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Mechanical vibration of non-reciprocating machines — Measurements on rotating shafts and evaluation criteria —

Part 1: General guidelines

*Vibrations mécaniques des machines non alternatives — Mesurages sur
les arbres tournants et critères d'évaluation —*

Partie 1: Directives générales



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Foreword

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Draft International Standards adopted by the technical committees are circulated to the member bodies for voting. Publication as an International Standard requires approval by at least 75 % of the member bodies casting a vote.

International Standard ISO 7919-1 was prepared by Technical Committee ISO/TC 108, *Mechanical vibration and shock*, Subcommittee SC 2, *Measurement and evaluation of mechanical vibration and shock as applied to machines, vehicles and structures*.

This second edition of ISO 7919-1 cancels and replaces the first edition (ISO 7919-1:1986), which has been technically revised.

ISO 7919 consists of the following parts, under the general title *Mechanical vibration of non-reciprocating machines — Measurements on rotating shafts and evaluation criteria*:

- *Part 1: General guidelines*
- *Part 2: Large land-based steam turbine generator sets*
- *Part 3: Coupled industrial machines*
- *Part 4: Gas turbine sets*
- *Part 5: Machine sets in hydraulic power generating and pumping plants*

Annex A forms an integral part of this part of ISO 7919. Annexes B, C, D and E are for information only.

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Introduction

Machines are now being operated at increasingly high speeds and loads, and under increasingly severe operating conditions. This has become possible, to a large extent, by the more efficient use of materials, although this has sometimes resulted in there being less margin for design and application errors.

At present, it is not uncommon for continuous operation to be expected and required for 2 or 3 years between maintenance operations. Consequently, more restrictive requirements are being specified for operating vibration values of rotating machinery, in order to ensure continued safe and reliable operation.

ISO 10816-1 establishes a basis for the evaluation of mechanical vibration of machines by measuring the vibration response on non-rotating, structural members only. There are many types of machine, however, for which measurements on structural members, such as the bearing housings, may not adequately characterize the running condition of the machine, although such measurements are useful. Such machines generally contain flexible rotor shaft systems, and changes in the vibration condition may be detected more decisively and more sensitively by measurements on the rotating elements. Machines having relatively stiff and/or heavy casings in comparison to rotor mass are typical of those classes of machines for which shaft vibration measurements are frequently to be preferred.

For machines such as steam turbines, gas turbines and turbo-compressors, all of which may have several modes of vibration in the service speed range, measurements on non-rotating parts may not be totally adequate. In such cases, it may be necessary to monitor the machine using measurements on the rotating and non-rotating parts, or on the rotating parts alone.

The guidelines presented in this part of ISO 7919 are complemented by those given in ISO 10816-1. If the procedures of both standards are applied, the one which is more restrictive generally applies.

Shaft vibration measurements are used for a number of purposes, ranging from routine operational monitoring and acceptance tests to advanced experimental testing, as well as diagnostic and analytical investigations. These various measurement objectives lead to many differences in methods of interpretation and evaluation. To limit the number of these differences, this part of ISO 7919 is designed to provide guidelines primarily for operational monitoring and acceptance tests.

During the preparation of this part of ISO 7919, it was recognized that there was a need to establish quantitative criteria for the evaluation of machinery shaft vibration. However, there is a significant lack of data on this subject at present and, consequently, this part of ISO 7919 has been structured to allow such data to be incorporated as it becomes available.

Specific criteria for different classes and types of machinery will be given in the relevant parts of ISO 7919 as they are developed.

Mechanical vibration of non-reciprocating machines — Measurements on rotating shafts and evaluation criteria —

Part 1: General guidelines

1 Scope

This part of ISO 7919 sets out general guidelines for measuring and evaluating machinery vibration by means of measurements made directly on rotating shafts for the purpose of determining shaft vibration with regard to

- a) changes in vibrational behaviour;
- b) excessive kinetic load;
- c) the monitoring of radial clearances.

It is applicable to measurements of both absolute and relative radial shaft vibration, but excludes torsional and axial shaft vibration. The procedures are applicable for both operational monitoring of machines and to acceptance testing on a test stand and after installation. Guidelines are also presented for setting operational limits.

NOTES

1 Evaluation criteria for different classes of machinery will be included in other parts of ISO 7919 when they become available. In the meantime, guidelines are given in annex A.

2 The term “shaft vibration” is used throughout ISO 7919 because, in most cases, measurements will be made on machine shafts; however, ISO 7919 is also applicable to measurements made on other rotating elements if such el-

ements are found to be more suitable, provided that the guidelines are respected.

For the purposes of ISO 7919, operational monitoring is considered to be those vibration measurements made during the normal operation of a machine. ISO 7919 permits the use of several different measurement quantities and methods, provided that they are well defined and their limitations are set out, so that the interpretation of the measurements will be well understood.

This part of ISO 7919 does not apply to reciprocating machinery.

2 Normative reference

The following standard contains provisions which, through reference in this text, constitute provisions of this part of ISO 7919. At the time of publication, the edition indicated was valid. All standards are subject to revision, and parties to agreements based on this part of ISO 7919 are encouraged to investigate the possibility of applying the most recent edition of the standard indicated below. Members of IEC and ISO maintain registers of currently valid International Standards.

ISO 10816-1:1995, *Mechanical vibration — Evaluation of machine vibration by measurements on non-rotating parts — Part 1: General guidelines*.

3 Measurements

3.1 Measurement quantities

3.1.1 Displacement

The preferred measurement quantity for the measurement of shaft vibration is displacement. The unit of measurement is the micrometer ($1 \mu\text{m} = 10^{-6} \text{ m}$).

NOTE 3 Displacement is a vector quantity and, therefore, when comparing two displacements, it may be necessary to consider the phase angle between them (see also annex D).

Since this part of ISO 7919 applies to both relative and absolute shaft vibration measurements, displacement is further defined as follows:

- a) relative displacement, which is the vibratory displacement between the shaft and appropriate structure, such as a bearing housing or machine casing; or
- b) absolute displacement, which is the vibratory displacement of the shaft with reference to an inertial reference system.

NOTE 4 It should be clearly indicated whether displacement values are relative or absolute.

Absolute and relative displacements are further defined by several different displacement quantities, each of which is now in widespread use. These include:

- $S_{(p-p)}$ vibratory displacement peak-to-peak in the direction of measurement;
- S_{max} maximum vibratory displacement in the plane of measurement.

Either of these displacement quantities may be used for the measurement of shaft vibration. However, the quantities shall be clearly identified so as to ensure correct interpretation of the measurements in terms of the criteria of clause 5. The relationships between each of these quantities are shown in figures B.1 and B.2.

NOTE 5 At present, the greater of the two values for peak-to-peak displacement, as measured in two orthogonal directions, is used for evaluation criteria. In future, as relevant experience is accumulated, the quantity $S_{(p-p)\text{max}}$, defined in figure B.2, may be preferred.

3.1.2 Frequency range

The measurement of relative and absolute shaft vibration shall be broad band so that the frequency spectrum of the machine is adequately covered.

3.2 Types of measurement

3.2.1 Relative vibration measurements

Relative vibration measurements are generally carried out with a non-contacting transducer which senses the vibratory displacement between the shaft and a structural member (e.g. the bearing housing) of the machine.

3.2.2 Absolute vibration measurements

Absolute vibration measurements are carried out by one of the following methods:

- a) by a shaft-riding probe, on which a seismic transducer (velocity type or accelerometer) is mounted so that it measures absolute shaft vibration directly; or
- b) by a non-contacting transducer which measures relative shaft vibration in combination with a seismic transducer (velocity type or accelerometer) which measures the support vibration. Both transducers shall be mounted close together so that they undergo the same absolute motion in the direction of measurement. Their conditioned outputs are vectorially summed to provide a measurement of the absolute shaft motion.

3.3 Measurement procedures

3.3.1 General

It is desirable to locate transducers at positions such that the lateral movement of the shaft at points of importance can be assessed. It is recommended that, for both relative and absolute measurements, two transducers should be located at, or adjacent to, each machine bearing. They should be radially mounted in the same transverse plane perpendicular to the shaft axis or as close as practicable, with their axes within $\pm 5^\circ$ of a radial line. It is preferable to mount both transducers $90^\circ \pm 5^\circ$ apart on the same bearing half and the positions chosen should be the same at each bearing.

A single transducer may be used at each measurement plane in place of the more typical pair of orthogonal transducers if it is known to provide adequate information about the shaft vibration.

It is recommended that special measurements be made in order to determine the total non-vibration runout, which is caused by shaft surface metallurgical non-homogeneities, local residual magnetism and shaft mechanical runout. It should be noted that, for asymmetric rotors, the effect of gravity can cause a false runout signal.

Recommendations for instrumentation are given in annex C.

3.3.2 Procedures for relative vibration measurements

Relative vibration transducers of the non-contacting type are normally mounted in tapped holes in the bearing housing, or by rigid brackets adjacent to the bearing housing. Where the transducers are mounted in the bearing, they should be located so as not to interfere with the lubrication pressure wedge. However, special arrangements for mounting transducers in other axial locations may be made, but different vibration criteria for assessment will then have to be used. For bracket-mounted transducers, the bracket shall be free from natural frequencies which adversely affect the capability of the transducer to measure the relative shaft vibration.

The surface of the shaft at the location of the pick-up, taking into account the total axial float of the shaft under all thermal conditions, shall be smooth and free from any geometric discontinuities (such as keyways, lubrication passages and threads), metallurgical non-homogeneities and local residual magnetism which may cause false signals. In some circumstances, an electroplated or metallized shaft surface may be acceptable, but it should be noted that the calibration may be different. It is recommended that the total combined electrical and mechanical runout, as measured by the transducer, should not exceed 25 % of the allowable vibration displacement, specified in accordance with annex A, or 6 μm , whichever is the greater. For measurements made on machines already in service, where provision was not originally made for shaft vibration measurements, it may be necessary to use other runout criteria.

3.3.3 Procedures for absolute vibration measurements using combined seismic and non-contacting relative vibration transducers

If a combination of seismic and non-contacting relative vibration transducers is used, the absolute vibration is obtained by vectorially summing the outputs from both transducers. The mounting and other requirements for the non-contacting transducer are as specified in 3.3.2. In addition, the seismic transducer

shall be rigidly mounted to the machine structure (e.g. the bearing housing) close to the non-contacting transducer so that both transducers undergo the same absolute vibration of the support structure in the direction of measurement. The sensitive axes of the non-contacting and seismic transducers shall be parallel, so that their vectorially summed, conditioned signals result in an accurate measure of the absolute shaft vibration.

3.3.4 Procedures for absolute vibration measurements using a shaft-riding mechanism with a seismic transducer

The seismic transducer (velocity type or accelerometer) shall be mounted radially on the shaft-riding mechanism. The mechanism shall not chatter or bind in a manner modifying the indicated shaft vibration. The mechanism shall be mounted as described for transducers in 3.3.1.

The shaft surface against which the shaft-riding tip rides, taking into account the total axial float of the shaft under all thermal conditions, shall be smooth and free from shaft discontinuities, such as keyways and threads. It is recommended that the mechanical runout of the shaft should not exceed 25 % of the allowable vibration displacement, specified in accordance with annex A, or 6 μm , whichever is the greater.

There may be surface speed and/or other limitations to shaft-riding procedures, such as the formation of hydrodynamic oil films beneath the probe, which may give false readings and, consequently, manufacturers should be consulted about possible limitations.

3.4 Machine operating conditions

Shaft vibration measurements should be made under agreed conditions over the operating range of the machine. These measurements should be made after achieving agreed thermal and operating conditions. In addition, measurements may also be taken under conditions of, for example, slow roll, warming-up speed, critical speed, etc. However, the results of these measurements may not be suitable for evaluation in accordance with clause 5.

3.5 Machine foundation and structures

The type of machine foundation and structures (for example piping) may significantly affect the measured vibration. In general, a valid comparison of vibration values of machines of the same type can only be made if the foundations and structures have similar dynamic characteristics.

3.6 Environmental vibration and evaluation of measurement system

Prior to measuring the vibration of an operating machine, a check with the same measuring system and stations should be taken with the machine in an in-operative state. When the results of such measurements exceed one-third of the values specified for the operating speed, steps should be taken to eliminate environmental vibration effects.

4 Instrumentation

The instrumentation used for the purpose of compliance with this part of ISO 7919 shall be so designed as to take into account temperature, humidity, the presence of any corrosive atmosphere, shaft surface speed, shaft material and surface finish, operating medium (e.g. water, oil, air or steam) in contact with the transducer, vibration and shock (three major axes), airborne noise, magnetic fields, metallic masses in proximity to the tip of the transducer, and power-line voltage fluctuations and transients.

It is desirable that the measurement system should have provision for on-line calibration of the readout instrumentation and, in addition, have suitable isolated outputs to permit further analysis as required.

5 Evaluation criteria

5.1 There are two principal factors by which shaft vibration is judged:

- a) absolute vibration of the shaft;
- b) vibration of the shaft relative to the structural elements.

5.2 If the evaluation criterion is the change in shaft vibration, then

- a) when the vibration of the structure, on which the shaft-relative transducer is mounted, is small (i.e. less than 20 % of the relative shaft vibration), either the relative shaft vibration or absolute shaft vibration may be used as a measure of shaft vibration;
- b) when the vibration of the structure, on which the shaft-relative transducer is mounted, is 20 % or more of the relative shaft vibration, the absolute shaft vibration shall be measured and, if found to be larger than the relative shaft vibration, it shall be used as the measure of shaft vibration.

5.3 If the evaluation criterion is the kinetic load on the bearing, the relative shaft vibration shall be used as the measure of shaft vibration.

5.4 If the evaluation criterion is stator/rotor clearances, then

- a) when the vibration of the structure, on which the shaft-relative transducer is mounted, is small (i.e. less than 20 % of the relative shaft vibration), the relative shaft vibration shall be used as a measure of clearance absorption;
- b) when the vibration of the structure, on which the shaft-relative transducer is mounted, is 20 % or more of the relative shaft vibration, the relative shaft vibration measurement may still be used as a measure of clearance absorption unless the vibration of the structure, on which the shaft-relative transducer is mounted, is not representative of the total stator vibration. In this latter case, special measurements will be required.

5.5 The shaft vibration associated with a particular classification range depends on the size and mass of the vibrating body, the characteristics of the mounting system, and the output and use of the machine. It is therefore necessary to take into account the various purposes and circumstances concerned when specifying different ranges of shaft vibration for a specific class of machinery. Where appropriate, reference should be made to the product specification.

5.6 General principles for evaluation of shaft vibration on different machines are given in annex A. The evaluation criteria relate to both operational monitoring and acceptance testing, and apply only to the vibration produced by the machine itself and not to vibration transmitted from outside. For certain classes of machinery, the guidelines presented in this part of ISO 7919 are complemented by those given in ISO 10816-1 for measurements taken on non-rotating parts. If the procedures of both International Standards are applied, the one which is more restrictive shall generally apply.

Specific criteria for different classes and types of machinery will be given in the relevant parts of ISO 7919 as they are developed.

5.7 The evaluation considered in this basic document is limited to broad-band vibration without reference to frequency components or phase. This will in most cases be adequate for acceptance testing and operational monitoring purposes. However, in some