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Description

This invention relates to an electrical lead terminating installation comprising a press driving an electrical terminal applicator and which may be incorporated in a lead making machine.

There is described in US-A-3,184,950, an electrical lead terminating installation comprising; a press having a press ram driven by a drive electric motor; an electrical terminal applicator having an applicator ram driven by the press ram, a terminal application die on the applicator ram, an anvil for cooperation with the die to apply a terminal to a lead presented between the die and the anvil during a cycle of operation of the rams and terminal strip feed means coordinated with the movement of the applicator ram to feed a strip of terminals incrementally towards the anvil to position a terminal thereof at a time on the anvil for application to said lead.

The press ram should be returned to its home position, that is to say to a fully raised position, with reasonable precision following each cycle of its operation, because the terminal strip feed means of the applicator is driven in coordination with the movement of the applicator ram so that if there is any significant overshoot or undershoot of the press ram with respect to its home position at the end of the cycle of operation of the ram, the terminal strip feed means will not correctly position a terminal on the anvil for the next cycle of operation. Another problem that is encountered in the case of an installation of the kind described above, is that when a strip of terminals is being manufactured by means of a usual progressive strip forming process, the forming press may comprise means for removing from the strip, any terminal which has been found by sensing means of the forming press, to be defective and for this reason, the strip of terminals to be fed to the terminal applicator may have had one or more terminals removed therefrom, so that no terminal may be present on the anvil during a particular cycle of the applicator ram. Thus, if the press is incorporated in a lead making machine, the machine may present a lead to the applicator when no terminal is present on its anvil so that the lead will be wasted.

An electrical lead terminating installation according to the present invention, is characterized by a control circuit arrangement comprising means for controlling the speed of the drive electric motor to stop the rams at least proximate to a home position thereof at the end of each cycle of operation thereof to ensure that the terminal strip feed means correctly positions said terminal on the anvil; and by means for sensing the absence of a terminal from the strip, at a position upstream of the anvil and for causing the rams and thus the terminal strip feed means to carry out an extra cycle of operation to place the next following terminal of the strip on the anvil.

Where the press is incorporated in a lead making machine having means for presenting a lead at a time between the die and the anvil of the applicator, the sensing means is arranged to cause the lead presenting means to dwell during said extra cycle of operation of the rams.

The sensing means may comprise a first sensor for sensing the absence of a terminal from a strip of terminals arranged in end to end strip form, and a second sensor for sensing the absence of a terminal from a strip of terminals arranged in side by side strip form, the control circuit arrangement having a control panel with a switch means for selectively bringing the sensors into operation according to the type of terminal strip with which the applicator is to be fed.

The control panel may be provided with switches for setting up the lead making machine for operation with terminal applicators of different kinds in accordance with a lead making program and may be arranged to signal the lead making machine to cause lead presenting means thereof to withdraw a terminated lead from between the die and the anvil of the applicator during a cycle of operation of the rams, before the press ram has completed that cycle, thereby to increase the speed of operation of the lead making machine.

The press may be provided with means driven by a further electric motor and actuated by a motor control circuit of the control circuit arrangement for shearing into fragments, carrier strips connecting the terminals of the strips each time a terminal has been severed therefrom by the applicator upon a lead having been terminated to the terminal. Such fragments are more easily disposed of than complete waste carrier strips.

The press will normally be provided with a rotary storage reel about which the strip of terminals is wound by a multiplicity of turns, the turns being separated from one another by means of a length of separating material. Since the force required to turn the storage reel varies as a function of the length of the terminal strip that remains thereon, so that the force with which the terminal strip feed means of the applicator must advance the strip, will similarly vary, the terminal may be incorrectly positioned on the anvil as a result of such variation. In order to avoid this disadvantage, an auxiliary electric motor is provided for taking up the separating material on a spool, in order to assist the strip feed means of the applicator in feeding the strip of terminals towards the anvil, the auxiliary motor being controlled by means of a first sensor on one side of a strip of terminals and which is actuable to start the auxiliary motor when part of the strip extending from the storage reel becomes taught and a second sensor which is actuable to stop the auxiliary motor when the said part of the strip sags to a predetermined extent. Thus the force with which the terminal strip feed means is required to drive the strip of

terminals will be substantially constant.

The control circuit arrangement may comprise a motor drive circuit for feeding the drive electric motor with drive current and may be arranged to disable the motor drive circuit should the press break down, a terminal strip fault occur, or should the temperature of the drive motor or the drive circuit exceed a predetermined threshold temperature.

For a better understanding of the invention and to show how it may be carried into effect reference will now be made by way of example to the accompanying drawings in which:

FIGURE 1 is an isometric view of an electronically controlled crimping press having a slide ram, which is shown in a fully raised, home position;

FIGURE 2 is an enlarged top plan view of the press shown mainly in section;

FIGURE 3 is an enlarged fragmentary view illustrating details of Figure 2;

FIGURE 4 is an enlarged fragmentary, sectional view of the press, showing the slide ram in an intermediate position;

FIGURE 5 is an enlarged isometric view of a bearing ring which is shown in Figures 2, 3 and 8; FIGURE 6 is an enlarged elevational view, shown partly in section, of the lower part of the press shown in Figure 1 and having fixed thereto a mounting plate for an electrical terminal applicator;

FIGURE 7 is an enlarged fragmentary side view of the upper part press;

FIGURE 8 is an enlarged front view, shown partly in section, of the upper part of the press;

FIGURE 9 is an enlarged side view, shown partly in section, of the slide ram;

FIGURE 10 is an enlarged front view of the slide ram;

FIGURE 11 is an isometric view of one example of an electrical terminal applicator for the press; FIGURE 12 is a block schematic diagram illustrating an electronic control circuit arrangement for the press and for a lead making machine;

FIGURE 13 is a graph illustrating the operation of the control circuit arrangement; and

FIGURE 14 is a diagram of an eccentric assembly of the press, associated with the graph of Figure 13.

The mechanical construction of the press will now be described with particular reference to Figures 1 to 10.

An electronically controlled crimping press 2, comprises, a cast metal frame 4 having a generally rectangular ram drive housing 6, a pedestal 8 formed integrally therewith, and an applicator mounting base 10 formed integrally with the pedestal 8, mounting lugs 12 projecting from opposite sides of the latter. There projects from the rear of the housing 4, as shown in Figure 7, a lug 14 supporting a vertical shaft

16 carrying a rotatable storage reel 18, part of which is shown in Figure 1, and about which is wound strip S (Figure 11) of electrical terminals T. Secured to one side of the housing 6, is a control panel 20, for use in operating an electronic control circuit, which is described below and which is shown in Figure 12. Arranged for vertical, reciprocating, sliding movement, in the forward part of the housing 6, is a slide ram 22, which is connected, as best seen in Figure 2, by way of a reduction gear box 24, to a three-phase, brushless, maintenance free, DC synchronous electric motor 26. The motor 26 is mounted in the housing 6 with considerable clearance from its side walls 28, in which are provided louvers 31 for augmented ventilation of the motor 26. There is connected to the output shaft of the motor 26, at the opposite end of the shaft to the gear box 24, an incremental encoder 30 fixed to the motor 26. The gear box 24 is secured to the side walls 28 by means of screws 88.

As shown in Figure 6, an applicator mounting plate 32 provided with applicator mounting lugs 34 is secured to the base 10 by means of screws 36. The slide ram 22 is provided at its lower end with an adaptor 40 for releasably securing the ram 22, as shown in Figure 7, to a complementary adaptor 42 of an electrical terminal applicator 44, an example of which is shown in Figure 11. The applicator shown in Figure 11 is an end feed applicator, comprising a ram housing 46 containing an applicator ram 47 terminating at its upper end in the adaptor 42 and at its lower end, in terminal crimping dies 48. The applicator 44 has a terminal strip feeding device 50 for the strip S, comprising a feed finger 52 arranged to be driven in reciprocating motion by means of a piston and cylinder unit 54 to drive the strip S of electrical terminals along a feed track 56 towards a terminal crimping anvil 58 on an applicator base 60 adapted to be secured to the plate 32 by means of the lugs 34. Such an applicator is described, for example in US-A-3,184,950.

The ram 22 is mounted to the side walls 28 of the housing 6 by way of roller or ball bearings 62 comprising outer tracks 64 secured to the side walls 28 by means of screws 66) as best seen in Figure 3, and inner tracks 6B secured to lugs 69 extending along vertical margins of the ram 22 by means of screws 70. The track 64 on one side wall 68 is laterally adjustable by means of grub screws 72, as will best be appreciated from Figure 8. As best seen in Figure 3, the ram 22 is mounted in the bearings 62 bisected by its transverse, or horizontal, central axis X-X so that it does not tend to tilt forwardly or rearwardly during its vertical, reciprocating, sliding movement on the bearings 62. As best seen in Figures 9 and 10, the ram 22 is formed with a substantially rectangular cross section, elongate guideway 74 opening into its rear face only, extending horizontally thereacross parallel to the axis X-X and which receives an eccentric assembly 76 for horizontal reciprocating movement as indicated by

the arrows A, in Figure 3, at right angles to the axis of rotation Y-Y of the shaft of the motor 26, which axis is at right angles to the axis X-X. The ram 22 is formed with channels 77 for oil for lubricating the guideway 74 and the bearings 62. The eccentric assembly 76, comprises a central stub shaft 78 which is mounted for rotation about its axis in a roller bearing ring 80 which is best seen in Figure 5 and which is in turn mounted in a circular cross section bearing block 82 in the form of a roller, which is best seen in Figure 8. The shaft 78, is arranged to be driven in rotation by reduction gearing (not shown) in the gearbox 24, and is mounted to an output shaft 79 thereof (as best seen in Figures 4 and 14), eccentrically with respect to said axis Y-Y which is also the axis of rotation of the output shaft 79.

As the shaft 78 is rotated by the motor 25 by way of the reduction gear box 24, assembly 76 drives the ram 22 through its vertical, reciprocating motion, the eccentricity of the assembly 76 being taken up by rolling movement thereof along the guideway 74; as will be apparent from a comparison of Figures 2 and 3, in which the ram 22 is in its fully raised, or home, position, with Figure 4 in which the ram 22 is in an intermediate position. Thus when the applicator 44 is mounted to the press 2, in the manner described above, the crimping die 48 of the applicator 44 is driven by the ram 22 in reciprocating motion to crimp terminals T to leads inserted between the die 48 and the anvil 58. The encoder 30, serves incrementally to measure the angular position of the shaft 78 and thus the vertical position of the ram 22, which is driven through one cycle of its reciprocating movement during each revolution of the shaft 78. The bearing block could be of rectangular, instead of circular, cross-section, arranged to slide, instead of roll, along the guideway 74.

It is important that the press ram 22 should be returned to its home position, that is to say to its fully raised position (0° in Figure 14), with reasonable precision following each cycle of its reciprocating movement because part, for example the feed finger, of an applicator on the plate 32, driven according to the vertical position the applicator ram will be incorrectly synchronized with the end positions of the applicator ram should the latter either overshoot, or undershoot with respect to its home position at the end of a crimping cycle. Also a significant overshoot of the ram 22, could cause the applicator ram to obstruct the insertion of a lead between the crimping die and the crimping anvil of the applicator, at the beginning of a crimping cycle. Proper return of the press ram 22 to its home position at the end of a cycle, is of enhanced importance where the applicator is part of a lead making machine having automatic lead insertion means which must be synchronized with the cycle of the applicator ram. Again, where the applicator is a stripper crimper, stripping means thereof must also be coor-

dated with the movement of the applicator ram.

A circuit arrangement 89, for controlling the press 2, so that the ram 22 returns, with the required accuracy, to its top dead center, or home, position at the end of each cycle of the press, and for controlling the operation of auxiliary means of an applicator of the press and associated parts of a lead making machine of which the press is part, will now be described with a particular reference to Figures 12 to 14.

As shown in Figure 12, the motor 26 which as mentioned above, is a maintenance free, brushless, three phase, synchronous, DC motor, comprises a permanent magnet 90, which is fixed to shaft 92 of the motor 26 and which is rotated by the field coils (not shown) thereof which are fed with phased DC pulses, PU, PV and PW, respectively, the speed of the motor 26 being a function of the pulse frequency. The magnet 90 cooperates with Hall effect sensors 94 each of which produces a pulse train PX, PY and PZ, respectively, the pulse frequency of which is a function of the speed rotation of the shaft 92, that is to say the motor speed. Three inlets U', V' and W', of the motor 26 are supplied with the pulses PU, PV and PW, respectively by a motor drive pulse generator 96 fed with direct current via a rectifying and smoothing circuit 98 connected via a ganged switch 100 to an alternating current filter 101 which is in turn connected to AC mains voltage by a further ganged switch 102. The motor drive pulse generator 96 is controlled via lines 103 and 105 by a motor control digital logic circuit 104, by way of an interface circuit 106, to vary the frequency of, or reverse the polarity of, the pulses PU, PV and PW or to supply a continuous pulse to a phase of the motor 26 to hold it stationary. The circuit 104 is connected to a main computer 108 by way of a first optoisolator 110, the computer 108 having entered therein a desired motor speed program 112. The computer 108 is also connected to a lead making machine 114 by way of a second optoisolator 116, in which machine the press 2 is incorporated. The computer 108 is supplied from the AC mains by way of a rectifier and voltage changer 118 and is also connected to the control panel 20 by way of an array of lines 120.

Both the sensors 94, and the incremental encoder 30 are connected to the motor control circuit 104 by way of lines 105 and 107, respectively. The circuit 104 comprises a comparator 109 which compares the outputs on the lines 105 and 107 which represent the speed of the motor 26 and the angular position of its shaft 92, respectively, with the desired motor speed registered in the program 112, the speed of the motor 26 being controlled by the circuit 104 by way of the pulse generator 96 upon the basis of such comparison. In theory, the motor 26 could be brought to a halt when the ram 22 is in its top dead center, or home position, only by comparison of the output of the sensors 94 with the program 112, but this could not be achieved with reasonable accuracy in practice by

means of a circuit 104 of a kind which can be produced commercially at a reasonable cost. In the present case, however, the speed of the motor 26 as controlled upon the basis of a comparison between the program 112 and the frequency of the pulses PX, PY and PZ, tends to hunt, that is to say it becomes unstable, as the ram 22 is moved towards its home position. At this stage however, the signals supplied by the incremental encoder 30 are effective in the circuit 104 to supply control signals to the pulse generator 96 continually to return the motor 26 to the desired speed stipulated by the program 112. Figure 13 is a graph in which the ordinate represents the motor speed VL and the abscissa, the angular position AP of the shaft 78. It will be seen from the graph that as the ram 22 descends towards the fully depressed position, that is to say the position at which the applicator ram crimps the terminal to the lead, the speed of the motor 26 rises linearly up to a point proximate to the 180° position of the shaft 78 and falls slightly as the crimping operation is carried out around that position. Thereafter the motor speed rises slightly and then falls again, as the shaft 78 moves towards its home position. As shown in Figure 13, the encoder 30 serves to linearise the speed of the motor 26 between approximately the 200° to 300° angular positions of the shaft 78. Lines 123 connecting the program 112 to the circuit 104, by way of the optoisolator 110 continually feed into the circuit 104, the desired motor speed criteria for different angular positions of the shaft 78.

The control panel 20 is provided with a bank 121 of touch screens 122, and an indicator screen 124 on which the computer causes to be displayed operating information for example that the press is ready for use or that there is a fault in a particular part of the system.

The motor 26 is controlled throughout its rotation in order to halt the ram 22 when it is at least approximately in its home position, at which time the circuit 104 signals the pulse generator 96 to reverse the polarity of the pulses PU, PV and PW, no specific brake means for the motor 26 being needed. Respective ones of the touch screens 122 may be actuable by the operator to cause the computer 108 to signal the pulse generator 96 by way of the control circuit 104 to the following ends, for example: to start the motor 26; to stop the motor 26 by momentarily reversing the current supply thereto; to hold the motor 26 in its stopped position by applying a continuous current to one of its phases; to reverse the motor 26 to clear a jammed terminal; or to cause the motor 26 to crawl forwardly and rearwardly, by applying its feed pulses at reduced frequency in the appropriate senses, when the press is being set up.

The sense of rotation, of the motor 26 is controlled by way of lines 125 between the computer 108 and the circuit 104, the motor 26 is held in its stopped position by signals applied by the computer 108 to lines

127 between the computer 108 and the circuit 104 and the motor 26 is controlled to crawl by way of lines 129 between the computer 108 and the circuit 104.

A clock pulse line 134 is provided between the computer 108 and the control circuit 104 for the transmission of pulses for synchronizing the computer 108 therewith so that the pulse generator 96 is signalled to control the motor 26, only with a rapidity which is compatible with the following capacity of the motor 26. The motor 26 is provided with a temperature sensor 132, connected via lines 134 to the computer 108 to cause it to actuate the circuit 104 and hence the pulse generator 96, stop the motor 26 when its temperature exceeds a predetermined threshold. The pulse generator 96 also has a temperature sensor 136 connected to the line 134 so that the motor 26 is stopped should the generator 96 become overheated.

When a strip of terminals is being manufactured, by means of a usual progressive strip forming process, the forming process may comprise means for removing from the strip, any terminal which has been found by sensing means of the forming press to be defective. For this reason, the strip of terminals on the reel 18 of the press 2 may have had one or more terminals removed therefrom, so that no terminal may be present on the anvil during a particular cycle of the applicator ram. If the lead making machine presents a lead to the applicator when no terminal is present on its anvil, then that lead will be wasted. For this reason, the circuit arrangement 89 is provided with missing terminal sensors 140 and 142 for end strip terminals and side strip terminals respectively, which sensors are connected to the computer 108 by lines 144 and 146 respectively, by way of the optoisolator 110. If a missing terminal is detected upstream of the anvil, the main computer 108 signals the lead presenting means of the lead making machine 114, via lines 148 or 150, as the case may be, and the optoisolator 116, to dwell during one cycle of operation so that no lead is presented to the applicator when there is no terminal on its anvil. The computer 108 also signals the press 2, to carry out an extra cycle during the dwell period of the lead presenting means, by way of lines 152, the optoisolator 110, the circuit 104 and the pulse generator 96, so that the feed finger of the applicator places the next following terminal of the strip on the anvil at the proper time.

The force required to turn the reel 18 of the press 2, varies as a function of the length of the terminal strip T that remains thereon, so that the force with which the feed finger of the applicator must advance the strip will similarly vary, whereby a terminal may be incorrectly positioned on the anvil, as a result of such variation. To avoid this disadvantage, the applicator is provided with an electric motor 154 arranged to rotate a spool 156 to take up a length of interleaving paper 158 with which the turns of a strip of terminals

on a reel are customary separated. As the length of paper is taken up, the part of the strip of terminals extending from the reel 18 towards the applicator is caused to sag slightly thereby to relieve the force that the feed finger needs to exert against the strip to advance it towards the anvil of the applicator. Strip sensors 160 and 162 are provided, for sensing the position of said part of the strip of terminals in order to avoid over-winding the paper length by the motor 156. When the feed finger of the applicator has taken up the terminal strip S to an extent that said part thereof becomes taut said part thereof engages the sensor 160, which actuates a relay 164 to close a switch 166 to connect the motor 154 to the main supply, via lines 168. The motor accordingly starts and rotates the reel 18 by pulling on the paper length 158 until said part of the terminal strip sags to an extent to activate the sensor 162 which actuates the relay 164 to open the switch 166 to stop the motor 156.

When the terminals T are arranged in side or ladder strip form as shown in Figure 11, the terminals T of the strip S are connected to each other by carrier strip CS, from which the applicator shears a terminal T during each crimping operation. The carrier strips CS from which the terminals are shared are waste, and shear blades 170, driven by an electric motor 172, are provided for shearing the waste strips CS into easily disposable fragments F. If, however, the terminals are in end to end strip form, the applicator only shears out slugs connecting the terminals of the strip, so that the blades 70 are not needed. One of the touch screens 122 is therefore actuable to instruct the computer 108 to bring the motor 172 into operation if, and when, it is needed, by way of the optoisolator 110, and the motor control circuit 104 to which the motor 172 is connected by way of lines 174.

Others of the touch screens 122 are actuable to control parts of, or peripheral equipment of, the lead making machine 114, in light of a particular lead making program, by way of the computer 108, lines 176 and the optoisolator 116, for example to allow for the type of applicator to be used, for example a stripper crimper, or an end feed or a side feed applicator.

At least one set of lines 178 is provided, running from the lead making machine 114, by way of the optoisolator 116, the computer 108, the optoisolator 110, a further optoisolator 180 and the interface circuit 106, to the pulse generator 96 for disabling the pulse generator 96 in the event of a fault, for example a terminal strip fault, or press breakdown.

A key operated shut-down switch 182 is connected to the optoisolator 180 by a line 184, and to the computer 108 via the optoisolator 110, by lines 186, for disabling both the pulse generator 96 and the computer 108 whilst leaving its program 112 intact, however. A guard operated switch 188, connected to the motor control circuit 104 by way of a line 190 is provided for opening the switch 100 to cut-off power to

the pulse generator 96, should a guard (not shown) of the press, be opened.

The control circuit 104 is arranged to signal the computer 108 via the optoisolator 116, by way of lines 192 when the eccentric assembly 76 has reached a point P1 (Figure 14) spaced angularly from the home position, 0°, of the ram 22, for example by 90°, to cause the computer 108, in turn to signal the lead making machine 114, by way of the optoisolator 116 and lines 194 to cause the lead presenting means thereof to withdraw a terminated lead from between the dies and anvil of the applicator, thereby to increase the speed of operation of the lead making machine 114, by the length of a sector S1 of the press cycle, that is to say by as much as a quarter.

Claims

1. An electrical lead terminating installation comprising; a press (2) having a press ram (22) driven by a drive electric motor (26); and an electrical terminal applicator (44) having an applicator ram (47) driven by the press ram (22), a terminal application die (48) on the applicator ram (47), an anvil (58) for cooperation with the die (48) to apply a terminal (T) to a lead presented between the die (48) and the anvil (58) during a cycle of operation of the rams (22 and 47) and terminal strip feed means (50,52) coordinated with the movement of the applicator ram (47) to feed a strip (S) of terminals (T) incrementally towards the anvil (58) to position a terminal (T) thereof, at a time, on the anvil (58) for application to said lead; characterized by a control circuit arrangement (89) comprising means (96,104,110) for controlling the speed of the electric motor (26) to stop the rams (22 and 47) at least proximate to a home position (0°) thereof at the end of each cycle of operation thereof to ensure that the terminal strip feed means (50,52) correctly positions said terminal on the anvil (58); and means (108,140,142) for sensing the absence of a terminal (T) from the strip (S), at a position upstream of the anvil (58) and for causing the rams (22 and 47) and thus the terminal strip feed means (50,52) to carry out an extra cycle of operation to place the next following terminal (T) of the strip (S) on the anvil (58).
2. An installation according to claim 1, characterized in that the press (2) is incorporated in a lead making machine (114) having means for presenting a lead at a time between the die (48) and the anvil (58) of the applicator (44), the sensing means (108,140,142) being arranged to cause the lead presenting means to dwell during said extra cycle of operation of the rams (22 and 47).

3. An installation according to claim 1 or 2, characterized in that the sensing means comprises a first sensor (140) for sensing the absence of a terminal (T) from a strip of end strip terminals, and a second sensor (142) for sensing the absence of a terminal (T) from a strip (S) of side strip terminals (T), the control circuit arrangement (89) having a control panel with switch means (122) for selectively bringing said sensors (140 and 142) into operation. 5

4. An installation according to claim 1, characterized in that the press (2) is incorporated in a lead making machine (114), the control circuit arrangement (89) having a control panel (20) provided with switches (122) for setting up the lead making machine (114) for operation with terminal applicators of different kinds, in accordance with a lead making program (112). 10

5. An installation according to claim 1 characterized in that the press (2) is incorporated in a lead making machine (114) having means for presenting a lead, at a time, between the die (48) and the anvil (58) of the applicator (44), and in that the control circuit arrangement (89) is arranged to signal the lead making machine (114) to cause the lead presenting means thereof to withdraw a terminated lead from between the die (48) and the anvil (58) of the applicator (44) during a cycle of operation of the press ram (22) and before it has completed that cycle of operation. 15

6. An installation according to any one of the preceding claims, characterized in that the press (2) is provided with means (170) driven by a further electric motor (172) actuated by a motor control circuit (104) of the control circuit arrangement (89) for sheering into fragments, carrier strips (CS) connecting the terminals (T) of the strip (S), each time a terminal (T) has been severed therefrom by the applicator (44) upon a lead having been terminated to the terminal (T). 20

7. An installation according to any one of the preceding claims, characterized in that the press (2) is provided with a rotary storage reel (18) about which the strip (S) of terminals (T) is wound by a multiplicity of turns separated from each other by means of a length of separating material (158), the press (22) being provided with an auxiliary electric motor (154) arranged to take up said separating material (158) on a spool (156) in order to assist the strip feed means (50,52) of the applicator (44) in feeding the strip (S) of terminals (T) towards the anvil (58), the auxiliary motor (154) being controlled by means of a first sensor (160) which is actuable to start the auxiliary motor 25

(154) when part of the strip (S) extending from the storage reel (18) becomes taught and a second sensor (162) which is actuable to stop the auxiliary motor (154) when said part of the strip (S) sags to a predetermined extent.

8. An installation according to any one of the preceding claims, characterized in that the control circuit arrangement (89) comprises a motor drive circuit (96) for feeding the drive motor (26) with drive current and is arranged to disable the motor drive circuit (96) should the press (2) break down, a terminal strip fault occur, or should the temperature of the drive motor (26) or a drive circuit (96) therefor exceed a predetermined threshold temperature. 30

Patentansprüche

1. Einrichtung zur Fertigung von elektrischen Leitern mit einer Presse (2), die einen Pressenstempel (22) hat, der durch einen elektrischen Antriebsmotor (26) angetrieben ist, und mit einer Anbringungsanordnung (44) für elektrische Anschlüsse, die einen Anbringungsstempel (47) hat, der durch den Pressenstempel (22) angetrieben ist, mit einer Anschluß-Anbringungsform oder einem Anschluß-Anbringungsgegenstand (48) an dem Anbringungsstempel (47), einem Amboß (58) zum Zusammenwirken mit der Form oder dem Gegenstand (48), um einen Anschluß (T) an einen Leiter anzubringen, der zwischen dem Gegenstand (48) und dem Amboß (58) während eines Betriebszyklus der Stempel (22 und 47) dargeboten wird, und mit Anschlußstreifen-Zuführeinrichtungen (50, 52), die mit der Bewegung des Anbringungsstempels (47) koordiniert sind, um einen Streifen (S) von Anschlüssen (T) schrittweise dem Amboß (58) zuzuführen, um einen seiner Anschlüsse (T) zu einer Zeit auf dem Amboß (58) zum Anbringen an dem Leiter zu positionieren, **gekennzeichnet** durch eine Steuerstromkreisanordnung (89), die Mittel (96, 104, 110) zum Steuern der Geschwindigkeit des elektrischen Motors (26) aufweist, um die Stempel (22 und 47) wenigstens in der Nähe von deren Ruhestellung (0°) am Ende jedes ihrer Betriebszyklen anzuhalten, um sicherzustellen, daß die Anschlußstreifen-Zuführeinrichtung (50, 52) den Anschluß korrekt auf dem Amboß (58) positioniert, sowie durch Mittel (108, 140, 142) zum Feststellen des Fehlens eines Anschlusses (T) in dem Streifen (S) an einer Stellung stromaufwärts von dem Amboß (58) und zum Veranlassen der Stempel (22 und 47) und somit der Anschlußstreifen-Zuführeinrichtung (50, 52), einen zusätzlichen Betriebszyklus durchzuführen, um

den nächstfolgenden Anschluß (T) des Streifens (S) auf dem Amboß (58) zu plazieren.

2. Einrichtung nach Anspruch 1, **dadurch gekennzeichnet**, daß die Presse (2) in einer Leiterherstellungsmaschine (114) eingebaut ist, die Einrichtungen zum Darbieten eines Leiters zu einer Zeit zwischen der Form oder dem Gesenk (48) und dem Amboß (58) der Anbringungs-
vorrichtung (44) hat, wobei die Fühlmittel (108, 140, 142) so angeordnet sind, daß sie die Leiterdarbietungsmittel veranlassen, während des zusätzlichen Betriebszyklus der Stempel (22 und 47) zu ruhen. 5
3. Einrichtung nach Anspruch 1 oder 2, **dadurch gekennzeichnet**, daß die Fühlmittel einen ersten Fühler (140) zum Feststellen des Fehlens eines Anschlusses (T) von einem Streifen von Streifen-
endanschlüssen und einen zweiten Fühler (142) zum Feststellen des Fehlens eines Anschlusses (T) von einem Streifen (S) von Streifenseitenanschlüssen (T) haben, wobei die Steuerstromkreisanordnung (89) eine Steuertafel mit Schaltmitteln (122) hat, um die Fühler (140 und 142) wahlweise zur Tätigkeit zu bringen. 10
4. Einrichtung nach Anspruch 1, **dadurch gekennzeichnet**, daß die Presse (2) in einer Leiterherstellungsmaschine (114) eingebaut ist, wobei die Steuerstromkreisanordnung (89) eine Steuertafel (20) hat, die mit Schaltern (122) versehen ist, um die Leiterherstellungsmaschine (114) zum Betrieb mit Anschlußanbringungs-
vorrichtungen unterschiedlicher Arten gemäß einem Leiterherstellungsprogramm (112) einzustellen. 15
5. Einrichtung nach Anspruch 1, **dadurch gekennzeichnet**, daß die Presse (2) in einer Leiterherstellungsmaschine (114) eingebaut ist, die Einrichtungen zum Darbieten eines Leiters zu einer Zeit zwischen der Form oder dem Gesenk (48) und dem Amboß (58) der Anbringungs-
vorrichtung (44) hat, und daß die Steuerstromkreisanordnung (89) so ausgebildet ist, daß sie der Leiterherstellungsmaschine (114) signalisiert, ihre Leiterdarbietungsmittel zu veranlassen, einen angeschlossenen Leiter aus dem Raum zwischen der Form oder dem Gesenk (48) und dem Amboß (58) der Anbringungs-
vorrichtung (44) während eines Betriebszyklus des Pressenstempels (22) und bevor dieser diesen Betriebszyklus vervollständigt hat, zurückzuziehen. 20
6. Einrichtung nach einem der vorhergehenden Ansprüche, **dadurch gekennzeichnet**, daß die Presse (2) mit Einrichtungen (170) versehen ist, 25

die durch einen weiteren elektrischen Motor (172) angetrieben sind, der durch einen Motorsteuerkreis (104) der Steuerstromkreisanordnung (89) aktiviert wird, um Trägerstreifen (CS), die die Anschlüsse (T) des Streifens (S) verbinden, in Bruchstücke zu zerschneiden, jedesmal wenn ein Anschluß (T) davon durch die Anbringungs-
vorrichtung (44) abgetrennt worden ist, nachdem ein Leiter an dem Anschluß (T) angeschlossen worden ist.

7. Einrichtung nach einem der vorhergehenden Ansprüche, **dadurch gekennzeichnet**, daß die Presse (2) mit einer drehbaren Vorratsrolle (18) versehen ist, um die der Streifen (S) von Anschlüssen (T) in einer Vielzahl von Windungen herumgewickelt ist, die voneinander mittels einer Länge von Trennmaterial (158) getrennt sind, wobei die Presse (22) mit einem elektrischen Hilfsmotor (154) versehen ist, der so angeordnet ist, daß das Trennmaterial (158) auf einer Spule (156) aufgenommen wird, um die Streifenzuführ-
einrichtung (50, 52) der Anbringungs-
vorrichtung (44) beim Zuführen des Streifens (S) von Anschlüssen (T) zu dem Amboß (58) zu unterstützen, wobei der Hilfsmotor (154) mittels eines ersten Fühlers (160) gesteuert ist, der zum Starten des Hilfsmotors (154) betätigbar ist, wenn ein Teil des Streifens (S), der sich von der Vorratsrolle (18) erstreckt, straff wird, sowie mittels eines zweiten Fühlers (162), der betätigbar ist, um den Hilfsmotor (154) anzuhalten, wenn der Teil des Streifens (S) um einen vorbestimmten Betrag durchhängt. 30
8. Einrichtung nach einem der vorhergehenden Ansprüche, **dadurch gekennzeichnet**, daß die Steuerstromkreisanordnung (89) einen Motorantriebskreis (96) zum Speisen des Antriebsmotors (26) mit Antriebsstrom aufweist und so ausgebildet ist, daß sie den Motorantriebskreis (96) abschaltet, wenn die Presse (2) zum Stillstand kommen sollte, ein Anschlußstreifenfehler auftreten sollte oder die Temperatur des Antriebsmotors (26) oder eines Antriebskreises (96) dafür eine vorbestimmte Schwellentemperatur überschreiten sollte. 35

Revendications

1. Une installation de montage de bornes de terminaison sur des conducteurs électriques, comprenant : une presse (2) ayant un coulisseau de presse (22) entraîné par un moteur électrique d'entraînement (26); et un applicateur de borne électrique (44) ayant un coulisseau d'applicateur (47) entraîné par le coulisseau de presse (22), un 40

- poinçon d'application de borne (48) sur le coulisseau d'applicateur (47), un berceau (58) destiné à coopérer avec le poinçon (48) pour appliquer une borne (T) sur un conducteur qui est présenté entre le poinçon (48) et le berceau (58) pendant un cycle de fonctionnement des coulisseaux (22 et 47) et des moyens d'avance de bande de bornes (50, 52) coordonnés avec le mouvement du coulisseau d'applicateur (47) pour faire avancer de façon incrémentielle une bande (S) de bornes (T) vers le berceau (58), de façon à positionner une borne (T) à la fois de la bande sur le berceau (58) pour l'application au conducteur; caractérisée par une structure de circuit de commande (89) comprenant des moyens (96, 104, 110) pour commander la vitesse du moteur électrique (26) de façon à arrêter les coulisseaux (22 et 47) au moins à proximité d'une position de repos (0°) de ceux-ci, à la fin de chacun de leurs cycles de fonctionnement, pour garantir que les moyens d'avance de bande de bornes (50, 52) positionnent correctement la borne sur le berceau (58); et des moyens (108, 140, 142) pour détecter l'absence d'une borne (T) dans la bande (S), à une position située en amont du berceau (58) et pour faire en sorte que les coulisseaux (22 et 47) et donc les moyens d'avance de bande de bornes (50, 52) accomplissent un cycle de fonctionnement supplémentaire, pour placer sur le berceau (58) la borne (T) immédiatement suivante de la bande (S).
2. Une installation selon la revendication 1, caractérisée en ce que la presse (2) est incorporée dans une machine de fabrication de conducteurs (114) comportant des moyens pour présenter un conducteur à la fois entre le poinçon (48) et le berceau (58) de l'applicateur (44), les moyens de détection (108, 140, 142) étant conçus pour faire en sorte que les moyens de présentation de conducteur restent arrêtés pendant le cycle de fonctionnement supplémentaire précité des coulisseaux (22 et 47).
 3. Une installation selon la revendication 1 ou 2, caractérisée en ce que les moyens de détection comprennent un premier capteur (140) pour détecter l'absence d'une borne (T) dans une bande de bornes disposées bout à bout sur la bande, et un second capteur (142) pour détecter l'absence d'une borne (T) dans une bande (S) de bornes (T) disposées côte à côte sur la bande, la structure de circuit de commande (89) comportant un panneau de commande avec des moyens de commutation (122) pour mettre sélectivement les capteurs (140 et 142) en fonction.
 4. Une installation selon la revendication 1, caractérisée en ce que la presse (2) est incorporée dans une machine de fabrication de conducteurs (114), la structure de circuit de commande (89) comportant un panneau de commande (20) qui est muni d'interrupteurs (122) pour conditionner la machine de fabrication de conducteurs (114) pour le fonctionnement avec des applicateurs de bornes de différentes sortes, conformément à un programme de fabrication de conducteurs (112).
 5. Une installation selon la revendication 1, caractérisée en ce que la presse (2) est incorporée dans une machine de fabrication de conducteurs (114) comportant des moyens pour présenter un conducteur à la fois entre le poinçon (48) et le berceau (58) de l'applicateur (44), et en ce que la structure de circuit de commande (89) est conçue pour commander à la machine de fabrication de conducteurs (114) de faire en sorte que ses moyens de présentation de conducteur retirent de la position située entre le poinçon (48) et le berceau (58) de l'applicateur (44), un conducteur sur lequel une borne a été montée, pendant un cycle de fonctionnement du coulisseau de presse (22), et avant que ce dernier n'ait achevé ce cycle de fonctionnement.
 6. Une installation selon l'une quelconque des revendications précédentes, caractérisée en ce que la presse (2) est équipée de moyens (170), entraînés par un moteur électrique supplémentaire (172) qui est actionné par un circuit de commande de moteur (104) de la structure de circuit de commande (89), pour cisailier en fragments des bandes de support (CS) qui relient les bornes (T) de la bande (S), chaque fois qu'une borne (T) a été sectionnée à partir de la bande par l'applicateur (44), au moment où la borne (T) a été montée sur un conducteur.
 7. Une installation selon l'une quelconque des revendications précédentes, caractérisée en ce que la presse (2) est munie d'une bobine de stockage tournante (18) autour de laquelle la bande (S) de bornes (T) est enroulée en un grand nombre de spires qui sont mutuellement séparées par une longueur de matière de séparation (158), la presse (22) étant munie d'un moteur électrique auxiliaire (154) qui est conçu pour enrouler la matière de séparation (158) sur une bobine (156), afin d'assister les moyens d'avance de bande (50, 52) de l'applicateur (44) dans l'opération d'avance de la bande (S) de bornes (T) vers le berceau (58), le moteur auxiliaire (154) étant commandé au moyen d'un premier capteur (160) qui peut être actionné de façon à faire démarrer le moteur auxiliaire (154) lorsqu'une partie de la bande (S) qui s'étend à partir de la bobine

de stockage (18) devient tendue, et d'un second capteur (162) qui peut être actionné pour arrêter le moteur auxiliaire (154) lorsque la partie précitée de la bande (S) présente une flèche d'une valeur prédéterminée.

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8. Une installation selon l'une quelconque des revendications précédentes, caractérisée en ce que la structure de circuit de commande (89) comprend un circuit d'attaque de moteur (96) qui est destiné à appliquer un courant d'attaque au moteur d'entraînement (26) et elle est conçue pour désactiver le circuit d'attaque de moteur (96) en cas de panne de la presse (2), en cas d'apparition d'un défaut dans la bande de bornes, ou si la température du moteur d'entraînement (26) ou d'un circuit d'attaque (96) de celui-ci dépasse une température de seuil prédéterminée.

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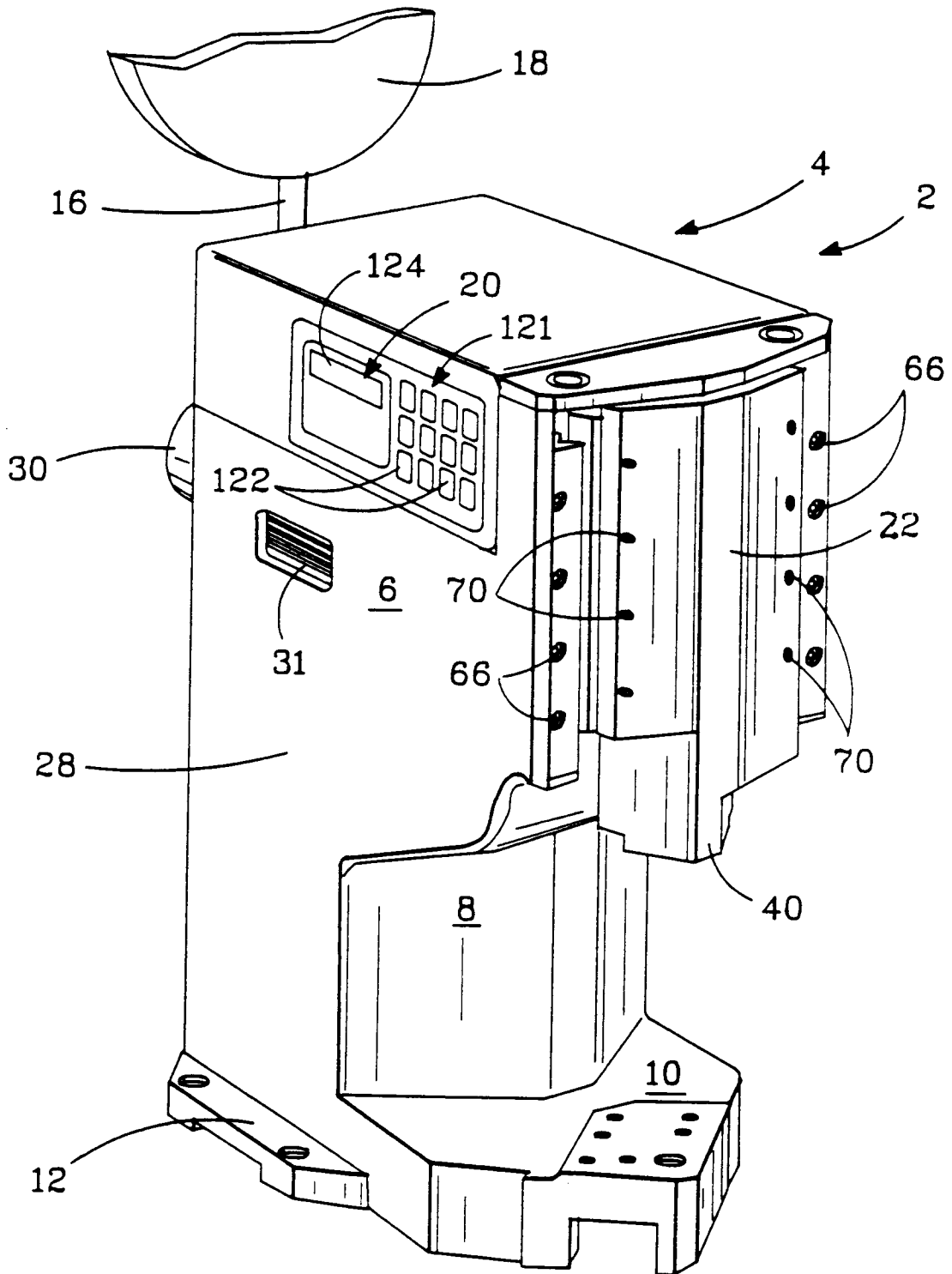
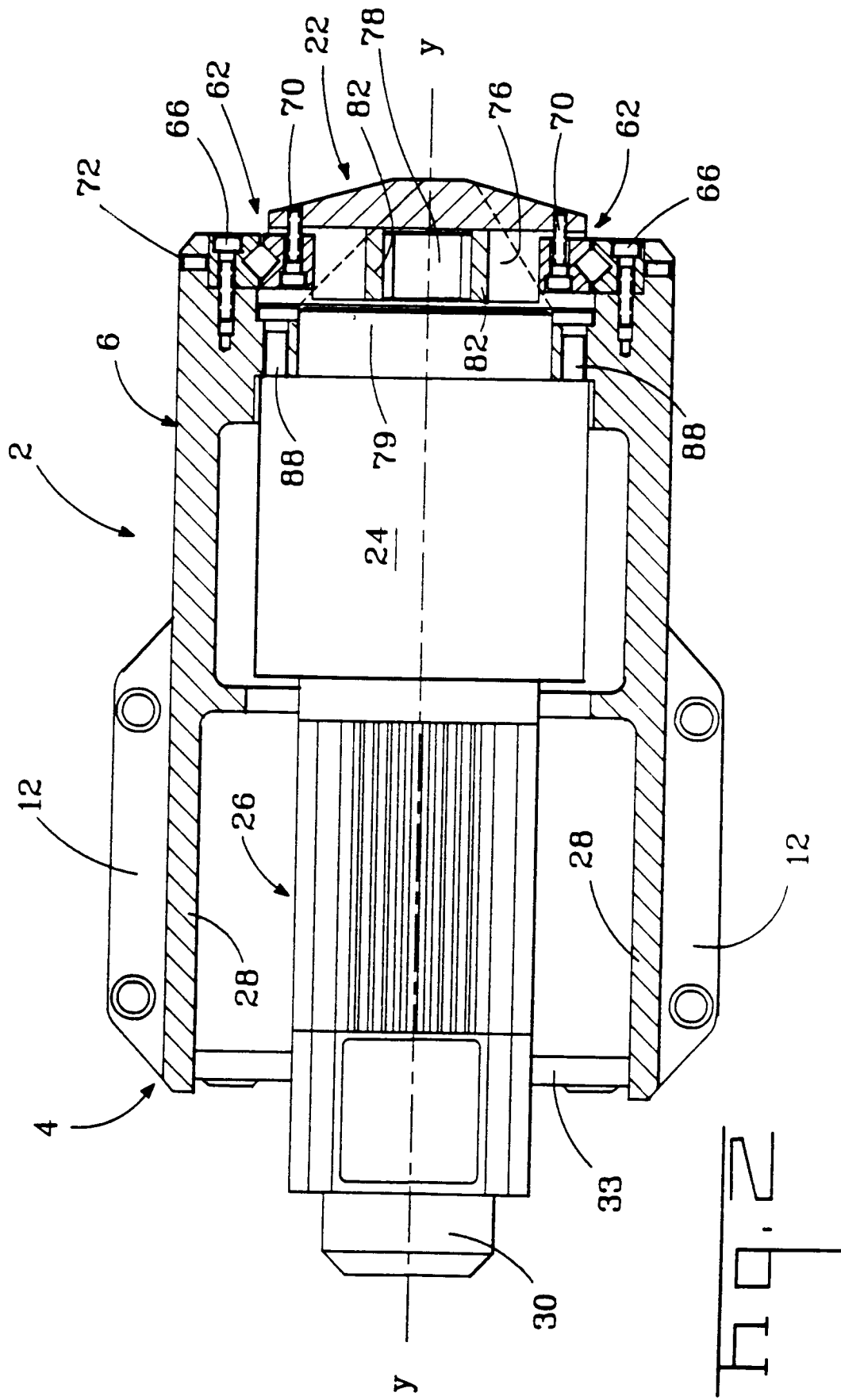


Fig. 1



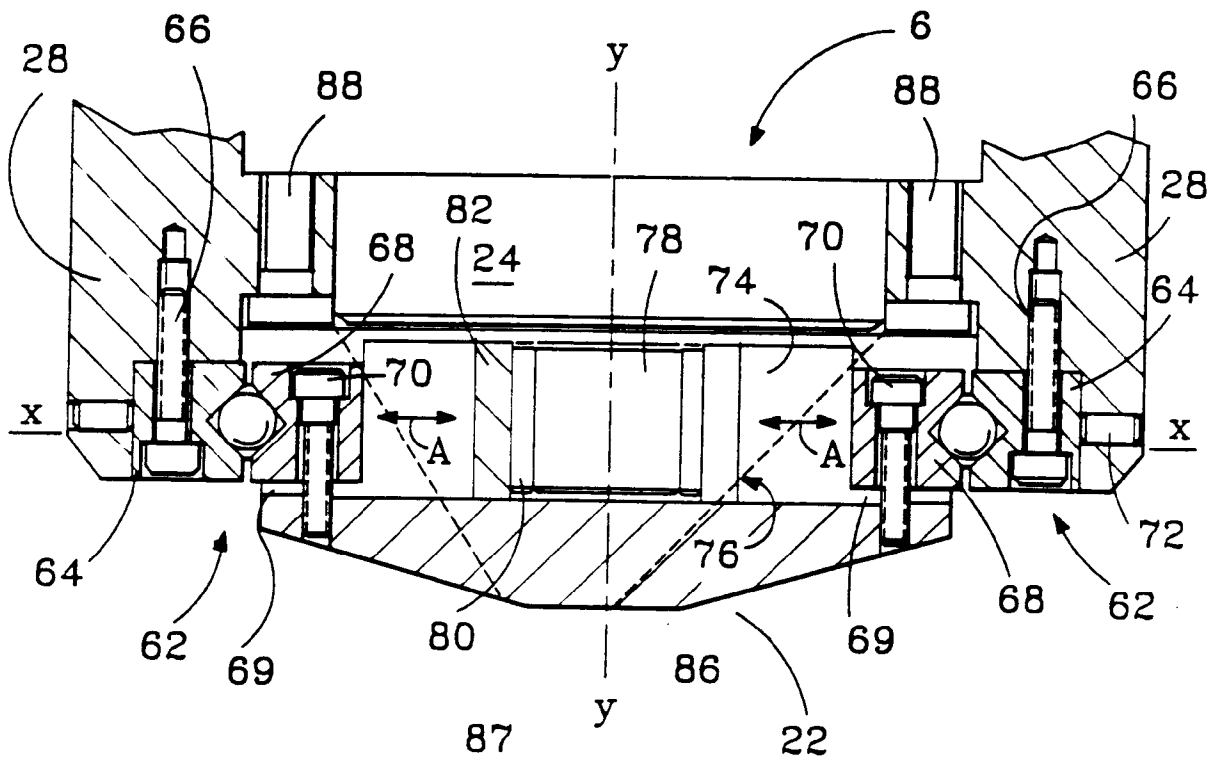


Fig. 3

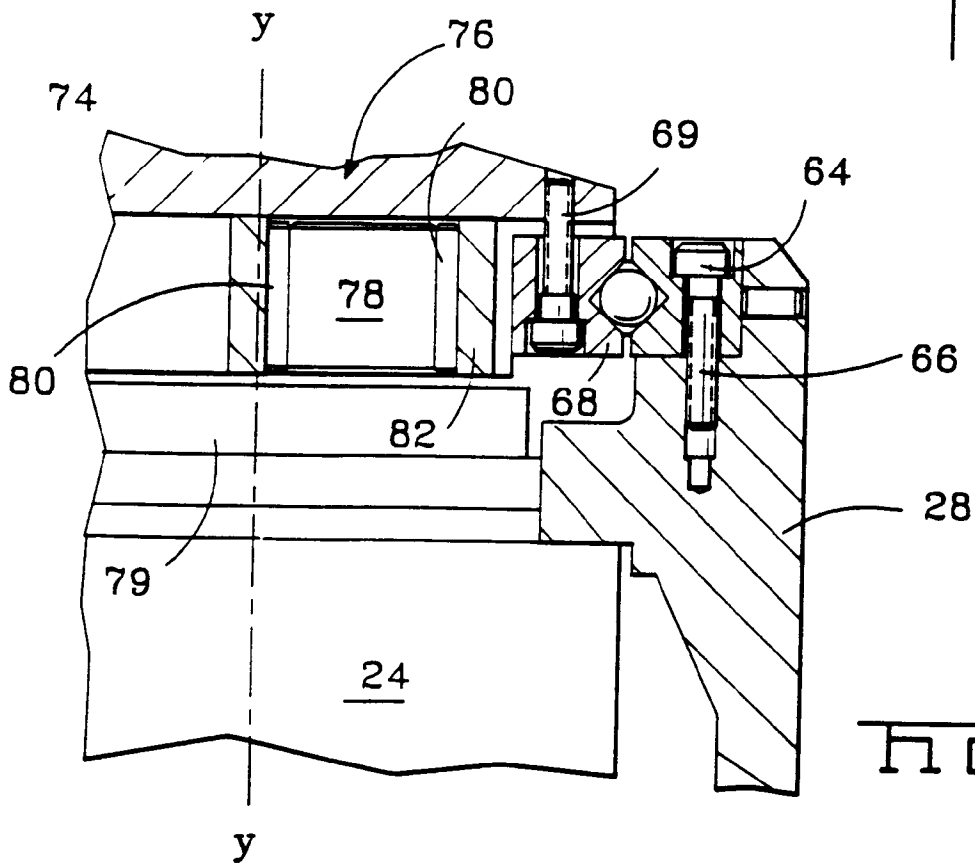
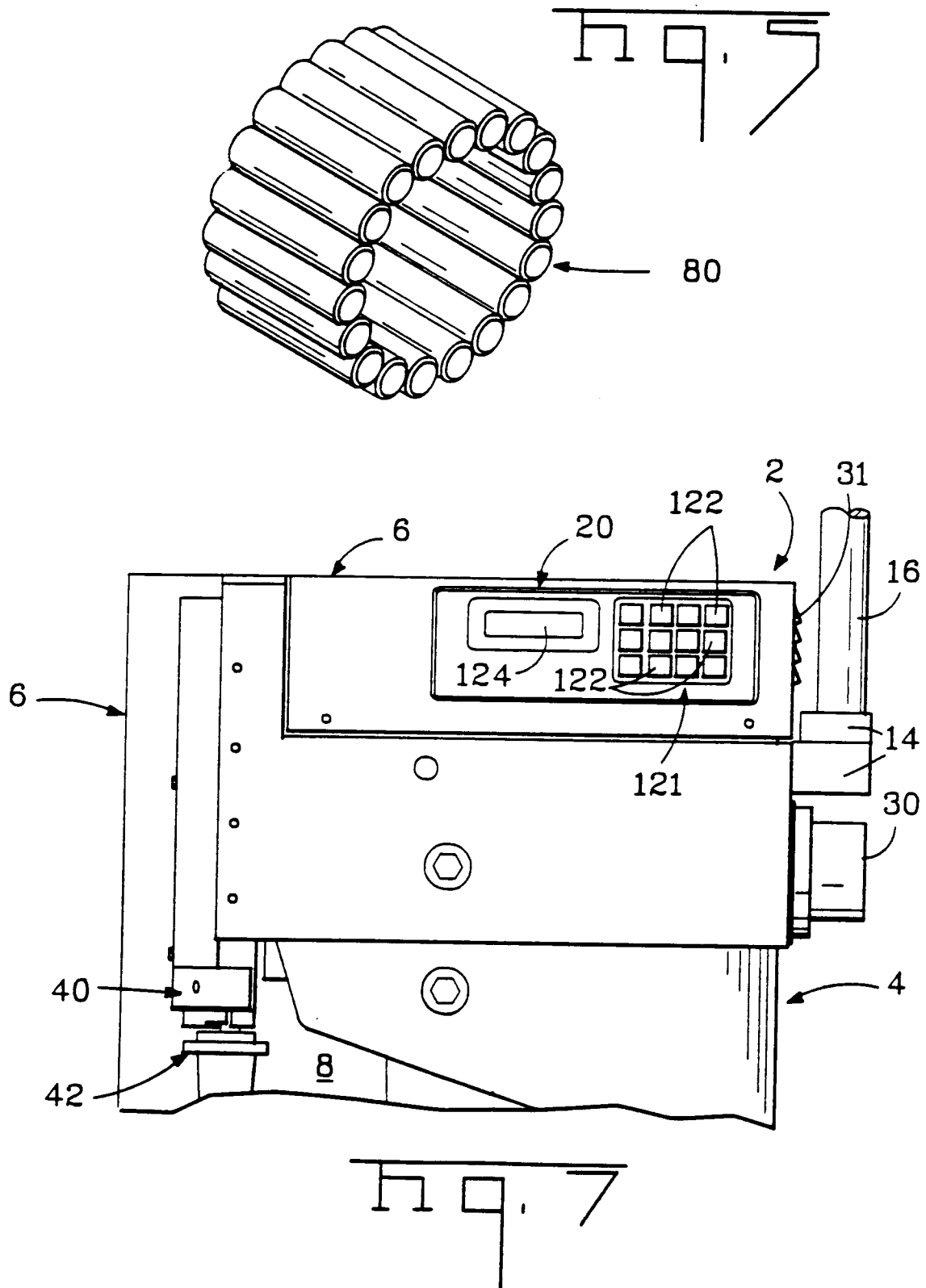
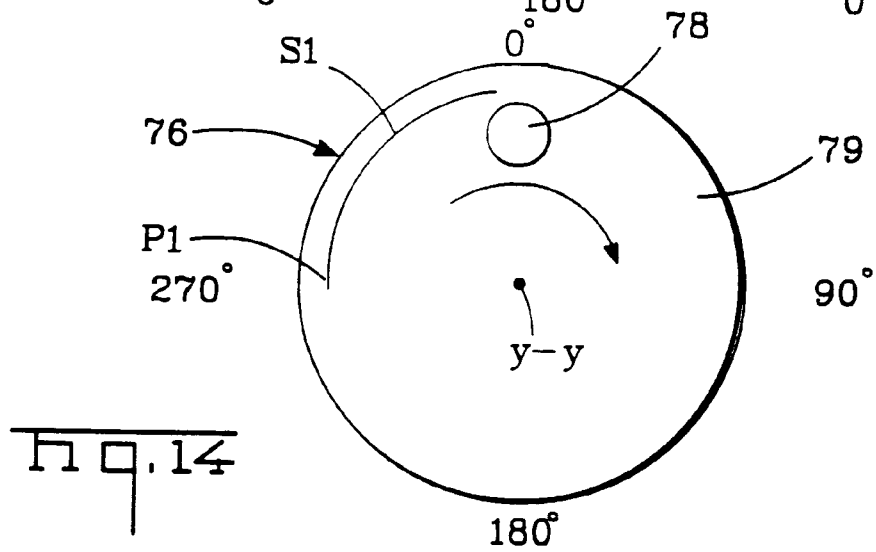
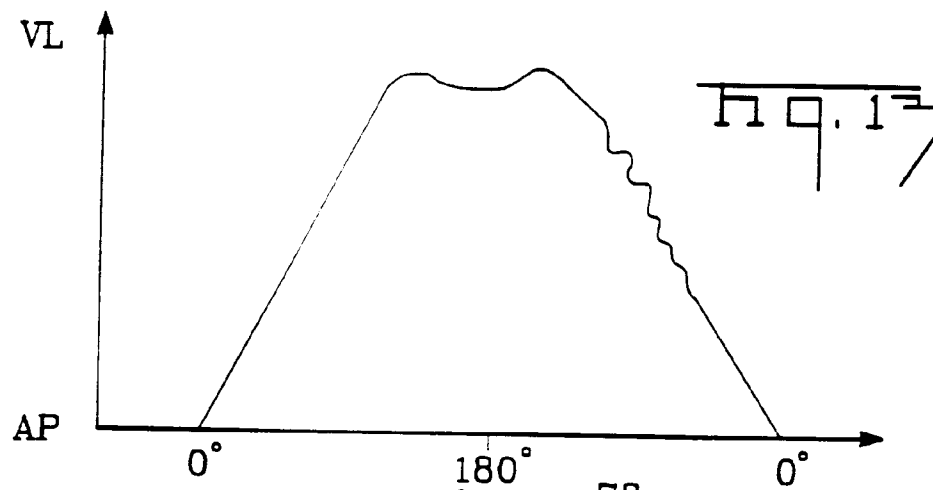
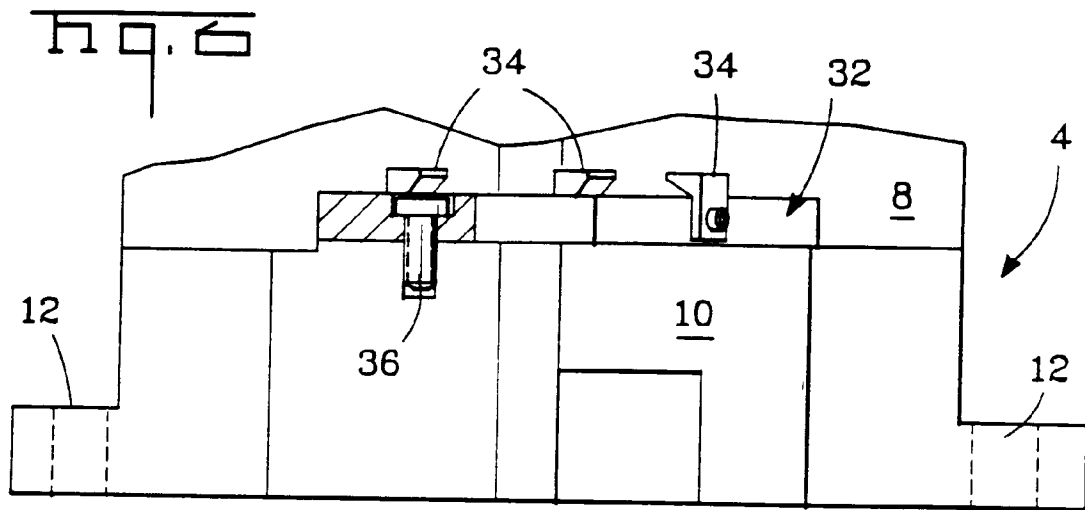
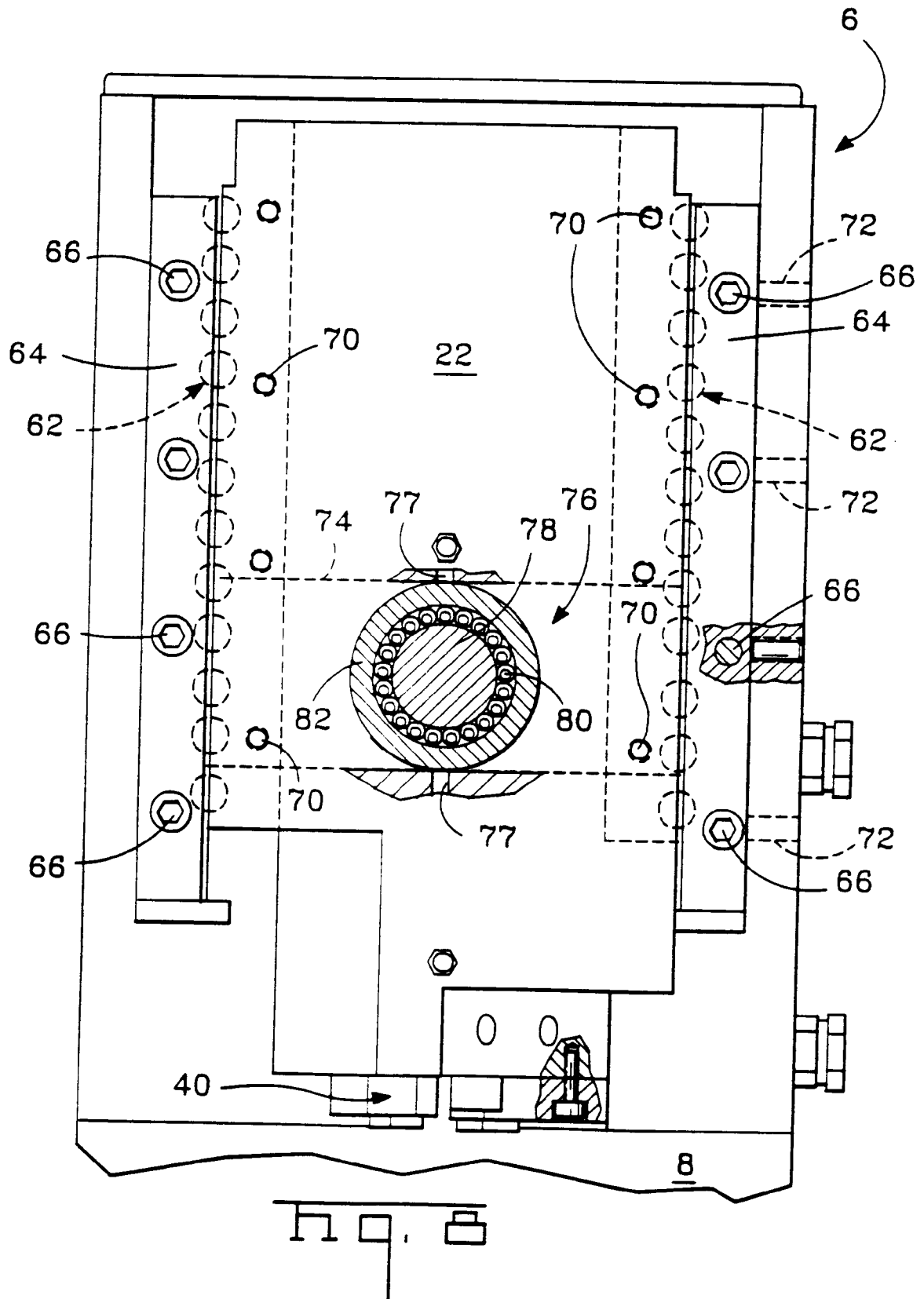
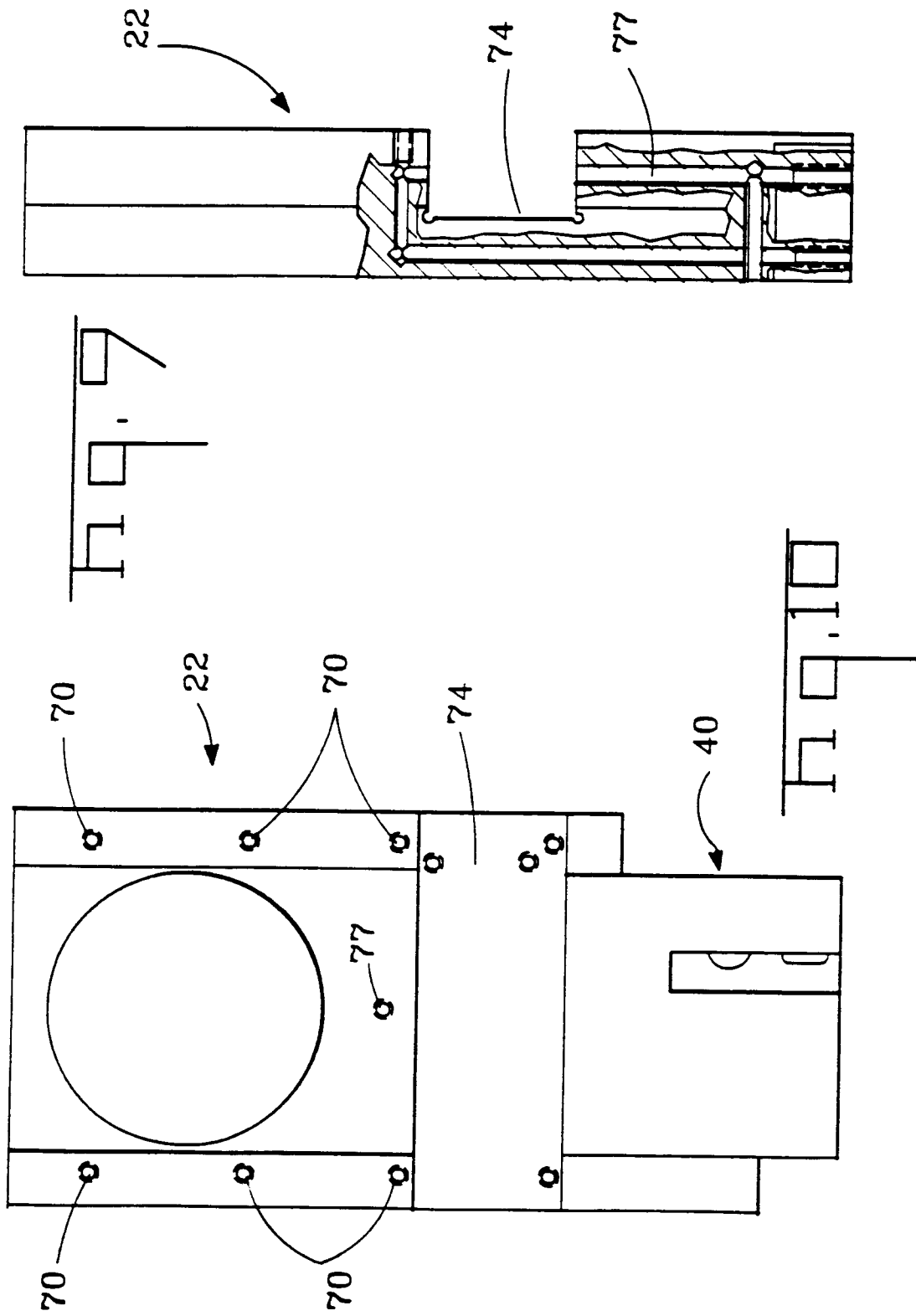


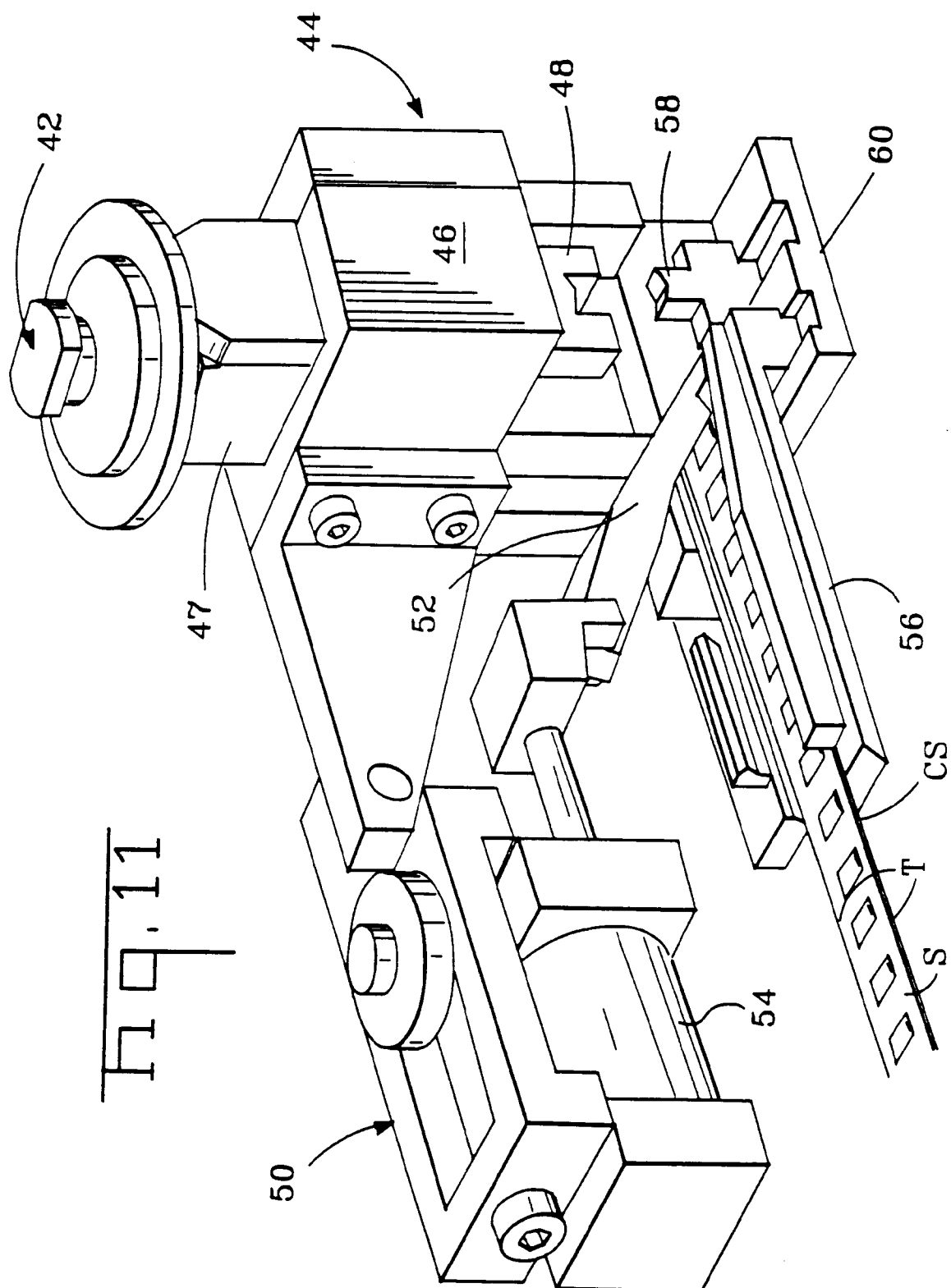
Fig. 4











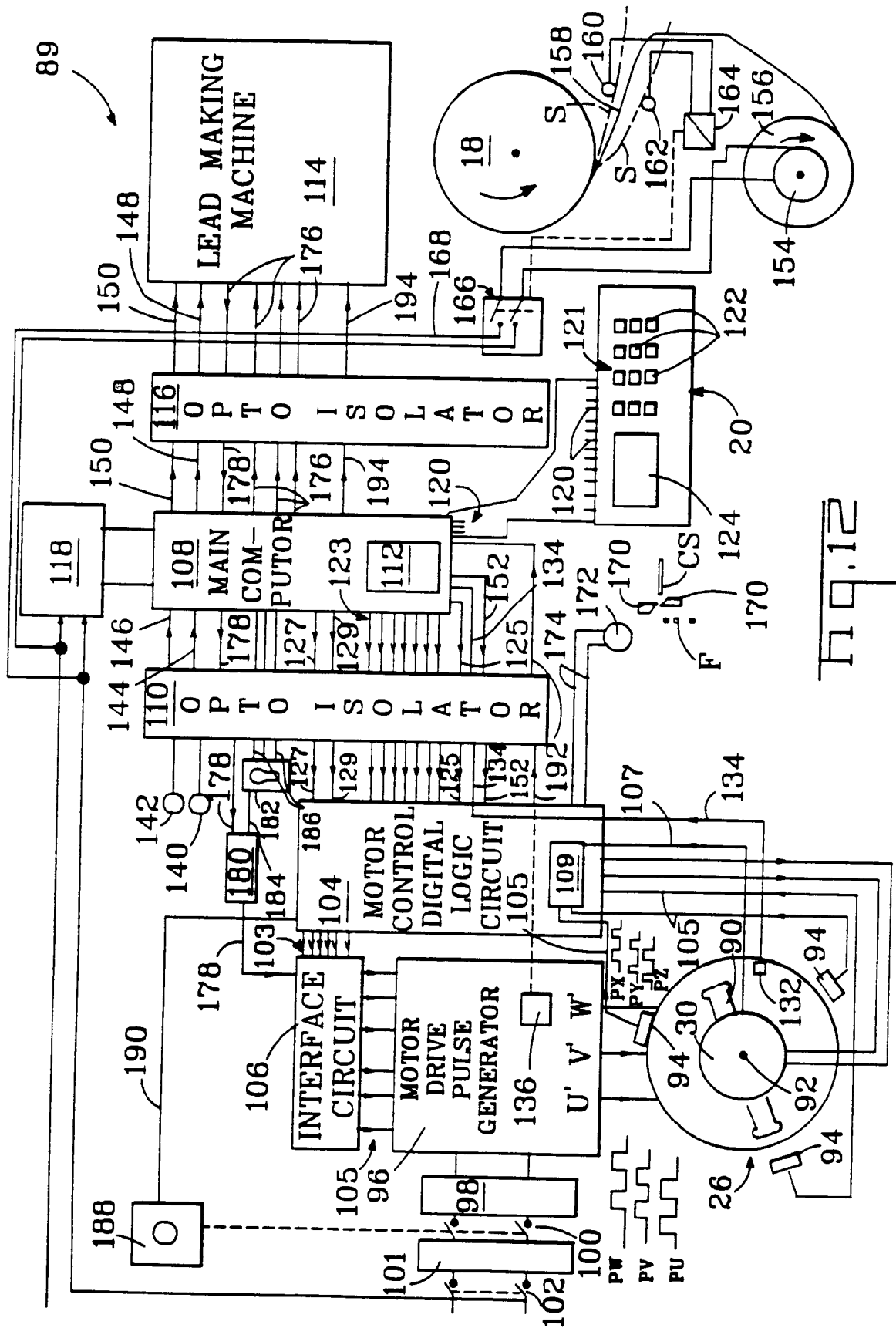


Fig. 12