Abstract — In-wheel type permanent magnet synchronous motors for electric commuter cars are required to be compact and light to use limited wheel space effectively and reduce unspringing weight. Therefore, our previous papers presented a low-cost in-wheel axial-gap motor that uses ferrite permanent magnets. This motor adopted an open slot structure to reduce production costs. However, to achieve further size and weight reduction, we examine here in detail the adoption of a semi-closed slot structure instead of an open slot structure. Experimental results show that the semi-closed slot structure is effective in realizing size and weight reduction.

I. INTRODUCTION

Small electric vehicles known as electric commuter cars, which are used for commuting and traveling short distances within cities, are being actively studied by researchers and industrial engineers [1]-[3]. Because of the compact size of these vehicles, the adoption of an in-wheel motor [2]-[4] is desirable for effective use of limited interior space. In addition, conventional traction motors for electric vehicles typically use powerful rare-earth permanent magnets (PMs) to generate large torques [5][6]. However, it is difficult to use such high-cost PMs in the in-wheel motors of electric commuter cars because the production budget is necessarily lower than that for large electric vehicles. Accordingly, it is very important to develop a low-cost in-wheel motor that does not use rare-earth PMs in order to make electric commuter cars more affordable and widespread.

Consequently, our research team has proposed an axial-gap-type in-wheel motor for electric commuter cars that uses ferrite PMs [7]-[9]. In general, torque is decreased by changing from rare-earth PMs to ferrite PMs because the residual magnetic flux density of the latter is only about 30% that of the former. Therefore, in the proposed motor, we adopt an axial-gap configuration that can achieve high torque density in the flat shape required for an in-wheel motor [10]-[15]. Moreover, a coreless rotor structure is used to increase magnetic torque and efficiency. The proposed motor is also equipped with a reduction gearbox on the inner side of the stator to utilize limited wheel space effectively.

In previous papers, we reported on the operational characteristics of the proposed motor with results of experiments on 5-kW and 10-kW prototypes [7]-[9]. In the examinations, an open slot structure is adopted for the stator in order to reduce production costs. It was shown that the proposed motor could satisfy the demands of an in-wheel motor for electric commuter cars, despite using ferrite PMs.
Our research team intends to develop a new 3-kW small-size motor. In order to achieve further size and weight reduction compared with the previously proposed motor, we examine afresh and in detail the adoption of a semi-closed slot structure instead of an open slot structure. Our experimental results show that the semi-closed slot structure is effective in realizing size and weight reduction.

II. REDUCTION OF MOTOR SIZE AND WEIGHT

A. Structure of Previously Proposed Motor

Fig. 1 shows the 3-kW motor structure that is based on the same design concept as the previous 5-kW and 10-kW motors which were introduced in [7]-[9]. This motor structure is an internal-rotor/external-stator type in which one rotor is sandwiched by two stators, as shown in Fig. 1(a). It is difficult to generate reluctance torque effectively in the proposed motor because, as a low-cost in-wheel motor, it cannot be equipped with a powerful cooling system such as water or oil cooling. It therefore cannot conduct the high-density currents that are required to generate reluctance torque. In addition, a concentrated winding structure is used to reduce the motor size, and this is disadvantageous to generating reluctance torque. Accordingly, it is important to generate magnetic torque effectively in the proposed motor. The rotor is therefore assembled with ferrite PMs and a non-magnetic stainless steel PM holder in order to maximize magnetic torque, as shown in Fig. 1(b). We refer to this as a “coreless rotor structure”.

Furthermore, the stator core shown in Fig. 1(c) is composed of soft magnetic composites [16] (SMC) that can cope with three-dimensional magnetic fluxes and that are made easily by press molding. In addition, the stator teeth are set in a simple open slot structure in order to reduce the press times and the numbers of mold templates and assembly steps.

To achieve the torque characteristics required for an electric city commuter, a reduction gearbox with a gear ratio of 10:1 is placed at one end of the stator, as shown in Fig. 1(a), and a resolver is placed at the other end. Inserting the gearbox and resolver in the dead spaces of the axial gap structure makes effective use of the limited wheel space.

B. Problems with Miniaturization

Table I lists the specifications and target values of the 3-kW motor. The values in Table I are the specifications of the motor alone, excluding the reduction gearbox.

In the proposed motor, the PM holder uses sus304 (a non-magnetic material), the ferrite PM uses NMF-12G+ (Hitachi Metal, Ltd.), and the soft magnetic composite of the stator core uses ML35D (Kobe Steel, Ltd.). Table II and III lists material properties of NMF-12G+ and ML35D.

To achieve the required specifications given in Table I, we sought a better motor shape by trials with three-dimensional finite-element analysis (3D-FEA) using the JMAG-Designer simulation software. As a result, a motor that could achieve the required specifications (e.g., output torque, speed, current density, and motor outer diameter) in Table I was designed as shown in Fig. 1. However, the axial length of this motor was 47 mm and its weight was 6.37 kg. These two size parameters could not satisfy the required specifications in Table I.

Fig. 2 shows an enlargement of two stator teeth of the motor shown in Fig. 1. We refer to the design shown in Figs. 1 and 2 as “open slot model (A)” or “open (A).” The stator teeth protrude from the upper surface of the winding area by 4 mm.

| Number of poles | 16 |
| Number of slots | 18 |
| Maximum output  | 3.0 kW |
| Rated output    | 2.0 kW |
| Maximum torque  | 12.0Nm |
| Base speed      | 2400 rpm |
| Maximum speed   | 5000 rpm |
| Max. current density | 10 A/mm² |
| Diameter        | 200 mm |
| Motor length    | less than 40 mm |
| Motor Weight    | less than 5.5 kg |

Table I

<table>
<thead>
<tr>
<th>Remanent magnetic flux density</th>
<th>0.45 T</th>
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<tr>
<td>Magnetic coercive force</td>
<td>-343,200 A/m</td>
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<td>Density</td>
<td>5100 kg/m³</td>
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Table II

<table>
<thead>
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<th>Maximum relative permeability</th>
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<tr>
<td>Magnetic coercive force</td>
<td>154 A/m</td>
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<td>Iron loss (W10/400)</td>
<td>34 W/kg</td>
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<tr>
<td>Density</td>
<td>7620 kg/m³</td>
</tr>
</tbody>
</table>

Table III
in order to avoid the magnetic fluxes penetrating the coils directly. Fig. 3 shows a section of the open (A) stator, in which the protrusion absorbs the magnetic flux. With this structure, we expect a reduction of eddy current losses in the coils. However, these 4-mm protrusions of the stator teeth do not contribute to generating torque. They are therefore dead space from the perspective of output. Fig. 4 shows the motor which aligns the heights of the stator teeth and the winding area by reducing the each protrusion. We refer to the design shown in Fig. 4 as “open slot model (B)” or “open (B).” The total axial length of the open (B) become 39 mm, which achieves the target value in Table I. However, the magnetic fluxes now penetrate the coils directly, as shown Fig. 5, which increases the eddy current losses in the coils.

C. Relationship between Stator-tooth Protrusion and Eddy Current Loss

This section discusses the motor characteristics and the eddy current losses in the coils when the 4-mm protrusions are removed from the stator teeth.

Fig. 6 shows the 3D-FEA results for eddy current density distribution in the coils of open (A) and open (B) at the maximum speed of 5,000 rpm with no torque load. The 3D-FEA temperature of the PMs and coils is 75 °C which is target value of average motor temperature in continuous operation at maximum speed 5000 rpm. At the top of the winding area near the air gap, eddy currents arise much more in the open (B) coil than in the open (A) one.

Fig. 7 shows the 3D-FEA results for no-load eddy current losses in all coils over a whole range of rotational speed. Detailed 3D mesh models of the winding are created by using the actual winding diameter, route and number of turns. Eddy current into each winding are calculated with the detailed 3D mesh models.

At the maximum speed of 5,000 rpm, the open (B) eddy current loss is 104.5 W, which is 8.16 times the 12.8 W of...
open (A). This result shows that the 4-mm protrusion from the stator teeth in the original open slot structure is very effective in reducing the eddy current loss generated in the coils.

We now discuss motor efficiency including the eddy current loss generated in the coils. Fig. 8 shows the open (A) and open (B) efficiencies at representative operational points, namely, a base speed of 2,400 rpm and a maximum speed of 5,000 rpm, and a rated output of 2 kW and a maximum output of 3 kW. Since it takes a huge amount of time to perform 3D-FEA covering the all operation area, we examine from analysis results of the above 4 representative operation points. These efficiencies are calculated simply by adding the eddy current losses generated in the coils at no load shown in Fig. 7 to the total losses of each operational point. This is because the eddy current loss cannot be analyzed under conducting currents in the simulation software that was used. At a base speed of 2,400 rpm, the efficiency reductions from open (A) to open (B) are not large. In contrast, the open (B) efficiencies are decreased notably at the maximum speed of 5,000 rpm because the eddy current loss generated in the coils increases rapidly as the speed increases, as shown in Fig. 7. For the rated output of 2 kW in particular, the efficiency decreases appreciably by 4.2%. Consequently, the open (B) efficiency is 88.8%, which is below 90% under ideal conditions. From previous experience, it is difficult to realize the continuous operation at 2 kW in an actual prototype machine.

Table IV lists the motor characteristics of open (A) and open (B) at the representative operational points (I)–(IV) shown in Fig. 8. The values of copper losses and iron losses are analysis value at each output condition. Because the current conditions are the same, there are no differences in the copper losses, whereas the iron losses are larger for open (B). At the stator core, iron losses are generated more in open (A) than in open (B) because of the stator teeth protrusion. However, the eddy current losses in the coils are much larger in open (B), so the open (B) efficiencies deteriorate at all the operational points.

D. Motor Miniaturization and Reduction of Eddy Current Loss by Adopting Semi-closed Slot Structure

The 3D-FEA results of the previous section show that it is not feasible to adopt the open slot model (B) design. Therefore, while keeping the same axial length of 39 mm as open (B), it is necessary to reduce the eddy current loss generated in the coils. Furthermore, the open (B) weight of 5.67 kg does not achieve the target value of 5.5 kg, so it is also necessary to reduce the motor weight.

In order to solve the above problems, a semi-closed slot structure is adopted, even though this increases the production costs. Fig. 9 shows the stator teeth in the semi-closed slot structure model, now with brims of SMC arranged on top. Fig. 10 shows the new estimated magnetic flux flow. Because a larger surface facing magnets is obtained by the brims, it is possible to utilize the magnetic fluxes more effectively compared to the open slot structure. In addition, we expect a
reduction of eddy current loss because the brims guard the coils from magnetic fluxes.

The height of the stator including the brim is 14.3 mm and the total axial length of the motor is 39 mm. These are the same values as for the open slot model (B). The shapes of the brims and stator teeth are determined by repeating 3D-FEA to achieve the required specifications in Table I. We refer to the design shown in Fig. 9 as “semi-closed slot model (C)” or “semi-closed (C).”

In semi-closed (C), the number of coil turns per stator tooth is reduced from 13 in open (B) to 12 on the condition that the fill factor is the same. To avoid decreasing the magnetic flux by reducing the coil turns, the upper surface area of the brim in the semi-closed (C) is increased from the 319.2 mm² of open (A) and (B) to 553.5 mm². Conversely, the area of the root portion of each stator tooth is decreased to 231.3 mm² in order to secure an area for winding the coils.

Fig. 11 shows the 3D-FEA results for line-to-line voltage waveform at no load in open (B) and semi-closed (C). Despite the reduction in coil turns, the line-to-line voltage amplitude of semi-closed (C) is 8.8% larger than that of open (B). The value of voltage per one turn of the winding at open (B) is 3.00 V/turn, and the same value at semi-closed (C) is 3.54 V/turn. The result shows that the no-load flux linkage per one turn of semi-closed (C) becomes 18.0% larger than that of open (B) by adopting the brim. In passing, both total harmonic distortions (THD) are below 1%. All models have good low-distortion characteristics because of the 16-pole/18-slot fractional-slot concentrated winding structure.

Fig. 12 shows a comparison of the maximum current density at maximum torque in open (B) and semi-closed (C). For the same generated torque, the current density of 10.8 A/mm² in semi-closed (C) is smaller than the 10.8 A/mm² in open (B).

Fig. 13 shows a 3D-FEA result for the eddy current density distribution in a coil of semi-closed slot model (C). The eddy current is drastically decreased from the open (B) case shown in Fig. 6(b) because the magnetic flux that penetrates the coils directly is reduced by the SMC brims.
Fig. 14 shows the 3D-FEA results for the semi-closed (C) no-load eddy current losses in all coils over a whole range of rotational speed. The results for open (A) and open (B) are also plotted for comparison. At the maximum speed of 5,000 rpm, the eddy current loss generated in semi-closed (C) is a mere 5.8 W, which is decreased by 94.4% from the open (B) loss and by 54.8% from the open (A) loss. This shows that the semi-closed slot structure is very effective in reducing the eddy current loss generated in the coils, more so than the stator-tooth protrusions in the open slot structure.

Fig. 15 shows the efficiencies at the same representative operational points as in Fig. 8 for open (A) and semi-closed (C). The efficiencies of semi-closed (C) are a little higher than those of open (A) at 2,400 rpm, and a little lower at 5,000 rpm. The former is caused by a decreased copper loss and the latter by an increased iron loss in the brims. Overall, the reduction in motor size with semi-closed (C) is sufficient to match the performance of the open (A).

Table V lists the motor characteristics of open (A) and semi-closed (C) at the representative operational points (I)–(IV) shown in Fig. 15. The semi-closed (C) copper losses are much lower because of decreasing the coil turns and current density, whereas its iron losses are higher. Fig. 16 shows the iron loss density distribution of the stator core at operational point (IV) in both models. Iron losses are generated constantly in the brims at high speed. For the above reasons, the semi-closed (C) efficiency is higher at low speeds; conversely, the open (A) efficiency is higher at high speeds.

Table VI gives the total weight and volume of each motor model. Open (A) exceeds open (B) and semi-closed (C) in both measures. Moreover, the semi-closed (C) stator teeth are thinner and shorter, and there are fewer coil turns. This makes semi-closed (C) lighter than open (B); at 5.49 kg, it achieves the required specification in Table I.
17(b) shows the stator core wound with coils. Fig. 17(c) shows the exterior of the prototype. The weight of the prototype including its case and reduction gearbox is 11 kg.

B. Experimental Results for 3-kW Prototype Motor

The experimental test of the prototype was performed without the reduction gearbox in order to evaluate the motor characteristics alone. Furthermore, 3D-FEA is carried out with the same conditions for comparison with the experimental results. In the 3D-FEA, to consider the effect of the segmented stator core, we analyzed the non-segmented core model examined in the previous chapter and also a segmented core model with an air gap of 0.1 mm inserted between the segmented cores. Fig. 18 shows a section of the segmented-stator-core analysis model. The 0.1-mm air gaps are placed between the back yokes and between the brims and the stator teeth.

Fig. 19 shows the line-to-line voltage waveform at no load. The line-to-line voltage amplitude of the experimental result is 9.5% smaller than the analysis result for the non-segmented core model. In contrast, the difference compared to the analysis result for the segmented core model is only 3.1%.

Fig. 20 shows the relationship between torque and current density. The prototype can achieve 12 Nm, which is the target value given in Table I. The experimental results for the prototype agree well with the analysis results for the
segmented core model.

The results of Fig. 19 and Fig. 20 show that the magnetic resistance increases in air gaps between segmented cores. Therefore, the air-gap magnetic flux density between rotor and stator decreases, hence the voltage decreases as shown Fig. 19 and the torque decreases as shown Fig. 20. It is possible to evaluate the effect of the segmented stator core by means of 3D-FEA.

Fig. 21 shows the efficiency map of the prototype. This was obtained by correcting for machine loss, which is measured by using the non-magnetized rotor. The maximum efficiency is 93.3% at 3,200 rpm, and high efficiencies over 90% are realized over a wide range. Moreover, a constant power output of 3 kW is accomplished at rotational speeds of 2,400–5,000 rpm.

Fig. 22 shows the changes in coil temperature at a base speed of 2,400 rpm or the maximum speed of 5,000 rpm, and for a rated output of 2 kW or the maximum output of 3 kW. Although the winding temperatures at the maximum output of 3 kW rise to 90 °C, this takes 15 min 5 s at 2,400 rpm and 17 min 37 s at 5,000 rpm. This confirms that the proposed motor would have sufficient time to accelerate in a city commuter. The winding temperature for the rated output of 2 kW at 2,400 rpm reaches a balance at 92.2 °C. Similarly, the winding temperature for the rated output of 2 kW at 5,000 rpm reaches a balance at 78.4 °C. At any speed, continuous operation at 2 kW is available from the prototype.

From all our experimental results, the 3-kW prototype motor achieves all required specifications in Table I.

IV. CONCLUSION

To reduce the size and weight of a 3-kW in-wheel axial-gap motor with ferrite permanent magnets that is intended for electric commuter cars, we examined the adoption of a semi-closed slot structure instead of an open slot structure. The analysis results of 3D-FEA showed that the semi-closed slot structure, in which SMC brims are attached to the tops of the stator teeth, could give a smaller size and weight than those of the conventional open slot structure. The efficiency of the proposed motor was maintained despite the miniaturization. Furthermore, we confirmed experimentally that a prototype motor could fulfill all the required specifications for an electric city commuter.

REFERENCES


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