THE INDUCTION PROBE UTILIZATION TO THE METAL COMMUTATOR GEOMETRY DETECTING

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ABSTRACT

The electrical commutator motors are steel very often used machines for many applications. The advantages of these motors are cost index value, easy speed regulation and dimensions/power ratio. The disadvantage is the short lifetime and service period of the sliding contact of the motor. Usually the sliding contact service period set the motor service period. The brush, brush holder and the commutator (slip-ring) are created the sliding contact. The commutator surface quality influents on sliding contact lifetime, too. Therefore the measurement workstation has been developed on our department. Measurement workstation has two main parts. The first part is table including the device, the motive machine sources and the measuring probe movement controls. The measuring frame is the second part. The measurement device including the measuring probes, the IR speed sensor, the data logger, the digital oscilloscope and personal computer with GPIB control card and Labview software. The motive device is assembly of the regulated supply and the motor. The induction analog probes are used for low distance sensing between the probe tip and electrically conducting material.

1. FIRST GENERATION OF THE MEASURING WORKSTATION FOR SENSING OF THE COMMUTATOR SURFACE

Till now the commutator surface has been measured with the contact measured method utilizing induction sensor. The rotor of the machine rotates with low speed. The probe tip is mechanically connected with ferrite core. The moving of the ferrite core changes of the impedance and the magnetic flow and induced voltage. The voltage gives the deflection of the final measuring device. The first measuring workstation was developed in 1988 on KESP VUT in Brno. The workstation has been developed for the contact-less measurement of the commutator surface in dynamic state. The workstation utilises the probe composed of the exciting coil and detecting coil. Measuring probe allows the contact-less measurement of the distance of the electrical conducting objects. The exciting coil is supplied through the harmonics high-frequency current. Detecting coil is placed as near as possible over the surface. The detecting coil has low mutual coefficient with the exciting coil.

a)

b)

Fig 1: The datalogger and the probe of the I. generation measuring device

Legend: a) datalogger, b) probe

The induced voltage is affected by the eddy currents in the measured object. Therefore the induced voltage is equal to distance from the measuring object. The probe is in the fig.1. The basic part is oscillator connected to the measuring probe and the detector. This generation has error of the measurement about 15 um. All measurement has a long time for evaluation of the results. Therefore the parts of the measuring workstation have been developed.

2. OTHER GENERATIONS OF THE MEASURING WORKSTATION FOR SENSING OF THE COMMUTATOR SURFACE

The way of the commutator bars protrusion measurement has been changed in second workstation generation. The new measuring devices and the new electronic components allow this change of the measurement. The measurement resolution has been increased. The digital oscilloscope Tektronix TDS210 was used as an A/D converter. The stopped waveform has been transferred to the PC via GPIB bus. The signal is uploaded into the PC by developed program LabView. This software is intended to control and measure. LabView only secure the uploading of the waveform. The next evaluation and analysis was made in MS Excel. The evaluation of the results was long. In [3] has been published drive composed of the step-motor and the gear. The drive has been assembled into the third workstation generation for the movement of the probes. This improvement set up faster and more accurate positioning of the measuring probes. The accurate movement of the probes is used for the measurement of the transform characteristics of the probes. The transform characteristics define the dependency between the output probe voltage and the distance from the measured object. In the third workstation the induction speed sensor has been replaced by the IR optical reflective sensor, too. But, a few new things have been done in the last generation of the workstation. The most important is development of the new probes. The probes have only one measuring coil. The probes have digital signal transfer between data-logger and probes. The probes have higher level of protection against electromagnetic interference. All uploading and evaluating procedures have been made in the LabView. This new program secures upload and evaluation at once. The new procedure for transfer characteristics interleaving by polynomial function has been built-into the program. These innovations have been published in [1]. All these changes of the last generation improve the time requirement and increase accuracy of the measurement

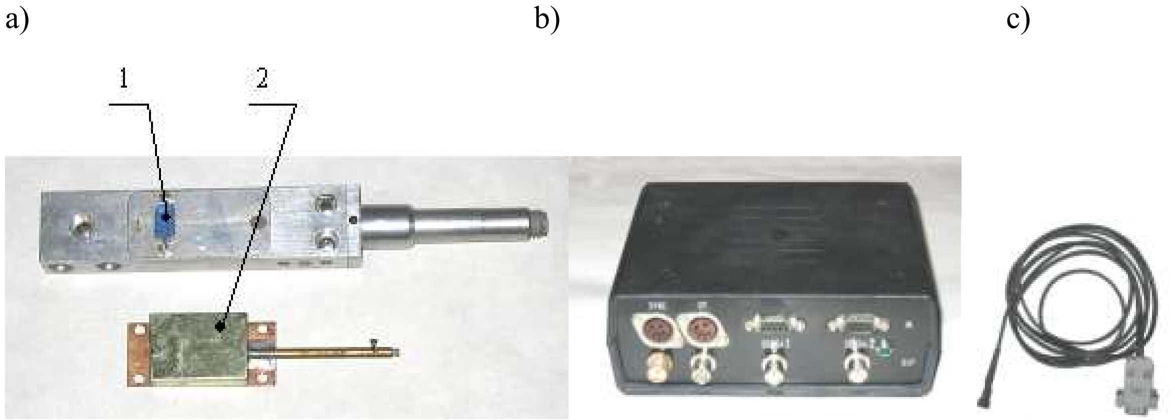


Fig 2: The parts of the measuring device.

Legend: a) measuring probe (1 – III.generation, 2 - IV.generation), b) datalogger, c) speed sensor

Tab.1: Comparison of the parameters of the workstation generations

Generation	Tip length [mm]	cross-section of probe tip [mm]	Probe resolution [μm/mV]	Measuring error [μm]
I. generation	300	17x20	10	15
II. generation	150	∅ 10	5	12
III. generation	150	∅ 10	2	6
IV. generation	100	∅ 3	0,5	3

3. WORKSTATION DESCRIPTION

Measurement workstation has two main parts. The table with the devices, with the motive machine supply and with the measuring probe position controls are the first part. The measuring frame is the second. The measurement device is composed of the measuring probes, the IR speed sensor, the datalogger, the digital oscilloscope and PC with GPIB control card and software. The electrical supply and the motor used as the motive device, or the motor is running itself. The developed induction analog probes are used for the low distance sensing between the probe tip and electric conducting materials. The analog induction probes have DC output voltage equal to the distance between probe tip and the sensing surface. The transfer function is the mathematical polynomial function for conversion from DC output voltage to the distance. The probes are placed on moveable support. The two measured induction probes could be used for measurement, in fig.3. One probe measures distance from the slip-ring or the commutator. The second probe measures vibration of the measuring object. This method allows the elimination of the vibration from the measurement. The signal transfer between the datalogger and the probe is digital. The data-logger transfers the IR speed sensor signal to oscilloscope, too. This signal is used to waveform synchronization on the scope display. The digital form of the measured waveform is transfer to the PC. The program for this measurement is developed in the LabView. The program allows the print, the data save and saved data open. The measured voltage waveform is converted to the distance by the transfer function of the probes. The peak of the measured waveform is equal to the bars. The evaluation function calculates the discrete protrusion of the commutator bars and the waveform of the bars protrusion is shown in fig.5. The most protrude bar is represented by zero value. The difference between the maximal protruded point of the surface and the minimal protruded point of the surface specifies the ovality of the commutator.

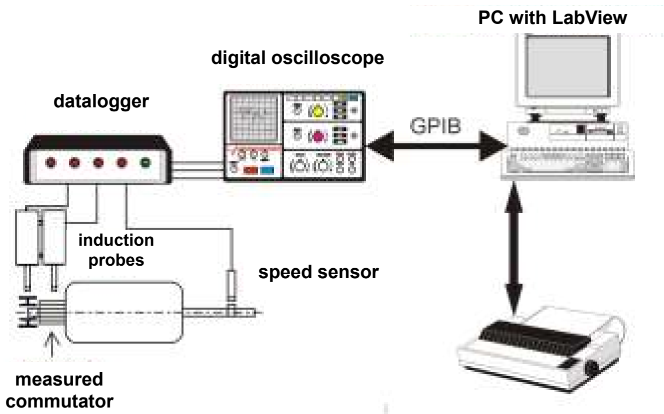
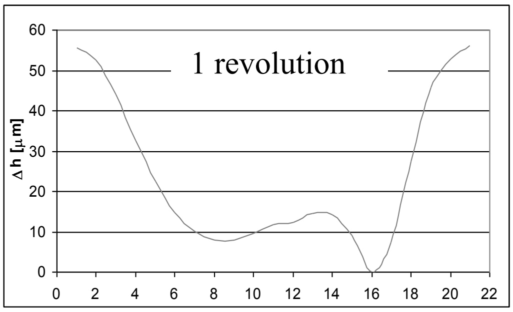


Fig 3: The block scheme of the measuring workstation for low distance sensing.

First have been measured the slip-ring of the car alternator. The results of the contact and contact-less measurement are in the fig.4. The contact-less measurement is provided with error up to 1μm. This measurement shows that our contact-less measuring method is acceptable for detecting of the shape of the slip-ring in the dynamic state. The ovality of this slip-ring is over the limits and it can influence the lifetime of the slip-ring.

a) b)



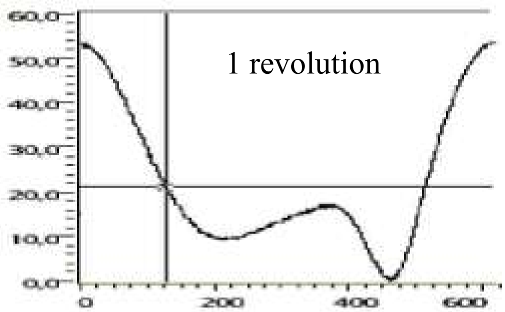


Fig 4: Waveform of the slip-ring roundness (x-axis...measured points on the surface):

a) measured with contact probe

b) measured with contactless probe of our construction (3000rpm)

The next was commutator with 24 cooper bars and diameter 28mm. The quality of the commutator has been measured on the machine. The machine type is a universal commutator machine designed for use in vacuum-cleaners. The machine ran for 200 hours before measurement. The measurement has been provided up to nominal speed 27000rpm. The vibration of the machine has been measured and has been eliminated from the measurement. The results of the contact and contact-less method are in fig.5. The protrusion of the bars of the commutator is over the recommended value allowed next motor using.

a) b)

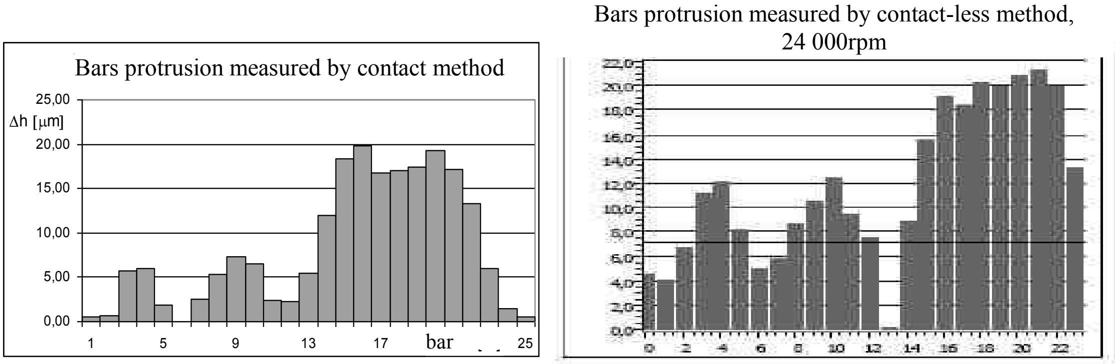


Fig 5: The universal commutator machine bars protrusion (x-axis... commutator bars).

a) measured by contact probe

b) measured by induction contact-less probe, n=24000 rpm.

The result of the measurement of the slip-ring is 60,46 ±1,23μm. The result of the measurement of the standstill slip-ring using contact method is 52 μm. The measuring error can be the difference between result of the contact measurement and the result of the contact-less measurement. This error is composed of the error of the transformation characteristic, of the vibration of the running slip-ring and other influences.

4. CONCLUSION

There was shortly presented the development of the contact-less measuring method on DPEE FEEC BUT in Brno. The last composition of the measuring workstation has good performance for low distance sensing over the rotating part. The measuring probes have small uncertainty of the results and it is comparable with contact measuring method. The contact-less measuring method can sense the ferromagnetic material too. The last measurement on big commutator shows the big advantage in time of the measurement against the contact method.

ACKNOWLEDGEMENT

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