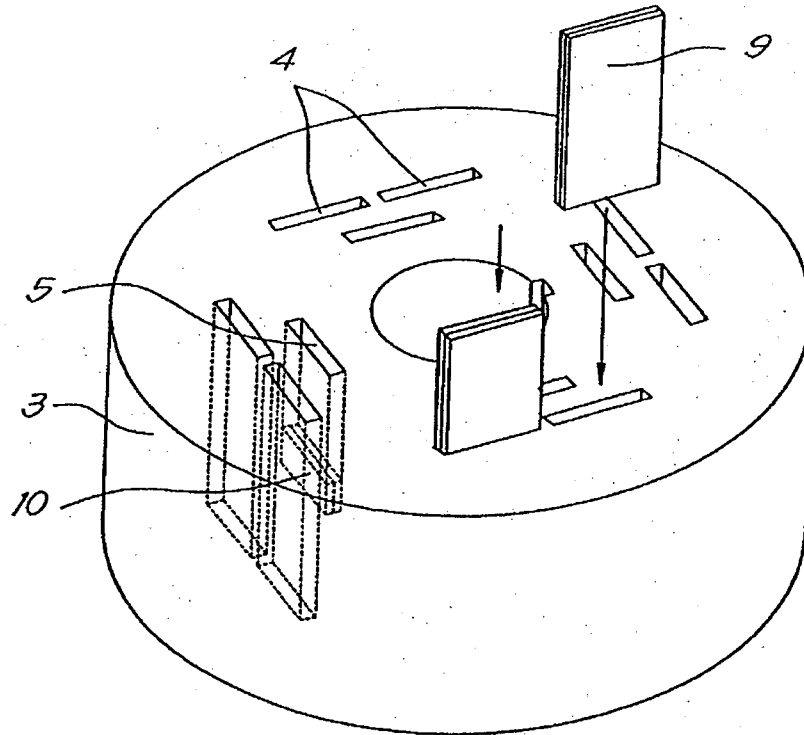


Fig. 3

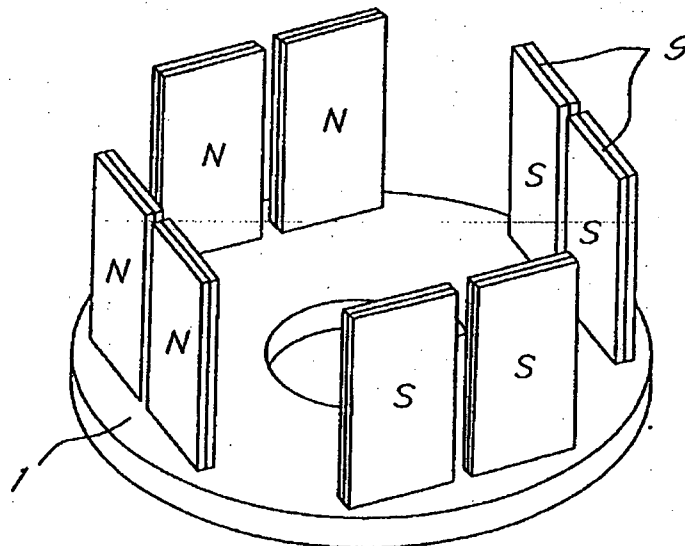


Fig. 4

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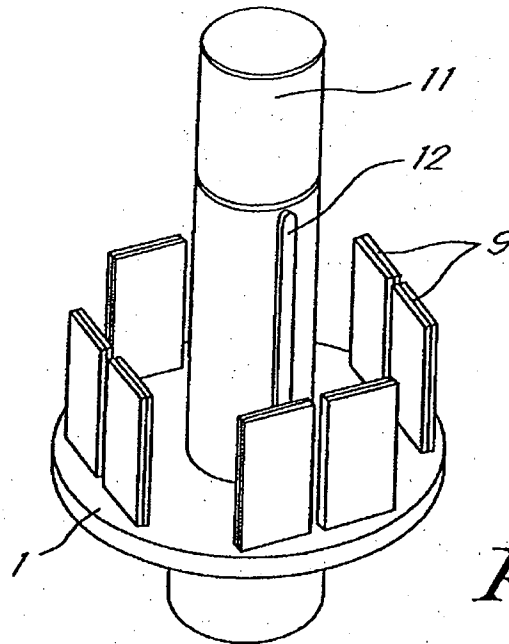


Fig. 5

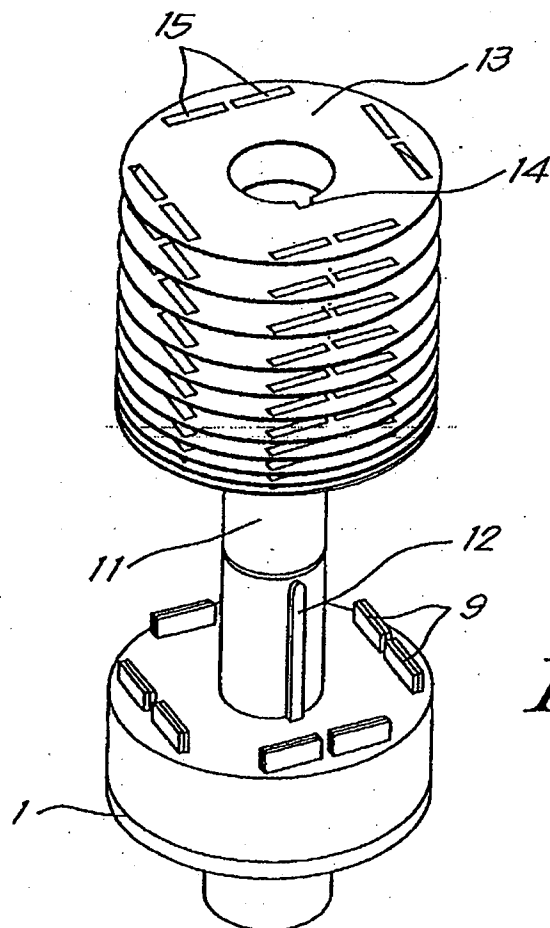


Fig. 6

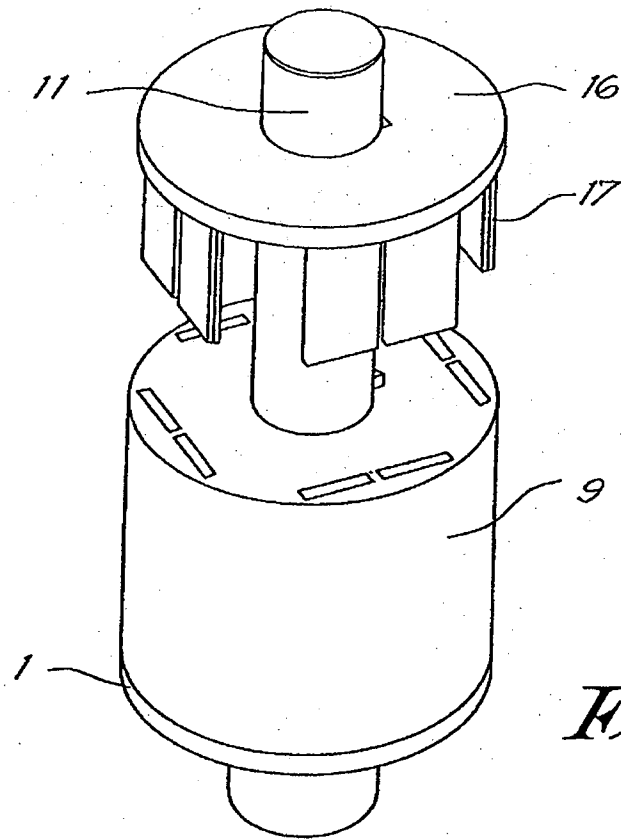


Fig. 7

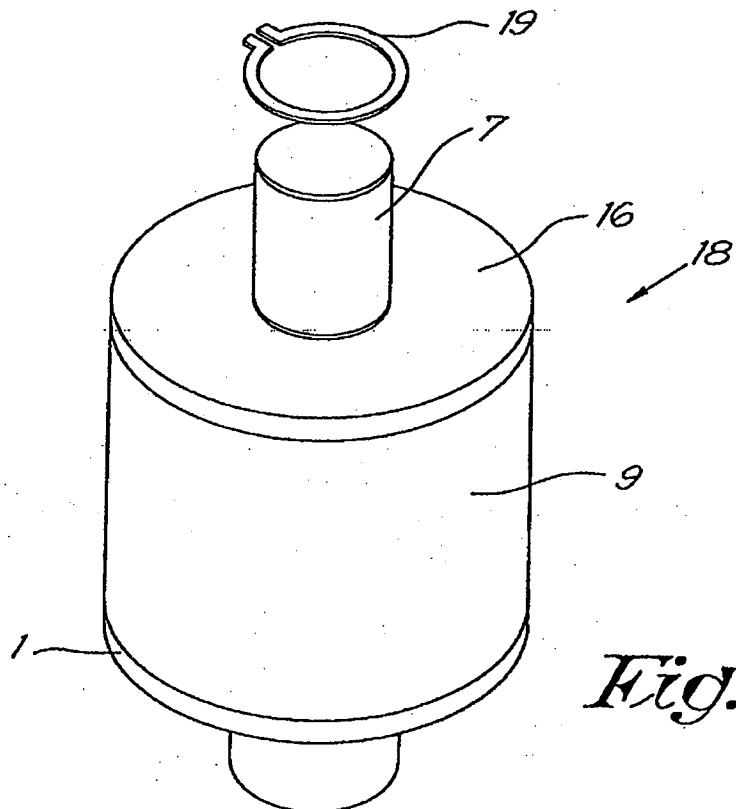


Fig. 8