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(54) **CLAMP FORCE AND ALIGNMENT CHECKING DEVICE**

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B23K 20/10 (2006.01)
B23K 31/12 (2006.01)
B23K 20/26 (2006.01)
G01L 5/00 (2006.01)
B23K 101/36 (2006.01)

(52) **U.S. Cl.**

CPC **G01L 5/16** (2013.01); **B23K 20/10** (2013.01); **B23K 20/26** (2013.01); **B23K 31/12** (2013.01); **G01L 5/0038** (2013.01); **G01L 5/0085** (2013.01); **B23K 2201/36** (2013.01)

(58) **Field of Classification Search**

CPC G01L 5/16; G01L 5/0085; G01L 5/0038; B23K 20/26; B23K 20/10; B23K 31/12; B23K 2201/36

USPC 156/64, 350, 358, 367, 378, 379, 379.6
See application file for complete search history.

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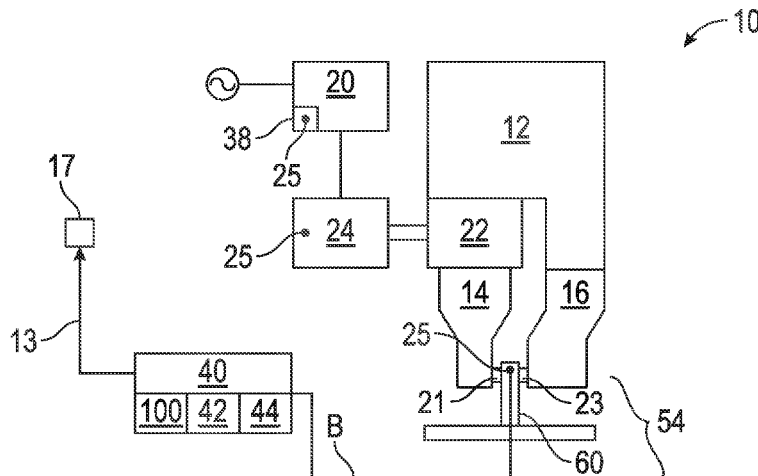
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(57) **ABSTRACT**

A check fixture measures a total clamp force applied by a welder device. The welder device includes a welding horn having a plurality of weld pads and welding anvil having a plurality of weld pads. The check fixture includes a base member operatively supporting a plurality of force sensors. The base member and the force sensors are received between the weld pads of the welding horn and the anvil pads of the welding anvil. Each force sensor is configured to measure an individual clamp force applied thereto by corresponding weld and anvil pads when the base member is received between the welding horn and the welding anvil and the welder device is in the clamped position. The individual clamp forces are used to determine whether the weld and/or anvil pads are worn or misaligned.

20 Claims, 5 Drawing Sheets



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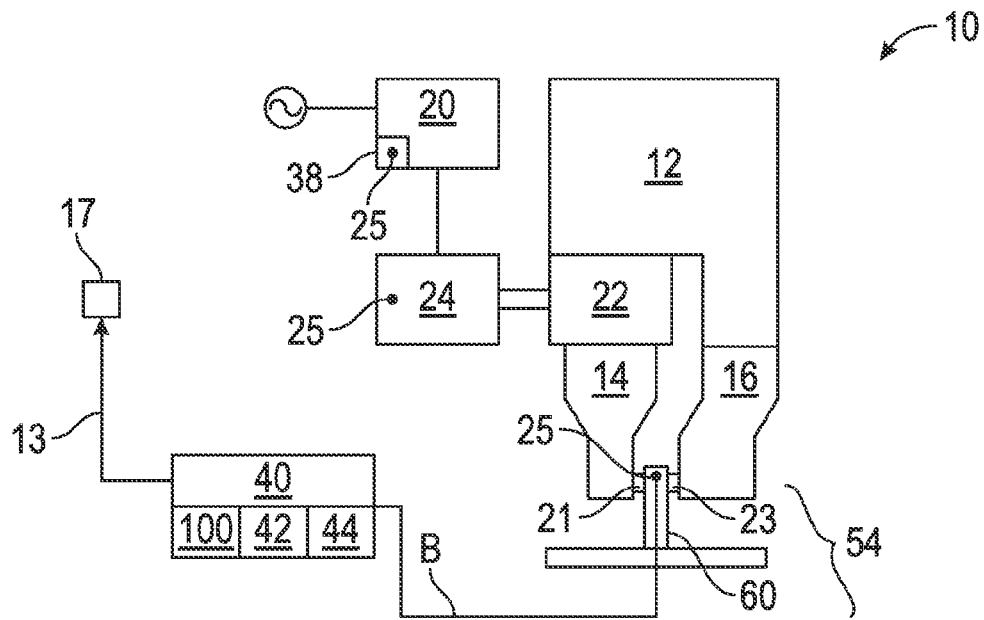


FIG. 1

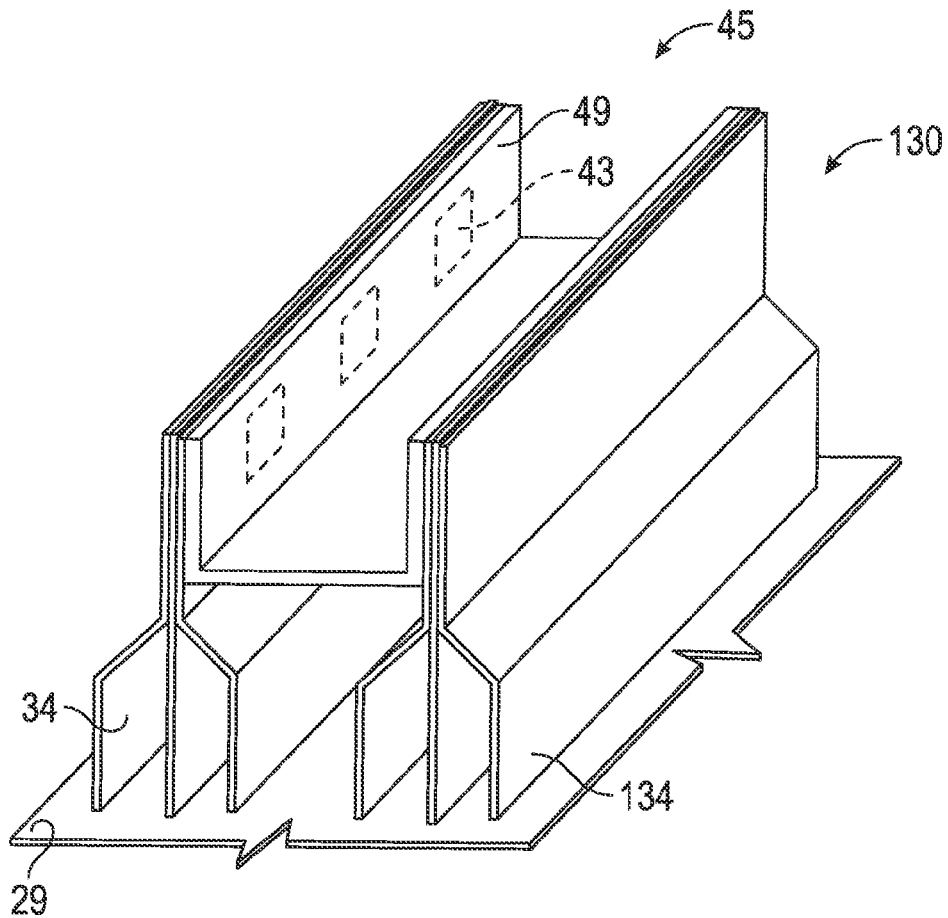


FIG. 2

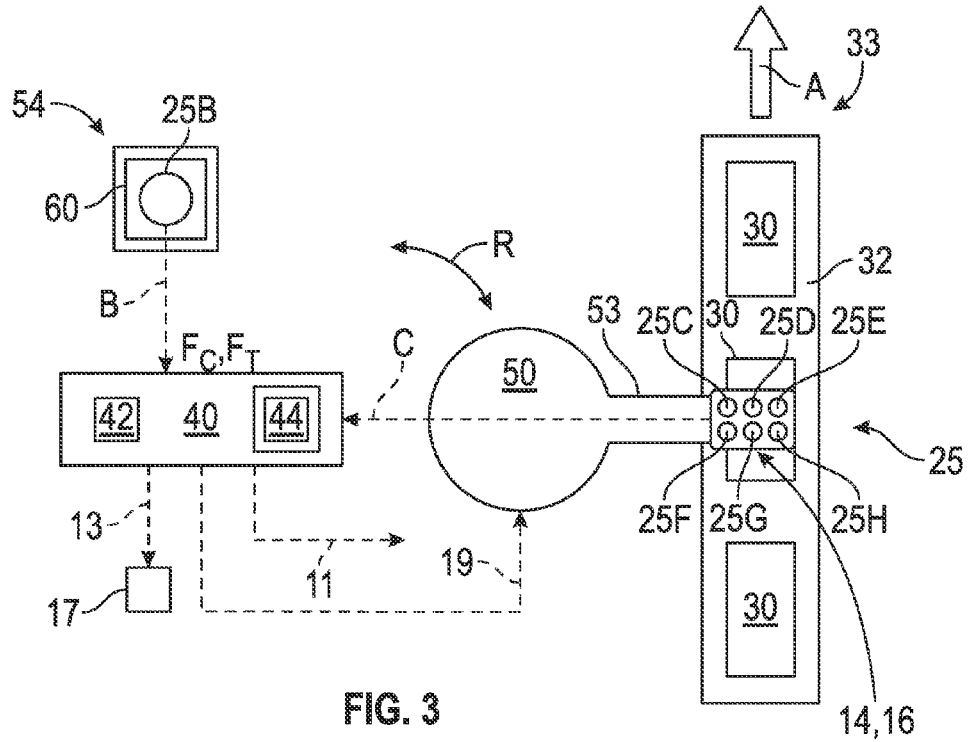


FIG. 3

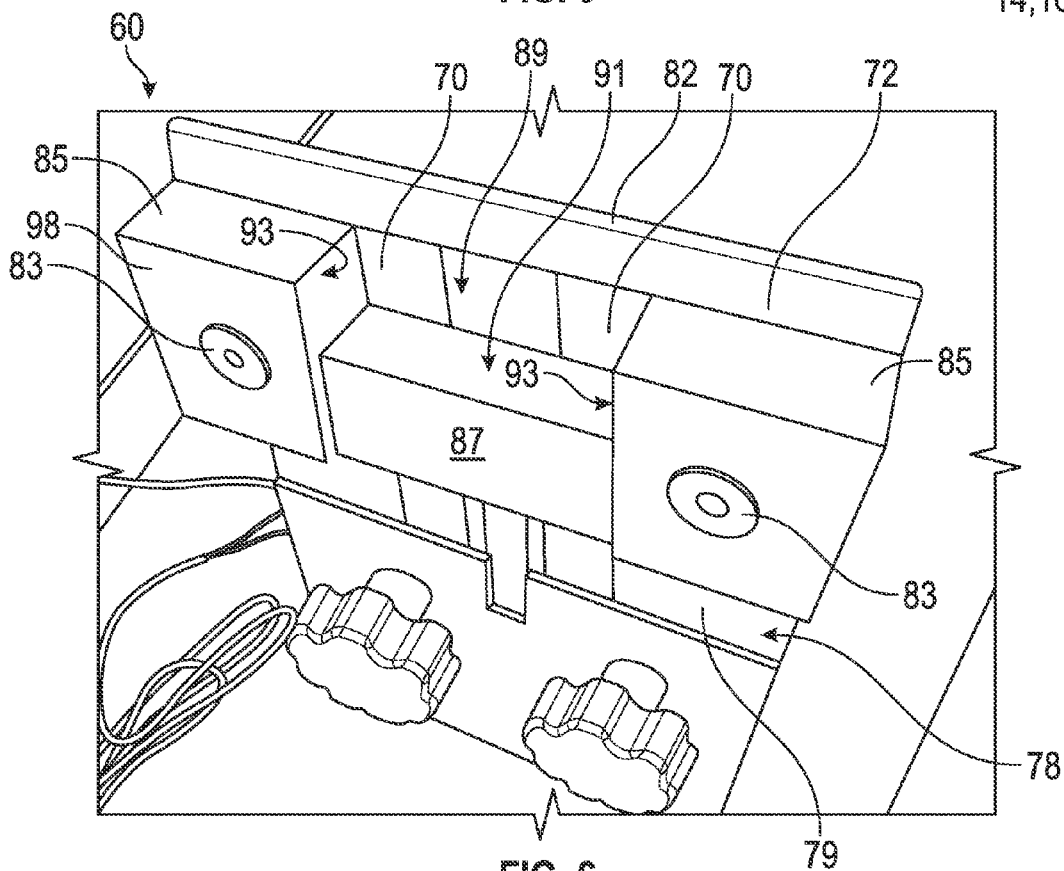


FIG. 6

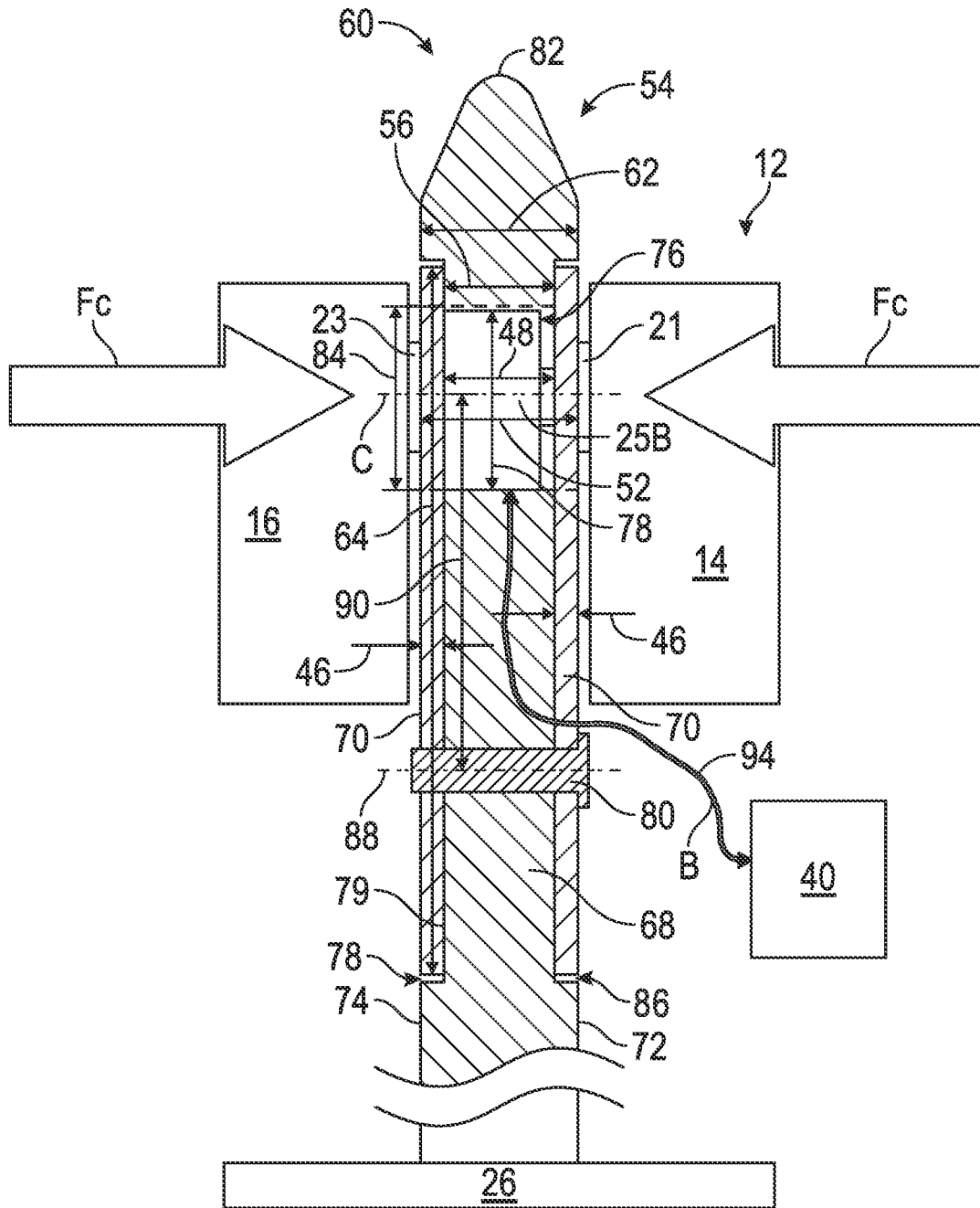


FIG. 4

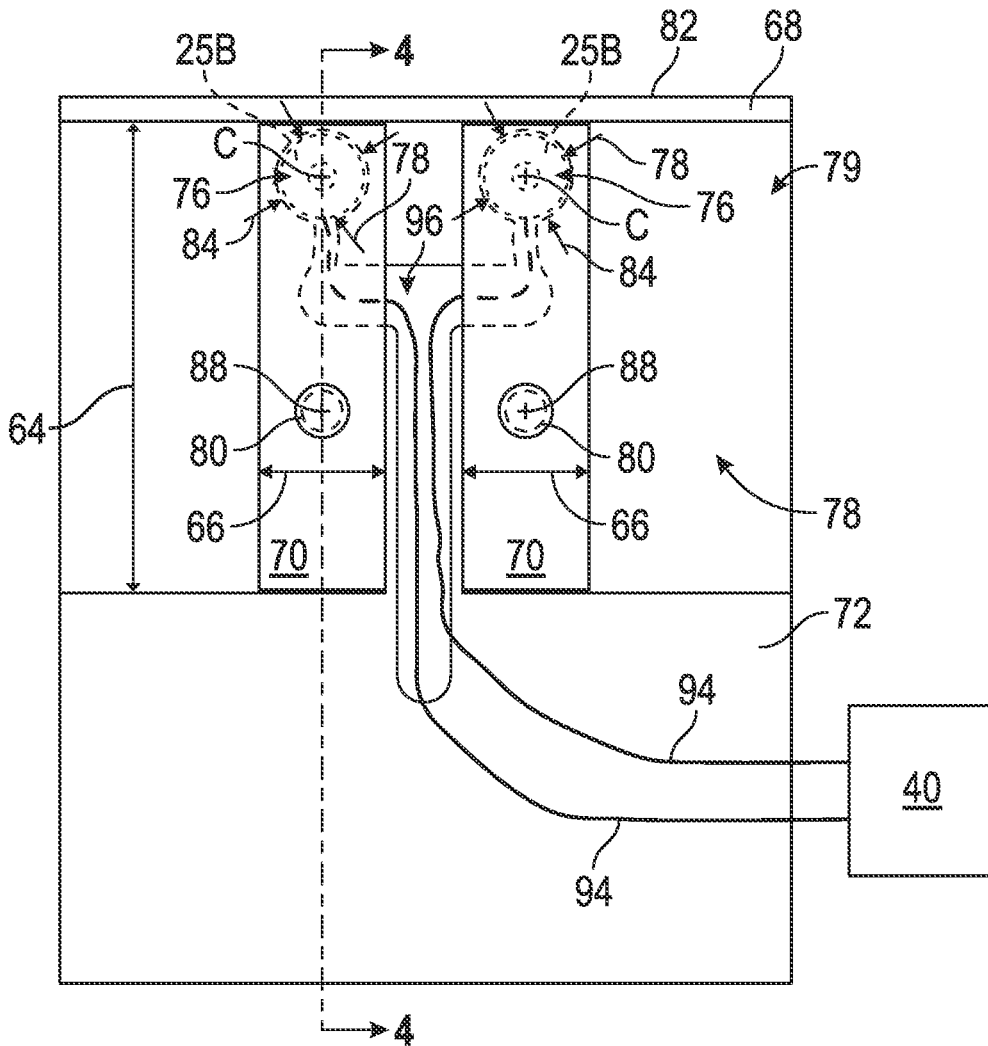


FIG. 5

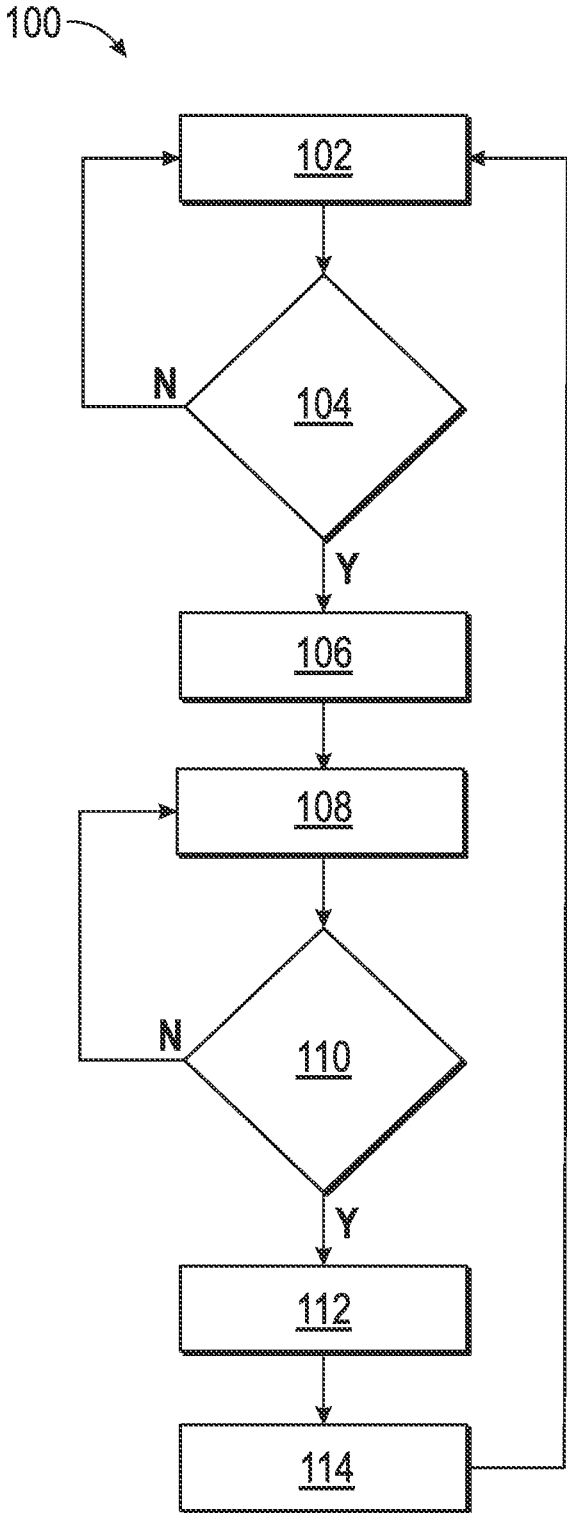


FIG. 7

1

CLAMP FORCE AND ALIGNMENT CHECKING DEVICE

CROSS-REFERENCE TO RELATED APPLICATIONS

This application claims the benefit of U.S. Provisional Application No. 61/915,865, filed on Dec. 13, 2013, which is hereby incorporated by reference in its entirety.

STATEMENT REGARDING FEDERALLY SPONSORED RESEARCH OR DEVELOPMENT

This invention was made with U.S. Government support under an Agreement/Project DE-EE0002217, Department of Energy American Recovery and Reinvestment Act (ARRA) of 2009, Battery Pack Manufacturing B511. The U.S. government may have certain rights in this invention.

TECHNICAL FIELD

The present disclosure relates to a clamp force and alignment checking device for monitoring of vibration welding equipment.

BACKGROUND

Vibration welding is a technique in which vibration energy is applied in a particular frequency range to a clamped work piece. The frequency range is typically ultrasonic. Surface friction between vibrating adjacent surfaces of the clamped work piece generates heat, which ultimately softens and bonds the adjacent surfaces of the work piece. Vibration welding in a well-controlled process, using properly functioning welding equipment, typically produces welds having a highly consistent and repeatable weld quality. However, while various approaches exist for ensuring control of a vibration welding process, such approaches may be less than optimal for the purposes of ongoing monitoring of a maintenance status or other status condition of the vibration welding equipment.

SUMMARY

One possible aspect of the disclosure provides a check fixture for measuring a total clamp force applied by a welder device. The welder device includes a welding horn and a welding anvil. The welding horn and welding anvil are movable between an unclamped position and a clamped position. The check fixture includes a base member and a plurality of force or pressure sensors. The base member has a first side and a second side, opposing the first side. The plurality of force sensors are operatively supported by the base member. The base member and the plurality of force sensors are configured to be received between the welding horn and the welding anvil with the welding horn facing the first side and the welding anvil facing the second side. Each of the plurality of force sensors is configured to measure an individual clamp force applied thereto by the welding horn and welding anvil when the base member is received between the welding horn and the welding anvil and the welder device is in the clamped position.

Another possible aspect of the disclosure provides a vibration welding system including a welder device and a check fixture. The welder device includes a welding horn and a welding anvil. The welder device is configured to apply a total clamp force to the check fixture clamped

2

between the welding horn and the welding anvil. The welding horn includes a plurality of weld pads. The welding anvil includes a plurality of anvil pads disposed in facing relationship to the plurality of weld pads. The check fixture is configured to measure the total clamp force applied thereto by the welder device. The check fixture includes a base member and a plurality of force sensors. The base member has a first side and a second side, opposing the first side. The force sensors are each operatively supported by the base member. The base member and the force sensors are configured to be received between the weld pads of the welding horn and the anvil pads of the welding anvil with the welding horn facing the first side and the welding anvil facing the second side. As such, each of the weld pads and each of the anvil pads face a respective one of the force sensors. Each force sensor is configured to measure an individual clamp force applied thereto by the respective weld pad of the welding horn and the respective anvil pad of the welding anvil when the base member is received between the welding horn and the welding anvil and the welder device is clamped.

Yet another possible aspect of the disclosure provides a method for determining a status of a welder device. The welder device includes a welding horn having a plurality of weld pads and a welding anvil having a plurality of anvil pads. The method includes clamping a plurality of force sensors between a respective weld pad of the welding anvil and a respective anvil pad of the welding horn. A force signal from each of the force sensors is transmitted to a processor. Each of the force signals corresponds to a respective one of the force sensors being clamped between the respective weld pad of the welding horn and the respective anvil pad of the welding anvil. The force signals from each of the force sensors are received in the processor. The force signals are processed in the processor to determine an individual clamp force corresponding to each of the force sensors to thereby determine a status condition of the weld and anvil pads of the vibration welding equipment.

The above features and advantages and other features and advantages of the present teachings are readily apparent from the following detailed description of the best modes for carrying out the present teachings when taken in connection with the accompanying drawings.

BRIEF DESCRIPTION OF THE DRAWINGS

FIG. 1 is a schematic illustration of an example suite of vibration welding equipment which may be monitored as set forth herein.

FIG. 2 is a schematic perspective view of an example work piece in the form of a multi-cell battery module which may be welded using the vibration welding equipment shown in FIG. 1.

FIG. 3 is a schematic illustration of a system for monitoring a condition of the vibration welding equipment shown in FIG. 1.

FIG. 4 is a schematic illustration of a partial cross-sectional side view of a check station taken along line 4-4 of FIG. 5, which may be used to measure a clamp force of a welder device of the vibration welding equipment shown in FIG. 1.

FIG. 5 is a schematic side view of the check station of FIG. 4.

FIG. 6 is a schematic perspective side view of the check station of FIG. 4 including a guide member.

FIG. 7 is a flow chart describing an example method for checking the clamping force and alignment of the welding equipment using the check station.

DETAILED DESCRIPTION

Referring to the drawings, wherein like reference numbers refer to like components throughout the several Figures, a suite of vibration welding equipment **10** is shown schematically in FIG. 1. The vibration welding equipment **10** may be used, for instance, to form welds in the fabrication of a work piece, with an example work piece **130** shown in FIG. 2 in the form of a portion of a multi-cell battery pack. While other types of work pieces may be ultrasonically welded without departing from the intended inventive scope, the example work piece **130** of FIG. 2 is typical of the type of welded system in which high-quality/durable welds must be formed in a repeatable process.

Referring now to FIGS. 1 and 2, a host device **40** is in communication with the vibration welding equipment **10** and sensors **25** positioned with respect to the vibration welding equipment **10**. Each sensor **25** has a different function, with a set of example sensors **25B-H** shown in FIG. 3. The host device **40**, i.e., a computer, also includes a processor **42** and tangible, non-transitory memory **44** on which is recorded instructions embodying the present method **100**, an example of which is shown in FIG. 7. The host device **40** periodically executes the instructions via the processor **42** to thereby monitor a maintenance status or other status condition of the vibration welding equipment **10**. As part of this process, the vibration welding equipment **10** may be tested at a nearby check station **54**, with such testing described in further detail below with reference to FIGS. 3-5.

The example vibration welding equipment **10** of FIG. 1 may include a welder device **12** having a sonotrode/welding horn **14** and a welding anvil **16**, with the welder device **12** providing a backing structure and support for the welding horn **14** and the welding anvil **16**. The vibration welding equipment **10** may also include a welding controller **20**. The welding horn **14** is typically connected to a transducer **24**, for instance a piezoelectric stack. Signals from the welding controller **20** cause the transducer **24** to vibrate at a calibrated frequency, which in turn vibrates the welding horn **14** at that same frequency, possibly amplified by a booster **22**.

As will be understood by those of ordinary skill in the art, a welding controller/power supply of the type used for vibration welding, such as the welding controller **20** of FIG. 1, may be electrically-connected to a suitable energy source, typically a 50-60 Hz wall socket. The welding controller **20** may include, for example, an oscillator or timer **38**, as well as voltage rectifiers, transformers, power inverters, and/or other hardware which ultimately transforms the source power, whatever its form, into vibration control signals. The control signals ultimately command predetermined waveform characteristic(s), for example a periodic signal having a frequency of about 20 kHz to about 40 kHz or more depending on the particular welding application.

The welding horn **14** shown in FIG. 1 typically includes a plurality of weld pads **21**, each having a textured knurl pattern, e.g., bumps and/or ridges, which are suitable for gripping and holding a work piece clamped between the welding horn **14** and the welding anvil **16**. Each weld pad **21** corresponds to a weld **43**, illustrated in FIG. 2. Two or more welds are typically formed at a time. Each anvil pad **23** of the welding anvil **16**, illustrated in FIG. 2, typically includes a similar knurl pattern and is disposed in opposing relation-

ship to a weld pad **21** of the welding horn **14**. The vibration welding equipment **10** may also include a booster **22**, i.e., a mechanical amplifier, which increases the amplitude of any commanded mechanical vibration from the transducer **24**, as needed.

The host device **40** of FIG. 3 receives signals from each of the sensors **25** and then processes the received signals in the execution of the method **100**. The sensors **25** may be configured to measure forces, amplitude, displacement, acoustics, temperatures, a weld pad attitude, and the like. The host device **40** may also transmit an acoustic test signal (arrow **11**) as part of the method **100**, and also may output a control signal (arrow **13**) to an external device **17**, e.g., a quality indicator. Some of these signals are force signals, e.g., individual clamp forces F_c and total clamp forces F_t , received from a force sensor **25B**, which are received from the check station **54** (arrow B), as described below with reference to FIGS. 3-5. Further, the host device **40**, may transmit a control signal (arrow **19**) to the robot **50** of FIG. 3 to command proper alignment of the weld head **21** for each weld and/or other positioning of the robot **50** and/or for process monitoring.

The host device **40** of FIGS. 1 and 3 may include, as noted above, the processor **42** and memory **44**. The memory **44** may include any required read only memory (ROM), flash, optical, and/or other non-transitory memory. The host device **40** may also include transitory memory, e.g., any required random access memory (RAM), electrically-programmable read-only memory (EPROM), etc. The host device **40** may also include additional circuitry such as a high-speed clock (not shown), analog-to-digital circuitry, digital-to-analog circuitry, a digital signal processor, and the necessary input/output devices and other signal conditioning and/or buffer circuitry. The host device **40** thus provides the necessary hardware components needed to execute process instructions embodying the present method **100**.

Referring to FIG. 2, in a non-limiting example embodiment, a work piece **130** is shown as a portion of a multi-cell battery having an elongated conductive interconnecting member **45**. A full battery module may include an extended series of interconnecting members **45** arranged side-by-side in multiple rows. Each interconnecting member **45** joins oppositely-charged battery cell tabs **34**, **134**, of adjacent battery cells, with the battery cell tabs **34**, **134** forming individual electrode extensions of a given battery cell. Each battery cell tab **34**, **134** is internally-welded, below an interconnect board **29** to the various anodes or cathodes comprising that particular battery cell, as is well understood by those of ordinary skill in the art. The battery cell tabs **34**, **134** may be welded using the vibration welding equipment **10** of FIG. 1 to a longitudinal side wall **49** of a given interconnecting member **45**, with substantially identical welds **43** formed at each interconnecting member **45**.

Referring to FIG. 3, in an example vibration welding process **33**, the vibration welding equipment **10** of FIG. 1 may be used to form welds on a set of work pieces **30** as the work pieces **30** move along a conveyor **32** in the direction of arrow A. A welding robot **50** may move between the conveyor **32** and the check station **54** as indicated by arrow R. Some components of the vibration welding equipment **10** of FIG. 1 may be disposed on an arm **53** of the robot **50**, including at least the welding horn **14** and welding anvil **16** described above. In normal operation, the robot **50** can be used to form welds on the work pieces **30** as the work pieces **30** move on the conveyor **32**, or alternatively as the robot **50** moves with respect to the work pieces **30**. Periodically, e.g., once per shift or once per a calibrated number of welds, the

5

robot **50** may rotate toward the check station **54** and perform certain condition monitoring steps to determine the status condition of the welder device **12**, including the measurement of a total clamp force F_t and individual clamp forces F_c , applied by the weld pads **21** and anvil pads **23** to the check station. The measured clamp forces F_c are then transmitted as signals B to the host device **40** of FIG. 1, where the signals B are stored in the memory **44**.

Referring to FIG. 4, the check station **54** includes a check fixture **60** having a plurality of force sensors **25B**, each corresponding to a respective weld pad **21** of the welding horn **14**. Therefore, if there are three weld pads **21** on the welding horn **14**, then there would need to be three force sensors **25B** on the check fixture **60**. To test the clamp force F_t , F_c , the welding horn **14** and welding anvil **16** of the welder device **12** are applied to the check fixture **60** with the welding horn **14** and welding anvil **16** in an unclamped position, i.e., the welding horn **14** and welding anvil **16** are not applying a clamp force F_t , F_c . Once applied to the check fixture **60**, the welder device **12** is activated such that the welding horn **14** and welding anvil **16** move toward one another to a clamped position, i.e., the welding horn **14** and welding anvil **16** are applying the clamp force F_t , F_c to the check fixture **60**. The force sensors **25B** may be force transducers, such as compression force sensors, and the like. More specifically, the force sensors **25B** are configured to convert an input mechanical force into an electrical output signal (arrow B). As such, the force sensors **25B** are configured for measuring the individual clamp force F_c and/or the total clamp force F_t applied by the weld pads **21**, **23** of the welding horn **14** and welding anvil **16**. Ultimately, a determination is made as to whether the total clamp force F_t is within an acceptable range. More specifically the total clamp force F_t is a total of individual clamp forces F_c applied by the welding horn **14** and welding anvil **16**. Each individual clamp force F_c corresponds to a respective weld pad **21** of the welding horn **14**. Therefore, two force sensors **25B** will result in the output of force signals B for two individual clamps forces F_c being transmitted to the host device **40**. The total or sum of these two individual clamp forces F_c is the total clamp force F_t applied by the welding horn **14** and welding anvil **16** to the check fixture **60**. The force sensors **25B** should be selected so as to prevent inadvertently being over compressed, and thus damaged, during testing of the welder device **12** on the check fixture **60**. Therefore, each force sensor **25B** needs to be selected to withstand the individual clamp force F_c that may be applied by the respective weld pad **21** and anvil pad **23** during the testing process.

Alignment of the welding horn **14** relative to the welding anvil **16** can also be determined as a function of the relative difference(s) between the individual clamp forces F_c between each weld pad **21** and the corresponding force sensor **25B**. An imbalance in the total clamp force F_t is signified if the relative difference(s) between the individual clamp forces F_c is beyond a defined threshold. Relative difference(s) beyond a defined threshold may be indicative of a misalignment between the welding horn **14** and welding anvil **16**, requiring the orientation of the welding horn **14** and the welding anvil **16** be realigned relative to one another. Therefore, if there are two force sensors **25B** and the difference between the two respective individual clamp forces F_c is greater than the defined threshold, a misalignment between the weld pads **21** and the anvil pad **23** is identified, requiring correction. Failure to correct the alignment between the weld pads **21** and anvil pad **23** may result in non-uniform welds across the workpiece **130**.

6

Referring now to FIG. 4, the check fixture **60** is configured for measuring the total clamp force F_t applied by clamping the welding horn **14** and the welding horn **16** to the check fixture **60**. The check fixture **60** includes a base member **68** and the plurality of the force sensors **25B**. The base member **68** includes a first side **72** and a second side **74**, opposing the first side **72**. The base member **68** has a base thickness **62** defined between the first and second sides **72**, **74**, thin enough to fit between the weld and anvil pads **21**, **23** of the welding horn **14** and welding anvil **16** when applying the welder device **12** to the check fixture **60**. By way of a non-limiting example, the base thickness **62** may be less than 6 millimeters.

A plurality of openings **76** are defined in the base member **68**, between the sides **72**, **74**. The location of each opening **76** is configured to correspond to the location of the respective weld and anvil pads **21**, **23** of the welding horn **14** and welding anvil **16**, when the welder device **12** is applied to the fixture **60**. The force sensors **25B** are disposed in a respective opening **76** such that the base member **68** supports the force sensors **25B**. Referring to FIGS. 4 and 5, the opening **76** may be sized to have a first diameter **84** and the force sensors **25B** may be sized to have a second diameter **78** that is less than the first diameter **84**. This difference between the second diameter **78** and the first diameter **84** allows the force sensors **25B** to float within the openings **76** and compensate for any small misalignments between the welder device **12** and the check fixture **60**. It should be appreciated that while force sensors **25B** and openings **76** shown and described herein are round, force sensors **25B** and openings **76** having other shapes may also be used, as known to those of skill in the art. As already described above, each force sensor **25B** is configured to measure the individual clamp force F_c between the pads **21**, **23** of the welding horn **14** and welding anvil **16**.

Referring to FIG. 4, the base member **68** extends to a ridge **82**. The ridge **82** may be generally rounded in shape so that the ridge **82** acts to guide the welding horn **14** and welding anvil **16** into the proper locations on opposite sides **72**, **74** of the base member **68** as the welder device **12** is applied to the check fixture **60**. As such, the base member **68**, tapers from the first and second sides **72**, **74**, to converge at the ridge **82**.

The plates **70** are operatively attached to each side **72**, **74** of the base member **68** to cover and protect the force sensors **25B** from being damaged through contact with the knurls of the weld and anvil pads **21**, **23**. The plates **70** may be formed from hardened steel to capture and protect the force sensors **25B**. It should be appreciated that the plates **70** may also be made of any other suitable material. The first side **72** and the second side **74** of the base member **68** each define a recess **86** that extends to a respective floor **79**. Each recess **86** is sized to receive a number of plates **70** corresponding to the number of force sensors **25B** and the plates **70** are inserted into the recess **86** such that the plates **70** are disposed therein, along the floor **79** to cover the respective openings **76**. Therefore, if there are two force sensors **25B**, there are two plates **70** disposed in the recess **86** defined in the first side **72** and two plates **70** disposed in the recess **86** defined in the second side **74**.

Referring specifically to FIG. 5, each plate **70** has a length **64** and a width **66**. The length **64** and width **66** are sized to cover the respective opening **76**. This allows the plates **70** to completely cover the respective opening **76**, thus protecting the force sensors **25B** from damage by the pads **21**, **23**. The plates **70** are attached to the base member **68** such that the force sensors **25B** are sandwiched between a corresponding

7

pair of plates 70. Each plate 70 is attached to the base member 68 at a fastening location 88, spaced a distance 90 from a center C of the respective opening 76. The fastening location 88 may be positioned such that the respective opening 76 is defined between the ridge 82 and the fastening location 88. The distance 90 is configured such that the plate 70 is cantilevered relative to the fastening location 88 and transfers the individual clamp force Fc from the weld pad 21 and anvil pad 23 to the respective force sensor 25B. The plates 70 are attached to the base member 68 via a fastener 80 and the like. Once attached to the base member 68, the plates 70 may be substantially flush with the respective side 72, 74 of the base member 68, as shown in FIGS. 4 and 5.

Referring again to FIG. 4, each plate has a plate thickness 46 and each load sensor 25B has a length 48. In order to provide additional accuracy in the measurements of the individual clamp forces Fc, the total of the plate thicknesses 46 of two corresponding plates 70 and the corresponding load sensor 25B should be selected to be a desired total thickness 52.

Further, with continued reference to FIG. 4, a span 56 is defined between the floors 79 of the opposing sides 72, 74 of the base member 68. The length of the load sensor 25B should be sized to be slightly larger than the span 56. This difference in size allows for a compression to take place as the load sensor 25B is sandwiched between the welding horn 14 and welding anvil 16, when the welder device 12 is in the clamped position.

In use, when the welder device 12 is applied to the check fixture 60, the welding horn 14 and welding anvil 16 clamp onto the plates 70 of the check fixture 60 such that the each of the weld pads 21, 23 of the welding horn 14 and welding anvil 16 contact a corresponding plate 70, while being aligned with a respective force sensor 25B. As such, the welding horn 14 and welding anvil 16 apply the individual clamp forces Fc to the respective force sensors 25B, via the respective plates 70, as illustrated in FIG. 4.

Referring again to FIGS. 4 and 5, the check station 54 includes the host device 40 in electrical communication with each of the force sensors 25B. The host device 40 may be attached to the force sensors 25B via wires 94, as shown in FIGS. 4 and 5. Alternatively, the force sensors 25B may be wirelessly connected to the host device 40, e.g., via Bluetooth, WiFi, and the like. The host device 40 is configured to collect data related to the total clamp force Ft and individual clamp forces Fc when the welder device 12 is applied to the check fixture 60 and in the clamped position. The host device 40 may collect the force data Ft, Fc to determine if the forces Ft, Fc are within acceptable limits. More specifically, the data may be stored for the individual clamp forces Fc, as well as the total clamp force Ft. The limits, i.e., upper and lower limits, may be set for each force sensor 25B.

Monitoring each load sensor 25B individually helps to ensure the weld pressure applied at each weld pad 21 is correct. Additionally, determining the total clamp force Ft allows for the diagnosis of at least three different issues within the welding equipment 10. A determination that the total clamp force Ft is too low or too high may indicate an issue with the air pressure that is supplied to the welder device 12, e.g., an air leak, the setting for air pressure is too high or too low, and the like. If the total clamp force Ft is slightly low or slightly high, it may be possible to adjust the air pressure automatically to re-target the total clamp force Ft to a target value. However, if the total clamp force Ft is too far out of the desired range, then a maintenance person should be alerted to correct the pressure of the system 10, if

8

the system is activated based on pneumatics. Further, the host device 40 may be configured to determine the amount of misalignment between the welding horn 14 and welding anvil 16. A determination that the total clamp force Ft is in an acceptable range, yet a difference between the individual clamp forces Fc of different weld pads 21 is too high may signify a misalignment between the welding horn 14 and welding anvil 16. If a misalignment is detected, the welding process must be stopped until the welding horn 14 and welding anvil 16 are realigned with one another. Individual force sensors 25B that have too much or too little clamp force Fc being applied thereto could be indicative of tool wear issues, e.g., one of the weld pads 21 or a portion of the welding pads 21, 23 is more worn than at another location 21, 23. If a detection of uneven wear of the weld pads 21, 23 is made, the welding horn 14 and/or welding anvil should be replaced or repaired. The system 10 may alert a maintenance person to perform this operation.

Referring again to FIG. 5, the first side 72 may define at least one channel 96 that opens to each opening 76. A portion of each wire 94 is routed along the first side 72 of the base member 68 to provide protection to the wires 94. Each wire 94 extends from the respective force sensor 25B, out of the opening 76, and is routed along the channel 96. Therefore, at least a portion of the wires 94 may be sandwiched between the respective plate 70 and a portion of the channel 96 defined in the floor 79 of the recess 86.

Referring again to FIG. 4, the check fixture 60 may be operatively disposed on a table 26 configured to swivel. Such a table may be spring-loaded to facilitate automatic alignment of the check fixture 60 with respect to the welder device 12.

Referring now to FIG. 6, the check fixture 60 may include a guide member 98 configured to assist with guiding the welder device 129 (FIG. 1) into alignment with the check fixture 60 such that the welding horn 14 and welding anvil 16 are on opposite sides 72, 74 of the base member 68 during a manual alignment, i.e., without the use of the robot 50 (FIG. 3). The guide member 98 may be attached to the first side 72 of the base member 68 via one or more fasteners 83 and the like. Alternatively, the guide member may be attached to the second side 74 of the base member 68. The guide member 98 include a pair of bookends 85 disposed in spaced relationship to one another and a beam 87 operatively interconnecting the pair of bookends 85. The bookends 85 and the beam 87 cooperate to define an insertion channel 89 therebetween. The beam 87 presents a first support surface 91 facing the channel 89 and the bookends 85 each present a second support surface 93, each also facing the channel 89. The first and second surfaces 91, 93 cooperate to essentially provide a datum surface to guide the horn 14 and/or anvil into alignment with the plates 70 of the check fixture 60.

An example embodiment of the method 100 will now be described with reference to FIG. 7. Commencing at step 102, welding proceeds in the typical manner. For instance, when manufacturing multi-cell batteries of the type shown in FIG. 2, the conveyor 32 of FIG. 3 may move the work pieces 30 into place in front of the robot 50 shown in the same Figure. The welding horn 14 and the welding anvil 16 of FIG. 1 clamp onto the work piece 30 and form the required welds. During step 102, any of the sensors 25 of FIG. 1 positioned on the vibration welding equipment 10 continue to measure their respective data, including for instance the sensors 25C-25H of FIG. 3, which would be transmitted to the host device 40 (arrow C). As step 102 is ongoing, the method 100 proceeds to step 104.

At step **104**, the host device **40** may reference a timer, or alternatively a counter, in order to determine if a calibrated amount of time or a calibrated number of welding cycles has occurred. In some embodiments, step **104** may be triggered manually, e.g., by an operator at the beginning or end of a shift. If the host device **40** determines that a predetermined/calibrated number or welding cycles has occurred, the method **100** proceeds to step **106**. Otherwise, steps **102** and **104** are repeated.

Step **106** entails rotating the robot **50** (arrow R) of FIG. **3** toward the check station **54**. As part of step **106**, the conveyor **32** of the same Figure is temporarily stopped. The method **100** proceeds to step **108** when the robot **50** has moved the welding horn **14** and the welding anvil **16** into position at the check station **54**.

At step **108**, the host device **40** receives the signals described above with reference to FIG. **3**. The signals measured at the check station **54** of FIG. **3** include the individual clamp forces F_c , as described above. As the measurements are being taken, the method **100** proceeds to step **110**.

Step **110** entails determining if all required clamp force F_c values have been measured by the individual force sensors **25B**. If not, step **108** is repeated. The method **100** proceeds to step **112** once all required measurements have been taken.

At step **112**, the host device **40** adds all recorded values for the individual force sensors F_c together to determine a total clamp force F_t and to determine if the value of the total clamp force F_t falls outside of the band defined by these thresholds. In this manner, the host device **40** determines a condition of the welding equipment **10** as a function of the collective signal B from the sensors **25B**.

The method may then proceed to optional step **114**, where the host device **40** subtracts the recorded values of the individual clamp forces F_c from one another to determine whether the difference is beyond the defined threshold.

Appropriate corrective actions may be taken as part of steps **112** and/or **114** in the event that the values are determined to be outside of their allowable limits. The method **100** then returns to step **102**, with the host device **40** commanding the robot **50** to rotate (arrow R) back toward the conveyor **32** and resume welding operations.

While the best modes for carrying out the disclosure have been described in detail, those familiar with the art to which this disclosure relates will recognize various alternative designs and embodiments for practicing the disclosure within the scope of the appended claims.

The invention claimed is:

1. A check fixture for measuring a total clamp force applied by a welder device having a welding horn and a welding anvil with the welding horn and welding anvil being movable between an unclamped position and a clamped position, the check fixture comprising:

a base member having a first side and a second side, opposing the first side; and

a plurality of force sensors operatively supported by the base member;

wherein the base member and the plurality of force sensors are configured to be received between the welding horn and the welding anvil with the welding horn facing the first side and the welding anvil facing the second side; and

wherein each of the plurality of force sensors is configured to measure an individual clamp force applied thereto by the welding horn and welding anvil when the

base member is received between the welding horn and the welding anvil and the welder device is in the clamped position.

2. The check fixture, as set forth in claim **1**, wherein the base member defines a plurality of openings extending between the first side and the second side; and

wherein each of the plurality of force sensors is disposed in a respective one of the plurality of openings such that the base member operatively supports the plurality of force sensors.

3. The check fixture, as set forth in claim **2**, further comprising a plurality of plates operatively attached to the first and second sides of the base member such that each of the plurality of force sensors is sandwiched between a corresponding pair of the plurality of plates operatively attached to the first and second sides;

wherein the base member, the plurality of plates, and the plurality of force sensors are configured to be received between the welding horn and the welding anvil such that the welding pads of the welding horn face the plurality of plates operatively attached to the first side and with the anvil plates of the welding anvil face the plurality of plates operatively attached to the second side such that each of the plurality of force sensors is configured to measure an individual clamp force applied to the respective pair of the plurality of plates by the respective weld and anvil pads when the welder device is in the clamped position.

4. The check fixture, as set forth in claim **3**, wherein each of the plurality of plates is attached to the base member at a respective fastening location, spaced a distance from a center of the respective opening; and

wherein the distance is configured such that each of the plurality of plates is cantilevered at the respective fastening location and each of the plurality of force sensors is configured to measure an individual clamp force applied thereto by the respective pair of the plurality of plates, via the welding horn and welding anvil, when the base member, the plurality of plates, and the plurality of force sensors are received between the welding horn and welding anvil and the welder device is in the clamped position.

5. The check fixture, as set forth in claim **4**, wherein each of the plurality of force sensors has a size configured such that each of the plurality of force sensors are in contact relationship with the respective pair of the plurality of plates to measure an individual clamp force applied thereto by the respective pair of the plurality of plates, via the welding horn and welding anvil, when the base member, the plurality of plates, and the plurality of force sensors are received between the welding horn and welding anvil and the welder device is in the clamped position.

6. The check fixture, as set forth in claim **5**, wherein the first and second sides each define a recess extending to a floor;

wherein a span is defined between the floors of the opposing first and second sides;

wherein each of the plurality of force sensors is sized to have a length that is larger than the span;

wherein the pairs of the plurality of plates are operatively disposed in the recess corresponding to the respective first and second sides of the base member such that the plurality of plates cover the respective openings and are in contact relationship with the respective one of the plurality of force sensors to measure an individual clamp force applied thereto by the respective pair of the plurality of plates, via the welding horn and welding

11

anvil, when the base member, the plurality of plates, and the plurality of force sensors are received between the welding horn and welding anvil and the welder device is in the clamped position.

7. The check fixture, as set forth in claim 3, further comprising a host device in operative communication with each of the plurality of force sensors;

wherein the host device includes a processor configured to:

receive the individual clamp forces from each of the plurality of force sensors applied thereto by the welding horn and welding anvil when the base member is received between the welding horn and the welding anvil and the welder device is in the clamped position; and

determine the total clamp force for the weld tool by totaling the individual clamp forces for each of the plurality of force sensors.

8. A vibration welding system comprising:

a welder device, including a welding horn and a welding anvil, that is configured to apply a total clamp force and form a weld on a work piece clamped between the welding horn and the welding anvil;

wherein the welding horn includes a plurality of weld pads and the welding anvil includes a plurality of anvil pads disposed in facing relationship to the plurality of weld pads;

a check fixture configured to measure the total clamp force applied by the welder device, the check fixture comprising:

a base member having a first side and a second side, opposing the first side; and

a plurality of force sensors operatively supported by the base member;

wherein the base member and the plurality of force sensors are configured to be received between the weld pads of the welding horn and the anvil pads of the welding anvil with the welding horn facing the first side and the welding anvil facing the second side such that each of the plurality of weld pads and each of the plurality of anvil pads are facing a respective one of the plurality of force sensors; and

wherein each of the plurality of force sensors is configured to measure an individual clamp force applied thereto by the respective weld pad of the welding horn and the respective anvil pad of the welding anvil when the base member is received between the welding horn and the welding anvil and the welder device is clamped.

9. The vibration welding system, as set forth in claim 8, wherein the base member defines a plurality of openings extending between the first side and the second side; and

wherein each of the plurality of force sensors is disposed in a respective one of the plurality of openings such that the base member operatively supports the plurality of force sensors.

10. The vibration welding system, as set forth in claim 9, further comprising a plurality of plates operatively attached to the first and second sides of the base member such that each of the plurality of force sensors is sandwiched between a corresponding pair of the plurality of plates operatively attached to the first and second sides;

wherein the base member, the plurality of plates, and the plurality of force sensors are configured to be received between the welding horn and the welding anvil such that the welding pads of the welding horn face the plurality of plates operatively attached to the first side

12

and with the anvil plates of the welding anvil face the plurality of plates operatively attached to the second side such that each of the plurality of force sensors is configured to measure an individual clamp force applied to the respective pair of the plurality of plates by the respective weld and anvil pads when the welder device is in the clamped position.

11. The vibration welding system, as set forth in claim 10, wherein each of the plurality of plates is attached to the base member at a respective fastening location, spaced a distance from a center of the respective opening; and

wherein the distance is configured such that each of the plurality of plates is cantilevered at the respective fastening location and each of the plurality of force sensors is configured to measure an individual clamp force applied thereto by the respective pair of the plurality of plates, via the welding horn and welding anvil, when the base member, the plurality of plates, and the plurality of force sensors are received between the welding horn and welding anvil and the welder device is in the clamped position.

12. The vibration welding system, as set forth in claim 11, wherein each of the plurality of force sensors has a size configured such that each of the plurality of force sensors are in contact relationship with the respective pair of the plurality of plates to measure an individual clamp force applied thereto by the respective pair of the plurality of plates, via the welding horn and welding anvil, when the base member, the plurality of plates, and the plurality of force sensors are received between the welding horn and welding anvil and the welder device is in the clamped position.

13. The vibration welding system, as set forth in claim 12, wherein the first and second sides each define a recess extending to a floor;

wherein a span is defined between the floors of the opposing first and second sides; wherein each of the plurality of force sensors is sized to have a length that is larger than the span;

wherein the pairs of the plurality of plates are operatively disposed in the recess corresponding to the respective first and second sides of the base member such that the plurality of plates cover the respective openings and are in contact relationship with the respective one of the plurality of force sensors to measure an individual clamp force applied thereto by the respective pair of the plurality of plates, via the welding horn and welding anvil, when the base member, the plurality of plates, and the plurality of force sensors are received between the welding horn and welding anvil and the welder device is in the clamped position.

14. The vibration welding system, as set forth in claim 10, further comprising a host device in operative communication with each of the plurality of force sensors;

wherein the host device includes a processor and tangible, non-transitory memory on which is recorded instructions for monitoring the vibration welding equipment to determine the total clamp force applied by the weld and anvil pads;

wherein the host device is configured to execute the instructions from the memory, via the processor, to thereby:

receive a signal from each of the plurality of force sensors corresponding to the base member being received between the weld pads of the welding horn and the anvil pads of the welding anvil and the welder device being clamped; and

13

process the plurality of signals to determine an individual clamp force corresponding to each of the plurality of force sensors.

15. The vibration welding system, as set forth in claim 14, wherein the host device is further configured to execute the instructions from the memory, via the processor, to thereby:

determine a total clamp force by totaling the plurality of individual clamp forces corresponding to each of the plurality of force sensors.

16. A method for determining a status of a welder device, wherein the welder device includes a welding horn having a plurality of weld pads and a welding anvil having a plurality of anvil pads, the method comprising:

clamping a plurality of force sensors between a respective weld pad of the welding anvil and a respective anvil pad of the welding horn;

transmitting a force signal from each of the plurality of force sensors to a processor, wherein each of the plurality of force signals corresponds to a respective one of the force sensors being clamped between the respective weld pad of the welding horn and the respective anvil pad of the welding anvil;

receiving the plurality of force signals from each of the force sensors in the processor; and

processing the plurality of force signals in the processor to determine an individual clamp force corresponding

14

to each of the plurality of force sensors to thereby determine a status condition of the weld and anvil pads of the vibration welding equipment.

17. A method, as set forth in claim 16, further comprising: determining, in the processor, a total clamp force applied to the plurality of force sensors by the plurality of weld and anvil pads by totaling the plurality of individual clamp forces corresponding to each of the plurality of force sensors; and

determining the total clamp force is not within an acceptable range.

18. A method, as set forth in claim 17, further comprising outputting an indication that the total clamp force applied by the weld pads of the welding horn and the weld pads of the welding anvil is not within the acceptable range.

19. A method, as set forth in claim 16, further comprising: determining a relative difference between at least two of the plurality of individual clamp forces; determining the relative difference between the at least two of the plurality of individual clamp forces is not within an acceptable range.

20. A method, as set forth in claim 19, further comprising outputting an indication that the relative difference between the at least two of the plurality of individual clamp forces is not within the acceptable range.

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