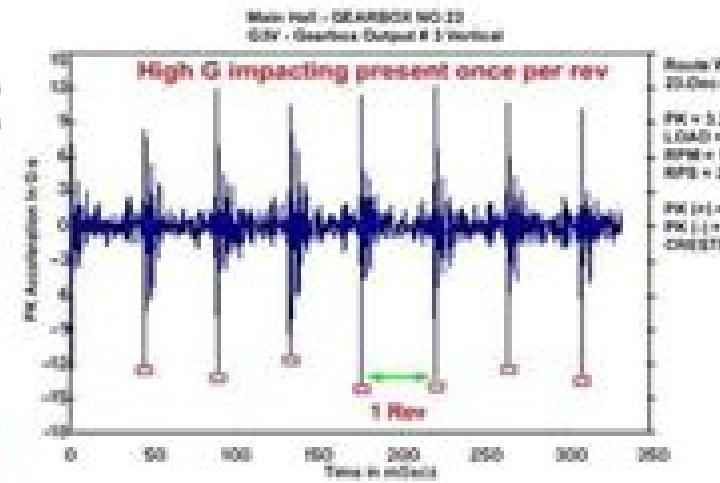
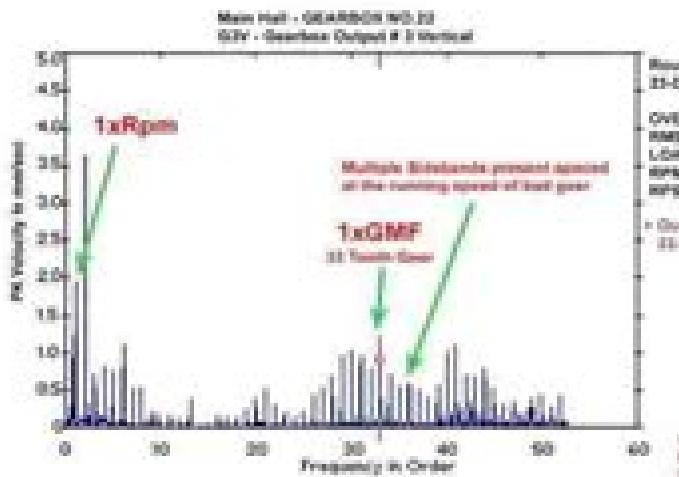
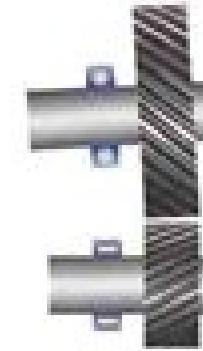
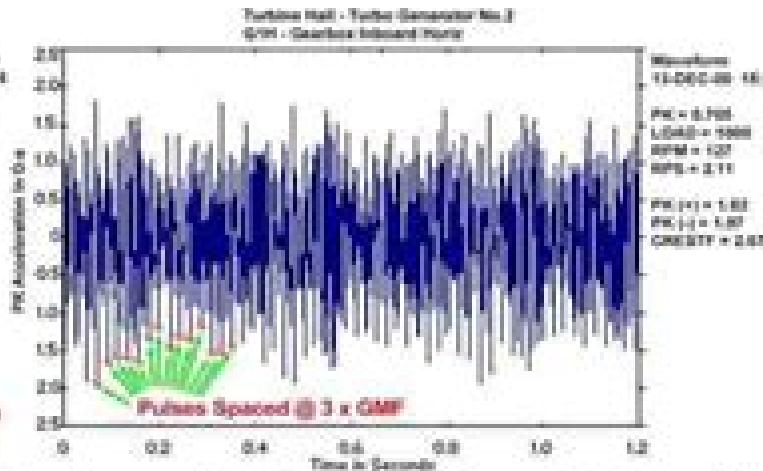
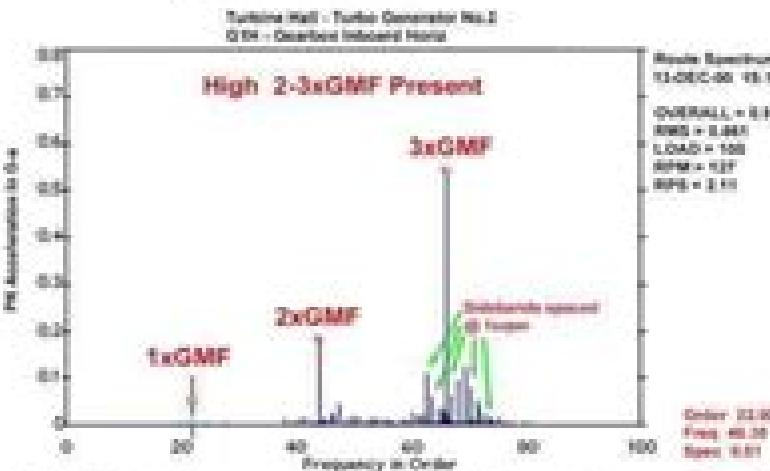


### ***Chipped / Broken Gear Teeth***



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 best way of identifying this problem is by using the time domain, where a once per revolution (1xRPM) impact will be generated by the gear tooth as it passes 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*



### Sample results 2

Misaligned gears will generally produce raised vibration amplitudes at  $2xGMF$  and  $3xGMF$ , which will typically be six  $1xRPM$  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.

# Vibration Analysis Pocket Guide

**British Institute of Non-destructive  
Testing**

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