

Recommended Practice on Electric Submersible System Vibrations

API RECOMMENDED PRACTICE 11S8
SECOND EDITION, OCTOBER 2012



AMERICAN PETROLEUM INSTITUTE

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Upstream Segment

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Recommended Practice on Electric Submersible Pump System Vibrations

1 Scope

This Recommended Practice (RP) provides guidelines to establish consistency in the control and analysis of electric submersible pump (ESP) system vibrations. This document is considered appropriate for the testing of ESP systems and subsystems for the majority of ESP applications.

This RP covers the vibration limits, testing, and analysis of ESP systems and subsystems.

2 Normative References

The following referenced documents are indispensable for the application of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

API Recommended Practice 11S4, *Recommended Practice for Sizing and Selection of Electric Submersible Pump Installations*

API Recommended Practice 11S7, *Recommended Practice on Application and Testing of Electric Submersible Pump Seal Chamber Sections*

ISO 2372:1974¹, *Mechanical vibration of machines with operating speeds from 10 to 200 rev/s—Basis for specifying evaluation standards* (replaced by 10816-1:1995)

William T. Thompson, *Theory of Vibration*, Prentice-Hall, Inc., Englewood, N. J., 1965, pg. 243.

3 Terms and Definitions

For the purposes of this document, the following definitions apply.

3.1 acceleration

a

A vector quantity that specifies the time rate of change of velocity, both linear and angular. Common units are in./sec² (cm/sec²) and radians/sec².

3.2 amplitude

The maximum value of a periodic quantity.

3.3 angular frequency

circular frequency

The frequency multiplied by 2π , in radians per unit time, applicable to a periodic quantity.

3.4 balancing

A procedure for adjusting the mass distribution of a rotor so that rotating imbalance, as seen by vibration of the journals or the forces on the bearings at once-per-revolution, is reduced or controlled.

¹ International Organization for Standardization, 1, ch. de la Voie-Creuse, Case postale 56, CH-1211 Geneva 20, Switzerland, www.iso.org.

3.5**critical speed**

A speed of a rotating system that corresponds to a natural frequency of the system.

3.6**damping**

The dissipation of energy with time.

3.7**displacement**

d

A vector quantity that specifies the change of position of a body or particle and is usually measured from its position of rest. Displacement is expressed in mils (1 mil = 0.001 in.) or millimeters (1 mm = 10^{-3} m).

3.8**excitation**

An external force (or other input) applied to a system that causes the system to respond in some way.

3.93.9**filter**

An analog or digital device for separating signals on the basis of their frequency. It introduces relatively small loss to signals in one or more frequency bands and relatively large loss to signals at other frequencies.

3.10**forced vibration**

Oscillation of a system if the response is imposed by continuous excitation.

3.11**foundation**

support

A structure that supports the loads of a mechanical system. It may be fixed in space, or it may undergo a motion that provides excitation for the supported system.

3.12**frequency**

f

The reciprocal of the period of a function in time.

NOTE 1 The unit is cycle per unit time.

NOTE 2 The unit cycle per second is called Hertz (Hz).

3.13**fundamental frequency**

The lowest natural frequency of an oscillating system.

3.14

g

The acceleration produced by the force of gravity, which varies with latitude and elevation at the point of observation.

NOTE By international agreement, the value $32.1739 \text{ ft/sec}^2 = 386.087 \text{ in./sec}^2 = 980.665 \text{ cm/sec}^2$ has been chosen as the standard acceleration due to gravity.

3.15**G**

The ratio of local acceleration to the acceleration of gravity.

NOTE For example, an acceleration of 38.6 in./sec² (98.1 cm/sec²) is written as 0.1G.

3.16**isolation**

A reduction in the response of a system to an external excitation, attained by the use of a resilient support.

3.17**natural frequency** **f_n**

A frequency of free vibration of a system.

NOTE There are a large number of natural frequencies in complicated systems, though normally only a few have energy contents high enough to be of concern.

3.18**oscillation**

The time variation of the magnitude of a quantity (e.g. displacement).

3.19**peak-to-peak displacement** **d_{pp}**

The algebraic difference between the extremes of the displacement of a vibrating quantity.

NOTE This is twice the amplitude of the sinusoidal displacement.

3.20**peak velocity**

The maximum velocity occurring during normal sinusoidal displacement.

NOTE Housing or case vibration is normally measured in units of peak velocity.

3.21**period**

The time interval to complete one cycle of sinusoidal oscillation, usually expressed in seconds.

3.22**resonance**

Situation when the forcing frequency is at or near a system natural frequency when a forced vibration exists.

NOTE Any change, however small, in the frequency of excitation results in a decrease in the response of the system.

3.23**rotating speed** **N**

The frequency at which the mechanical system rotates, generally expressed in revolutions per minute (RPM).

3.24**simple harmonic motion**

A motion in which the displacement is a sinusoidal function of time.

NOTE Sometimes it is designated by the term harmonic motion.

3.25**steady-state vibration**

Vibration that exists when period and amplitude are constant.

3.26**stiffness**

The ratio of change of force (or torque) to the corresponding change in translational (or rotational) deflection of an elastic element.

3.27**subharmonic**

A sinusoidal quantity having a frequency that is a fraction of the fundamental frequency.

3.28**synchronous vibration**

The filtered component of vibration at the frequency that corresponds to the machine rotating speed.

3.29**transducer**

pickup

A device that converts vibration or shock motion to an optical, a mechanical, or most commonly to an electrical signal that is proportional to a parameter of the experienced motion.

3.30**velocity**

v

A vector quantity that specifies the time rate of change of displacement with respect to a reference time frame.

3.31**vibration**

A term that describes oscillation in a mechanical system.

3.32**vibration meter**

An apparatus for the measurement of displacement, velocity, or acceleration of a vibrating body.

4 Vibration Analysis**4.1 Harmonic Motion**

A system that experiences simple harmonic motion follows a displacement pattern defined by:

$$D = d_o \sin(2\pi ft) = d_o \sin(\omega t) \quad (1)$$

where

f is the frequency of the simple harmonic motion;

$\omega = 2\pi f$ is the corresponding angular frequency;

t is the time;

d_o is the amplitude of displacement.

The velocity, v , and acceleration, a , of the system are found by differentiating the displacement, d , once and twice, respectively:

$$v = d_o(2\pi f)\cos(2\pi ft) = d_o\omega\cos(\omega t) \quad (2)$$

$$a = -d_o(2\pi f)^2\sin(2\pi ft) = -d_o\omega^2\sin(\omega t) \quad (3)$$

The maximum absolute values of the displacement, velocity, and acceleration of the system undergoing harmonic motion occur when the trigonometric functions in Equation (1), Equation (2), and Equation (3) are numerically equal to unity. These values are known, respectively, as displacement, velocity, and acceleration amplitudes; they are defined mathematically as follows:

$$d_o = d_o \quad v_o = (2\pi f)d_o \quad a_o = (2\pi f)^2 d_o \quad (4)$$

It is common to express the displacement amplitude, d_o , in mils when U.S. Customary (USC) system of units are used and in millimeters when metric (SI) units are used. The velocity amplitude, v_o , is expressed in inches per second in USC units (centimeters per second in SI units). The acceleration amplitude, a_o , usually is expressed in Gs.

Factors for converting values of rectilinear velocity and acceleration to different units are given in Table A.1. Similar factors for angular velocity and acceleration are given in Table A.2.

For certain purposes in analysis, it is convenient to express the amplitude in terms of peak value, the peak-to-peak value, the average value or the root-mean-square (rms) value. These conversion factors are set forth in Table A.3 for ready reference. Peak-to-peak displacement and peak velocity amplitude as a function of frequency are shown graphically in Figure A.1 (in USC units) and in Figure A.2 (in SI units).

The peak-to-peak displacements in terms of simple harmonic motion are given below:

$$d_{pp} = 2\left(\frac{v_p}{2\pi f}\right) \quad d_{pp} = \left(\frac{v_p}{\pi f}\right) \quad (5)$$

$$d_{pp} = 2\left(\frac{a_p}{(2\pi f)^2}\right) \quad d_{pp} = \left(\frac{a_p}{2(\pi f)^2}\right) \quad (6)$$

In USC units:

$$d_{pp} = 318.3\left(\frac{v_p}{f}\right) \quad (7)$$

$$d_{pp} = 50.66\left(\frac{a_p}{f^2}\right) \quad (8)$$

where

d_{pp} is the peak-to-peak displacement (mils);

v_p is the peak velocity (in./sec);

a_p is the peak acceleration (in./sec²);

f is the frequency (Hz).

In SI units:

$$d_{pp} = 3.183 \left(\frac{v_p}{f} \right) \quad (9)$$

$$d_{pp} = 0.5066 \left(\frac{a_p}{f^2} \right) \quad (10)$$

where

d_{pp} is the peak-to-peak displacement (mm);

v_p is the peak velocity (cm/sec);

a_p is the peak acceleration (cm/sec²);

f is the frequency (Hz).

The relationship between displacement, velocity, and acceleration is shown graphically in Annex B.

4.2 Concepts of Vibration

Vibration is a term that describes oscillation in a mechanical system. It is defined by the frequency (or frequencies) and amplitude. An excitation or oscillating force applied to the system is vibration in a generic sense. Conceptually, the ensemble or time-history of vibration may be considered sinusoidal or simple harmonic in form. Although vibration encountered in practice often does not have this regular pattern, it may be a combination of several sinusoidal quantities, each having a different frequency and amplitude. If the vibration ensemble repeats itself after a determined interval of time, the vibration is termed periodic. Mechanical systems experiencing forced vibrations continue under steady-state conditions because energy is supplied to the system continuously to compensate for that dissipated by damping in the system. In a free vibrating system, there is no energy added to the system, but rather the vibration is the continuing result of an initial disturbance. In the absence of damping, free vibration is assumed to continue indefinitely.

In general, the frequency at which energy is supplied (i.e. the forcing frequency) appears in the vibration of the system. The vibration of the system depends upon the relation of the excitation or forcing function to the properties of the system. This relationship is a prominent feature of the analytical aspects of vibration. The technology of vibrations embodies both theoretical and experimental facets. These methods of analysis and instruments for the measurement of vibration are of primary significance. The results of analysis and measurement are used to evaluate vibration environments, to devise testing procedures and instruments, and to design and operate equipment and machinery. The objective is to eliminate or reduce vibration severity or, alternatively, to design equipment to withstand its influences.

4.3 Sources of Vibration

4.3.1 General

Several potential sources of vibration are discussed in the following paragraphs. The correspondence between observed vibratory response frequencies and the likely cause of that response is shown in Table 1.

Table 1—Vibration Analysis of ESP Phenomena

| ESP (Machine) Parts | Response Frequency Relative to ESP Rotating Speed (rpm) | Probable Causes of Problem |
|------------------------------|---|---|
| Rotor and shafts | 1 or 2 × rpm | Bent shaft |
| All rotating parts | 1 × rpm | Mass or hydraulic unbalance or off center rotor |
| Couplings, shafts, bearings | Often 1 to 2 × rpm, sometimes 3 × rpm | Misaligned coupling and/or shaft bearing |
| Sleeve bearing | Less than $\frac{1}{2}$ × rpm | Oil whirl, lightly loaded bearing More prominent in seal chamber section |
| Antifriction bearing | Relatively high, >5 × rpm | Excessive friction, poor lubrication, too tight fit |
| Mechanical rub | $\frac{1}{3}$ or $\frac{1}{2}$ × rpm | Contact between stationary and rotating surfaces |
| Journal bearing rotation | $\frac{1}{2}$ × rpm | Journal rotating with shaft |
| Armature and electric motors | 1 × rpm | Eccentric armature (either OD or journals) |

4.3.2 Mass Unbalance

- a) Dissymmetry due to core shifts in casting, rough surfaces on forging, or unsymmetrical configuration of the ESP system components.
- b) Nonhomogeneous material—General observations include blowholes in castings, inclusions in rolled or forged materials, slag inclusions, or variations in material density.
- c) Eccentricity—Sources of vibration due to eccentricity include:
 - 1) journals not circular or concentric to shaft;
 - 2) bent or bowed shafts;
 - 3) tolerances or clearances of rotating parts may allow eccentricities that result in unbalance (e.g. rotating parts that are too loose);
 - 4) nonconcentric shaft and coupling interfaces;
 - 5) nonuniform thermal expansion.

4.3.3 Misalignment

There are two basic types of misalignment: angular misalignment, where the center lines of the two shafts meet at an angle, and offset misalignment, where the shaft centerlines are parallel but displaced from one another.

Misaligned couplings of shaft bearings can result in transverse vibration (vibration perpendicular to the shaft). Flexible couplings with angular misalignment may produce an axial mode of vibration. This is especially prominent in slender, long shafts. Misalignment may result in large axial vibration.

A characteristic of misalignment and bent shafts is that vibration will occur in both radial and axial directions. In general, whenever the amplitude of axial vibration is greater than 50 % of the highest radial vibration, then misalignment or a bent shaft should be suspected.

4.3.4 Flow Induced

Pump vibration can occasionally be caused by flow through the system. The amplitude usually depends upon where the pump is operated on the head-capacity curve. This normally causes a vibration due to turbulence. In diffuser-type pumps, certain combination of impeller blades and diffuser vanes are more likely to produce vibration than others. Although this phenomenon can produce vibration amplitudes that are unacceptable, especially at rates conducive to cavitation problems, testing indicates that when the pump is operated within its recommended operating range, the impact of turbulence is minimal. Nonsymmetrical fluid passages in a pump can induce hydraulic imbalance that may be seen as a once per revolution vibration. Multiphase flow can also induce vibration.

4.3.5 Journal Bearing Oil Whirl

A condition caused by hydrodynamic forces in lightly loaded journal bearings that results in a vibration at slightly less than one-half (42 % to 48 %) the rotating frequency.

4.3.6 Bearing Rotation

Journal bearings that are not properly secured can rotate with the shaft and produce vibration at one-half rotating frequency.

4.3.7 Mechanical Rub

Contact between the rotating and stationary surfaces results in a vibration at a frequency normally $1/3$ to $1/2$ the operating speed. Natural frequencies may be excited.

4.4 Control of Vibration

4.4.1 General

Methods of vibration control may be grouped into three broad categories: reduction at the source, isolation of external sources, and reduction of the response.

4.4.2 Reduction at the Source

Methods of vibration control in this category include the following.

- a) *Balancing of rotating masses*—Where vibration results from the unbalance of rotating components, the magnitude of the vibratory forces, and hence the vibration amplitude, can often be reduced by balancing.
- b) *Balancing of magnetic forces*—Vibratory forces arising in magnetic effects of electrical machinery are minimized by proper design and fabrication of the stator and rotor, details of which are beyond the scope of this RP.
- c) *Control of clearances*—Vibration can result when ESP system components and parts, operating within the clearances that exist between them, strike each other or otherwise come into impact-type contact during operation. Vibrations from this source can be minimized by avoiding excessive bearing clearances and by ensuring that dimensions of manufactured parts are within acceptable tolerances.

- d) *Straightness of rotating shaft*—Rotating shafts should be as straight as practical since lack of shaft straightness will have a large effect on system vibrations.

4.4.3 Isolation of External Sources

Other machines or equipment, unless properly isolated, may transmit vibration to an ESP under test or in operation. For example, a horizontal pump delivering high-pressure water may experience vibration interference from neighboring pumps and drivers through the foundation. Accepted practice is to avoid the structure's natural frequency by approximately 25 % above or below.

Isolation of equipment being tested is the responsibility of the tester. Isolation of equipment in service is the responsibility of the user.

4.4.4 Reduction of the Response

Methods of vibration control in this category include the following.

- a) *Alteration of natural frequency*—If a natural frequency of the system coincides with the frequency of the excitation, the vibration condition may be made much worse as a result of resonance. Under such circumstances, if the frequency of the excitation is substantially constant, it often is possible to alleviate the vibration by changing the natural frequency of such system. This generally involves modifying mass and/or stiffness of the system.
- b) *Operating at nonresonant frequencies*—Sometimes ESPs are operated with variable speed drives. Operation at a frequency corresponding to a critical speed should be avoided to minimize damage to the system.
- c) *Additional damping*—The vibration response of a system operating at resonance is strongly related to the amount of damping present. Techniques are available to increase the amount of damping. The addition of damping decreases unit efficiency.

4.5 Vibration in ESP Systems

4.5.1 General

The potential for vibrational problems is inherent with any rotating equipment having an extreme shaft length-to-diameter ratio such as an ESP system, consisting of a motor, seal chamber section, gas separator, and pump(s) all connected by a small-diameter, high-strength, coupled shaft. Recognizing that all ESP machinery operates in some state of unbalance, a reasonable displacement amplitude for new equipment should be established to allow a margin for deterioration in service. Guidelines are set forth in the following.

4.5.2 Vibration Modes

Vibration modes can be axial, lateral (transverse), torsional, or combinations of all three. Torsional vibration is known to be a potential problem, particularly when starting and when changing speeds. Axial and transverse vibrations on shaft seals and thrust bearings may be important under certain circumstances.

4.5.3 Critical Speeds

Torsional and lateral critical speeds exist in ESP systems. If possible, operation of the ESP near a critical speed for an extended period of time should be avoided. When this problem is identified over specific, planned rotating frequencies, alteration of the response may be in order and should be addressed. This problem may be particularly acute when the ESP is operated over a wide speed range or during start-up.

Torsional critical speeds for the ESP system are generally calculated for the system as an entity by the Holtzer method (*Shock and Vibration Handbook*, Third Edition, McGraw-Hill, pp. 38–39) and can be furnished by the manufacturer for a specific system configuration.

Lateral critical speeds for the ESP system can be calculated using either eigenvalue or Myklestad-Prohl (*Theory of Vibration*, William T. Thompson, Prentice-Hall, Inc., Englewood, N. J., 1965, pg. 243).

5 Vibration Testing

5.1 Vibration Limits

It is generally acknowledged that severe vibration can decrease ESP system run life. Annex C contains general industrial guidelines for assessing vibration severity. Vibration limits for ESPs are given below.

For ESP systems or components, a maximum velocity amplitude of 0.156 in./sec (0.396 cm/sec)—peak at the intended synchronous operating frequency or over the range of intended operating frequencies, with no other individual frequency component greater than 0.100 in./sec (0.254 cm/sec)—peak as measured on the housing or case, is recommended. For pumps, the vibration limit should be applied over the manufacturer's recommended operating flow range (refer to API 11S2-1997, Section 2.1.10).

Velocity measurements should be made in accordance with 5.2. The relationship between displacement, velocity, and acceleration amplitudes is given by Equation (4).

Accuracy and calibration of the measuring system should be considered when establishing vibration test acceptance limits.

Before testing, each component should be serialized. During testing, the frequencies of critical speeds should be recorded for future reference. Operation at critical speeds is not recommended.

5.2 Measurement of Vibration

5.2.1 General

Generally the ESP system components are vibration tested in the new condition and the baseline results saved for future comparisons to determine the need to replace or the ability to continue to use each component. The first step in establishing a condition-monitoring program for rotating machinery is to determine what shall be measured: shaft vibration or bearing vibration. When the shaft is accessible, then the displacement amplitude at the shaft is measured with a displacement transducer such as a proximity probe. For ESP system components, accessibility to the shaft is difficult and therefore one must rely on measurement of acceleration or velocity amplitudes at a suitable location on the component housing (bearing). Transducers have moving parts and thus may be orientation sensitive. They should be mounted in a manner that will provide accurate, repeatable measurements.

5.2.2 Transducers

5.2.2.1 General

Normally there are three types of transducers used for measuring vibrations. These are accelerometers, velocity probes, and proximity probes. Transducers should be properly calibrated before use.

5.2.2.2 Accelerometers

Accelerometers generally exhibit excellent linearity of electrical output vs input acceleration under normal usage; a dynamic range of 10,000 to 1 or more is not uncommon. Accelerometers are relatively insensitive to temperature and

magnetic influences and generally have a wide frequency response range (10 Hz to 10,000 Hz). It is common to obtain the velocity and displacement amplitudes by mathematically integrating the acceleration signal. Below 15 Hz, integrated displacement values may be suspect.

5.2.2.3 Velocity Probes

Velocity probes measure velocity directly. These transducers have a useful frequency range of approximately 10 Hz to 3000 Hz.

5.2.2.4 Proximity Probes

Proximity probes, which could be mounted within the machinery housing to measure the relative displacement between the shaft and the housing, are not usually used to measure ESP vibration because of the difficulties associated with mounting them.

5.2.3 Selection of Measurement Location

5.2.3.1 General

Vibration measurements should be taken at several bearing locations along each of the ESP system components when they are tested.

5.2.3.2 Pump

It may be advantageous to conduct the vibration test along with the pump acceptance test recommended in API 11S2 on ESP pumps. At a minimum, vibration measurements should be taken at the midpoint on the housing, top radial bearing location, and bottom radial bearing location. Pump rate should be held constant while measurements are being taken.

5.2.3.3 Gas Separator/Intake

At a minimum, vibration measurements should be taken at the midpoint on the housing, top radial bearing location, and bottom radial bearing location.

5.2.3.4 Seal Section

At a minimum, vibration measurements should be taken at the midpoint on the housing, top radial bearing location, and bottom radial bearing location.

5.2.3.5 Motor

At a minimum, vibration measurements should be taken at the midpoint on the housing, top radial bearing location, and bottom radial bearing location.

5.2.4 Test Drive Motor

Caution must be exercised in component testing. The test drive motor will contribute to the measured vibration amplitude. To minimize this effect, a well-balanced test drive motor should be used.

Annex A (informative)

Units Conversion

Table A.1—Conversion Factors for Translational Velocity and Acceleration

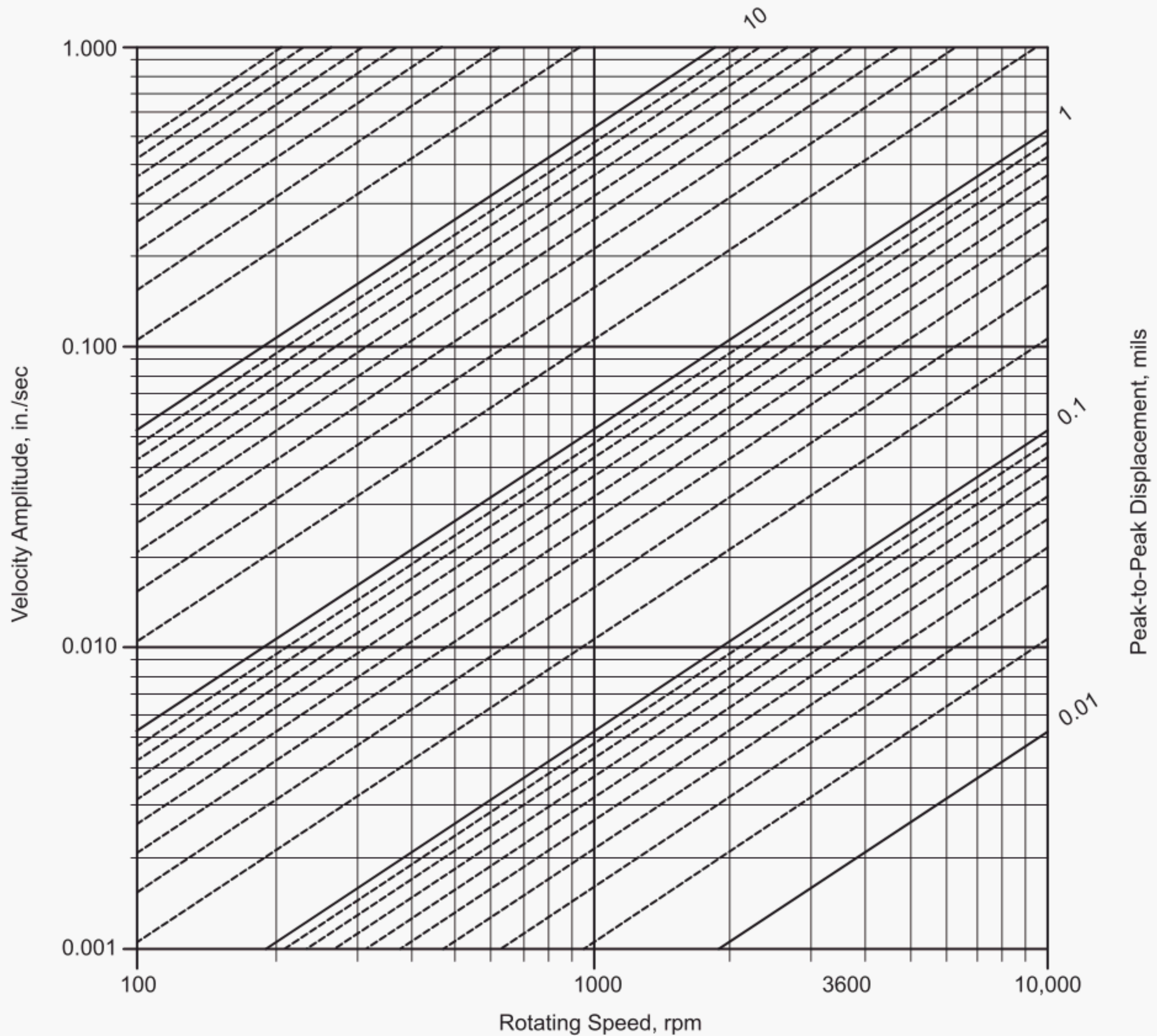
| <div style="display: inline-block; text-align: right; vertical-align: middle;"> Multiply Value in → or in → To Obtain Value in ↓ </div> | | g-sec g | ft/sec ft/sec ² | in./sec in./sec ² | cm/sec cm/sec ² |
|--|--|------------|-------------------------------|---------------------------------|-------------------------------|
| g-sec g | | 1 | 0.311 | 0.00259 | 0.00102 |
| ft/sec ft/sec ² | | 32.16 | 1 | 0.0833 | 0.0328 |
| in./sec in./sec ² | | 386 | 12 | 1 | 0.3927 |
| cm/sec cm/sec ² | | 980 | 30.48 | 2.54 | 1 |

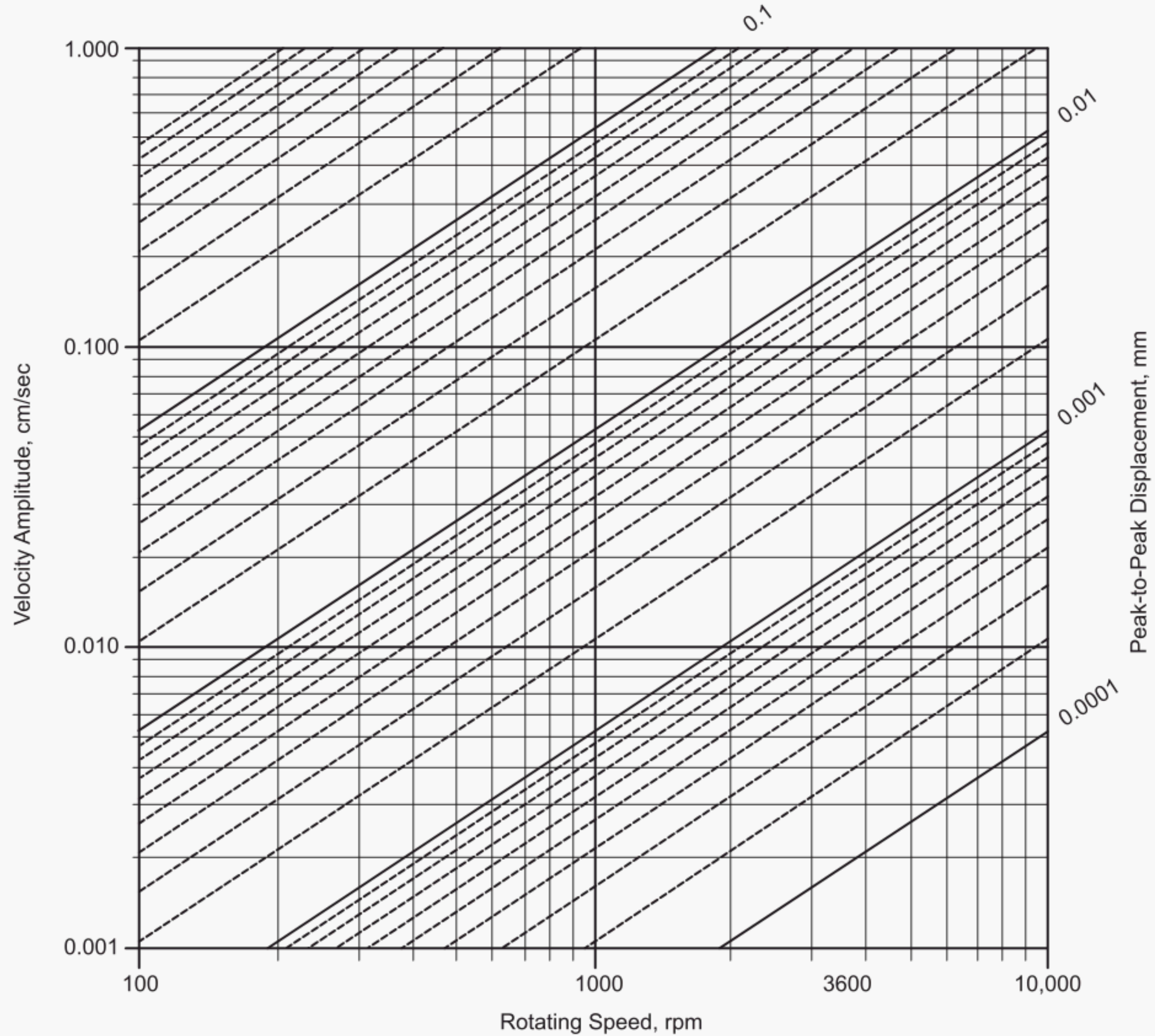
Table A.2—Conversion Factors for Rotational Velocity and Acceleration

| <div style="display: inline-block; text-align: right; vertical-align: middle;"> Multiply Value in → or in → To Obtain Value in ↓ </div> | | rad/sec rad/sec ² | degree/sec degree/sec ² | rev/sec rev/sec ² | rev/min rev/min/sec |
|--|--|---------------------------------|---------------------------------------|---------------------------------|------------------------|
| rad/sec rad/sec ² | | 1 | 0.01745 | 6.283 | 0.1047 |
| degree/sec degree/sec ² | | 57.30 | 1 | 360 | 6 |
| rev/sec rev/sec ² | | 0.1592 | 0.00278 | 1 | 0.0167 |
| rev/min rev/min/sec | | 9.549 | 0.1667 | 60 | 1 |

Table A.3—Conversion Factors for Simple Harmonic Motion

| <div style="display: inline-block; text-align: center;"> <div style="transform: rotate(-45deg);">Multiply Value in Terms of →</div> <div style="transform: rotate(45deg);">To Obtain Value in Terms of ↓</div> </div> | Amplitude | Root-Mean-Square Value (rms) | Peak-to-Peak Value |
|---|-----------|---------------------------------|--------------------|
| Amplitude | 1 | 1.414 | 0.5 |
| Root-Mean-Square Value (rms) | 0.707 | 1 | 0.354 |
| Peak-to-Peak Value | 2 | 2.828 | 1 |

**Figure A.1—Relation of Frequency to the Amplitudes of Displacement and Velocity (USC Units)
(Normal Synchronous Speed of 3600 rpm is Shown as a Dashed Reference Line)**



**Figure A.2—Relation of Frequency to the Amplitudes of Displacement and Velocity (SI Units)
(Normal Synchronous Speed of 3600 rpm is Shown as a Dashed Reference Line)**

Annex B (informative)

Relationship Between Displacement, Velocity, and Acceleration

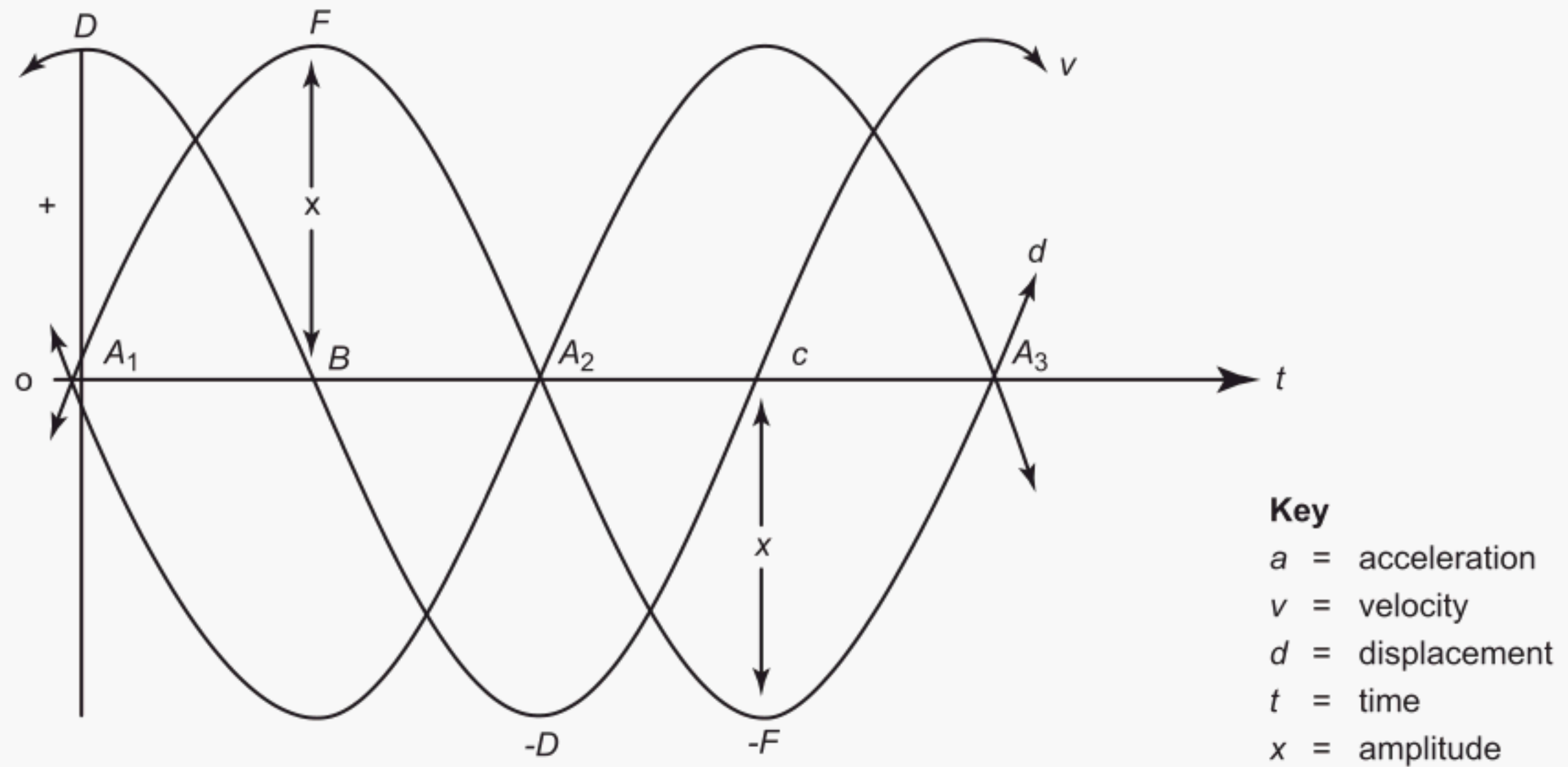


Figure B.1—Displacement, Velocity, and Acceleration Relationship

At position D , the velocity (v) is at its maximum; it approaches position B where the velocity is zero and continues in a negative direction to position $-D$, another maximum, then toward position C , where its velocity is zero. Then it continues on toward D at maximum velocity. The time interval for this total motion from D to B to $-D$ to C to D is one period. Notice the displacement (d) curve. At A_1 , the displacement amplitude (d_0) is zero; it approaches maximum amplitude at F and reverses direction toward A_2 again where it approaches zero. The displacement continues toward position $-F$ or maximum amplitude again and finally reaches one complete period at A_3 . Notice that the acceleration (a) curve follows the same pattern as displacement, except that the curve is generated in the negative direction, because of the change in velocity direction at B and C . The peak velocity (v_p) is denoted each time it passes through position D . Displacement has two peak amplitudes (x), namely at positions F and $-F$, and therefore is measured in terms of peak-to-peak displacement ($d_{pp} = 2x$).

Annex C

(informative)

Classification of Severity of Machinery Vibration

C.1 General

In the classification of severity of machinery vibration, the amplitude variable that is used (displacement, velocity, or acceleration) depends on the type of standard, the frequency range, and other factors. The International Organization of Standardization (ISO) has a special measure, vibration severity, which is defined as the highest value of the broad-band, velocity amplitude in the frequency range from 10 to 1000 Hz as evaluated on the structure at prescribed points (bearing caps or pedestals).

C.2 ISO IS 2372

ISO Standard 2372 applies to rotating machinery having rigid rotors and to those machines having flexible rotors in which bearing cap vibration is a measure of the shaft motion. Table C.1 lists the allowable vibration severity along with a corresponding peak-to-peak displacement amplitude calculated at 3600 rpm.

Table C.1—Vibration Severity Criteria (After ISO IS 2372: 1974)

| Peak Velocity Ranges of Vibration Severity | | Vibration Severity | Peak-to-Peak Displacement Amplitude @ 3600 rpm | |
|---|--------|---------------------------|---|---------|
| in./sec | cm/sec | | mils | mm |
| <0.014 | <0.036 | Extremely smooth | <0.074 | <0.0019 |
| 0.028 | 0.071 | Very smooth | 0.148 | 0.0038 |
| 0.042 | 0.107 | Smooth | 0.233 | 0.0057 |
| 0.057 | 0.145 | Very good | 0.302 | 0.0077 |
| 0.099 | 0.251 | Good | 0.525 | 0.0133 |
| 0.156 | 0.396 | Fair | 0.828 | 0.0210 |
| 0.255 | 0.648 | Slightly rough | 1.353 | 0.0344 |
| 0.396 | 1.006 | Rough | 2.101 | 0.0534 |
| 0.622 | 1.580 | Very rough | 3.300 | 0.0838 |
| >0.622 | >1.580 | Extremely rough | >3.300 | >0.0838 |

C.3 IRD Mechanalysis Severity Criteria

An accepted guide for vibrational evaluation is shown in Table C.2 and is based on filtered reading taken on the machine structure or bearing cap.

Table C.2—Vibration Severity Criteria (After Training Manual IRD Mechanalysis, Columbia, Ohio)

| Peak Velocity Ranges of Vibration Severity | | Vibration Severity | Generalization | Peak-to-Peak Displacement Amplitude @ 3600 rpm | |
|--|---------|--------------------|--------------------------|--|---------|
| in./sec | cm/sec | | | mils | mm |
| <0.0049 | <0.0124 | Extremely smooth | Well-balanced system | <0.026 | <0.0007 |
| 0.0097 | 0.0246 | Very smooth | | 0.051 | 0.0013 |
| 0.0195 | 0.0495 | Smooth | Normal for new equipment | 0.103 | 0.0026 |
| 0.0391 | 0.0993 | Very good | | 0.207 | 0.0053 |
| 0.0784 | 0.1991 | Good | Minor faults | 0.416 | 0.0106 |
| 0.1560 | 0.3962 | Fair | Correct to save wear | 0.828 | 0.0210 |
| 0.3130 | 0.7950 | Slightly rough | Cause major wear | 1.661 | 0.0422 |
| 0.6270 | 1.5925 | Rough | Premature breakdown | 3.326 | 0.0845 |
| >0.627 | >1.5925 | Very rough | Shut down | >3.326 | >0.0845 |
| ^a Nonharmonic (noninteger multiples). | | | | | |

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² International Organization for Standardization, 1, ch. de la Voie-Creuse, Case postale 56, CH-1211 Geneva 20, Switzerland, www.iso.org.

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