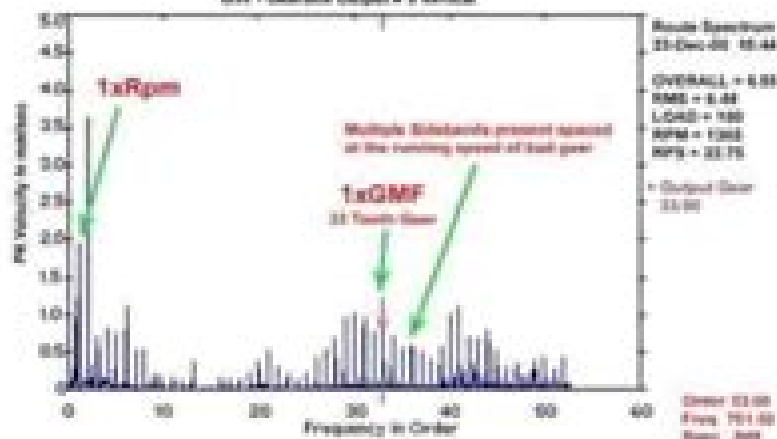
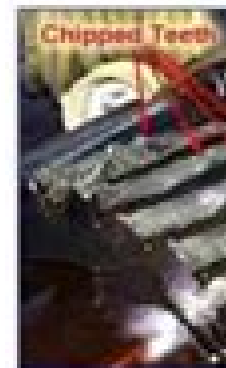
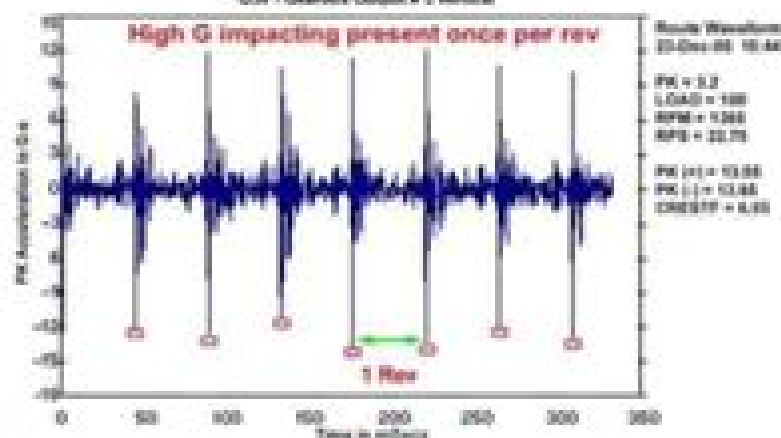


# Chipped / Broken Gear Teeth

Main Plot - GEARBOX NO.22  
G37 - Gearbox Output # 2 Vertical



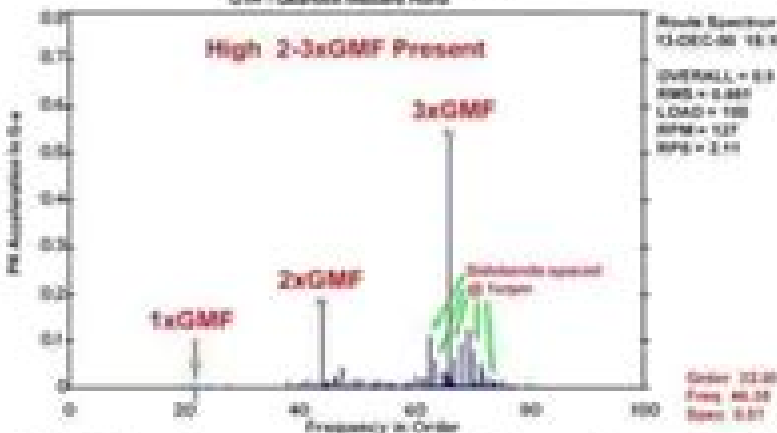
Main Plot - GEARBOX NO.22  
G37 - Gearbox Output # 2 Vertical



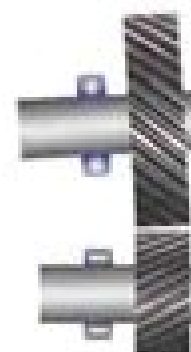
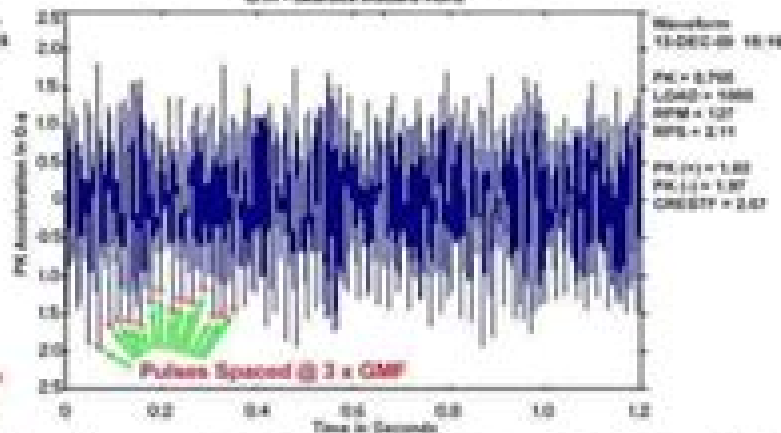
A single chipped or broken gear tooth will produce a 1xRPM vibration. It is difficult to identify this problem using spectral data alone, as the characteristic frequency can easily be confused with other problems occurring at 1xRPM. The way of identifying this problem is by using the time domain, where a once per revolution (1xRPM) impact will be generated falling down from the shaft with the defective gear tooth on. Due to the impacting nature of this fault the time waveform taken in acceleration, ensuring that the time period set-up captures as many shaft revolutions as possible.

## Misaligned Gears

Turbine Hall - Turbo Generator No.2  
G37 - Gearbox Inboard Flange



Turbine Hall - Turbo Generator No.2  
G37 - Gearbox Inboard Flange



Gears mesh at

Misaligned gears will generally produce raised vibration amplitudes at 2xGMF and 3xGMF, which will typically be six times the 1xRPM or 2xRPM. Therefore, it is essential to always capture at least 3.5xGMF when either troubleshooting or taking routine data. In general terms viewing both the time waveform and spectral data in acceleration provides the best representation of the problem.

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