








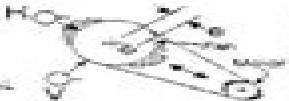






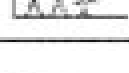





# TABLE I ILLUSTRATED VIBRATION DIAGNOSTIC CHART

PROBLEM SOURCE	TYPICAL SPECTRUM	PHASE RELATIONSHIP	REMARKS
<b>MASS UNBALANCE</b> A. FORCE UNBALANCE			Force unbalance will be in-phase and steady. Amplitude tends to increase with the square of speed below first critical up to speed increase of 50% higher vibration. 1X RPM phase constant and usually dominates spectrum. Can be corrected by placement of one or two correction weights in one plane at Force center of gravity (FCG). Approx. 0° phase difference should exist between CR & FC location (as well as between CR & FC vertical). Also, approx. 90° phase difference between horizontal & vertical readings usually exists at each bearing of unbalanced rotor (180°).
<b>B. COUPLE UNBALANCE</b>			Couple UNB also exists at 180° out-of-phase locations same shaft. 1X RPM always present and normally dominates spectrum. Amplitude varies with square of increasing speed below first critical speed. Speeds may cause high speed vibration as well as noise. Correction requires placement of corrective weights in at least 2 planes. Note that approx. 180° phase difference should exist between CR & FC horizontal, as exists between CR & FC vertical. Also, approx. a 90° difference between 180° horizontal & vertical phase readings at each bearing usually exists (i.e. 270°).
<b>C. DYNAMIC UNBALANCE</b>			Dynamic Unbalance is the dominant type of unbalance found and is a combination of both force and couple unbalance. 1X RPM dominates the spectrum, and may require 2 plane correction. Note, two radial phase difference located 90° apart and radial readings can vary a maximum from 0° to 180° (vertical). The horizontal phase difference should usually match the vertical phase difference, radial readings should exist in 180° bearing measurements (±30°). Separately, if unbalance predominates, roughly a 90° phase difference exists (usually) between the horizontal and vertical readings at each bearing (i.e. 90°).
<b>D. OVERHUNG ROTOR UNBALANCE</b>			Overhung Rotor Unbalance causes high 1X RPM in both axial and radial directions. Axial readings tend to be in-phase unless radial phase readings might be unsteady. However, the horizontal phase difference will usually match the vertical phase difference for the horizontal inner (HRI). Overhung rotors have both force and couple unbalance, each of which will likely require correction. Thus, correction weights will most always have to be placed in 2 planes to counteract both force & couple unbalance.
<b>ECCENTRIC ROTOR</b>			Eccentricity occurs when center of rotation is offset from geometric centerline of a shaft, gear, bearing, motor assembly, etc. Largest vibration occurs at 1X RPM or appears in a direction of rotation or that two planes. Corresponding horizontal and vertical phase readings usually differ either by 0° or by 180° (as of which indicate a straight line reading). Attempts to balance rotating rotors often result in reducing vibration in one radial direction, but increasing it in the other radial direction, depending on amount of eccentricity.
<b>BENT SHAFT</b>			Bent shaft problems cause high axial vibration with phase differences varying between 180° on the same machine components. Primary vibration normally occurs at 1X of bent inner shaft member, but at 2X if bent outer shaft. Coupling the shafts to correct for transducer error before for such axial measurements if you reverse probe direction; use and evaluate for center bent shaft.
<b>MISALIGNMENT</b> A. ANGULAR MISALIGNMENT			Angular Misalignment is characterized by high axial vibration, 180° axial phase across the coupling. Usually will have high axial vibration over 2000 Hz and 2X RPM. However, not unusual for either 1X, 2X, or 3X to dominate. These conditions may also indicate coupling problems as well. Severe angular misalignment may cause shafts 1X RPM vibration. (Under Machine Tool Handbook Type B, there must be tolerance do not typically have a bent shaft but in this case).
<b>B. PARALLEL MISALIGNMENT</b>			Parallel Misalignment has similar vibration symptoms to angular, but shows high axial vibration which approx 90° 180° out-of-phase axial coupling. 2X often larger than 1X, this is helpful reading for 1X is often, instead of by coupling type and construction. Symptom when Angular or Parallel Misalignment readings exist, they also show amplitude peaks at much higher harmonics (2X-50X), derived from forces of higher frequency or harmonics similar in appearance to mechanical looseness. Coupling type and material will often greatly influence the axial spectrum when misalignment is severe. Does not typically have radial noise from.
<b>C. MISALIGNED BEARING COCKED ON SHAFT</b>			Proper bearing fit generates standardized axial vibration. 1X00 causes bearing motion with approximately 180° phase shift top to bottom and noise to side as measured in disk direction on same bearing housing. Attempts to align bearing to improve the noise will not always produce. Bearing usually must be removed and correctly refitted.
<b>RESONANCE</b>			Resonance occurs when a forcing frequency coincides with a System Natural Frequency, and can cause dramatic amplitude amplification, which might result in structural failure. This may be a natural or forced resonance of the rotor, but can also originate from support frame. Resonance peaks occur even after the rotor is at or near resonance, it can be caused by a change in the rotor's mass or stiffness (e.g., a change in the rotor's mass or stiffness, usually 180° when passed this). Often requires changing natural frequency to a higher or lower frequency. Refused the change, do not generally change with a change in system which may become their characteristic (e.g., a large, stiff bearing machine or a soft, with unbalanced significant overhang).

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