

TABLE I ILLUSTRATED VIBRATION DIAGNOSTIC CHART

PROBLEM SOURCE	TYPICAL SPECTRUM	PHASE RELATIONSHIP	REMARKS
MASS UNBALANCE A. FORCE UNBALANCE			Force unbalance will be in-phase and steady. Amplitude tends to increase with increase in 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 C8 & 180° locations, as well as between C0 & 180° locations. Also, approx. 90° phase difference between horizontal & vertical readings usually exists at each bearing of unbalanced rotor (C45°).
B. COUPLE UNBALANCE			Couple UNB unbalances act in 180° out-of-phase motion on 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 C8 & 180° locations, as well as between C0 & 180° locations. Also, approx. 90° difference between 180° horizontal & vertical phase readings at each bearing usually exists (C45°).
C. DYNAMIC UNBALANCE			Dynamic unbalance is the dominant type of unbalance found and is a combination of both force and couple unbalances. 1X RPM dominates the spectrum, and may require 2 plane correction. Note, the radial phase difference between horizontal and vertical readings can vary anywhere from 0° to 180°; however, the horizontal phase difference should usually match the vertical phase difference, resulting in 0° or 180° phase difference. Bearing measurements (±30%). Separation of unbalance phenomenon, roughly a 90° phase difference usually exists between the horizontal and vertical readings at each bearing (C45°).
D. OVERHUNG ROTOR UNBALANCE			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 on the horizontal inner (H45°). 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.
ECCENTRIC ROTOR			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 times. Corresponding horizontal and vertical phase readings usually differ either by 0° or by 180° based on which indicates centrifugal motion. 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.
BENT SHAFT			Bent shaft problems cause high axial vibration with phase differences tending toward 180° on the same machine component. 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.
MISALIGNMENT 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 1X 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 high 1X RPM vibration. Unlike flexible coupling misalignment, Type B, there must be bearing noise do not typically have a steady state noise in this condition.
B. PARALLEL MISALIGNMENT			Parallel misalignment has similar vibration symptoms to angular, but shows high axial vibration which approximates 180° out-of-phase axial coupling. 2X often larger than 1X, thus, it helps verify for 1X is often, checked by coupling type and construction. Symptom when Angular or Parallel Misalignment symptoms present, if the coupling amplitude drops at much higher RPMs (500-1000), derated, or if the bearing noise is high, bearing noise 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 steady state noise.
C. MISALIGNED BEARING COCKED ON SHAFT			Proper bearing fit generates standardized axial vibration. 1X RPM 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.
RESONANCE			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, or a change in the forcing frequency to a higher or lower frequency. Refused the vibration, do not generally change with a change in speed, which may indicate that the vibration is caused by a large, stiff bearing housing or a rotor with significant unbalance.

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Ying-Ying Zheng

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