

# Table of contents

|                                                                                         |    |
|-----------------------------------------------------------------------------------------|----|
| <b>Preface</b> .....                                                                    | ix |
| <b>1 Introduction</b> .....                                                             | 1  |
| 1.1 Origin of machinery diagnostics and vibroacoustical diagnostics .....               | 1  |
| 1.1.1. Machine diagnostics .....                                                        | 2  |
| 1.1.2 Vibroacoustical diagnosis .....                                                   | 4  |
| 1.2 Possibilities of machine condition testing<br>and vibroacoustical diagnostics ..... | 5  |
| 1.3 The place of vibroacoustical diagnostics in machine life .....                      | 9  |
| 1.3.1 Design diagnostics .....                                                          | 9  |
| 1.3.2 Checkout diagnostics .....                                                        | 11 |
| 1.3.3 Condition monitoring .....                                                        | 12 |
| 1.3.4 Diagnostics of production processes.....                                          | 13 |
| <b>2 Generation of vibroacoustical phenomena and wear processes</b> .....               | 19 |
| 2.1 Introduction .....                                                                  | 19 |
| 2.2 Sources of vibroacoustical processes in machinery .....                             | 19 |
| 2.2.1 Unbalance .....                                                                   | 20 |
| 2.2.2 Misalignment of shafts, couplings clearances .....                                | 23 |
| 2.2.3 Critical rotations of the second order .....                                      | 24 |
| 2.2.4 Self-excited vibrations of bearings .....                                         | 25 |
| 2.2.5 Rolling bearings as the sources of vibrations .....                               | 26 |
| 2.2.6 Toothed gears .....                                                               | 27 |
| 2.2.7 Magnetic sources of machine vibrations .....                                      | 28 |
| 2.2.8 Motion of the working medium .....                                                | 29 |
| 2.2.9 Cavitation .....                                                                  | 31 |
| 2.2.10 Frictional vibrations .....                                                      | 31 |
| 2.2.11 Acoustical emission .....                                                        | 32 |
| 2.2.12 Range of vibroacoustical phenomena<br>in machinery and structures .....          | 35 |
| 2.3 Machine wear and vibroacoustical phenomena .....                                    | 35 |
| 2.3.1 Introduction .....                                                                | 35 |

|          |                                                                                                    |            |
|----------|----------------------------------------------------------------------------------------------------|------------|
| 2.3.2    | Fatigue wear .....                                                                                 | 36         |
| 2.3.3    | Frictional wear .....                                                                              | 39         |
| 2.3.4    | Cavitation wear .....                                                                              | 41         |
| 2.3.5    | Changes of form-creep .....                                                                        | 42         |
| 2.3.6    | Tribovibroacoustical model of a machine.....                                                       | 44         |
| 2.4      | Summary .....                                                                                      | 46         |
| <b>3</b> | <b>Failure-oriented process signals and<br/>measures of vibroacoustical phenomena .....</b>        | <b>49</b>  |
| 3.1      | Introduction .....                                                                                 | 49         |
| 3.2      | Observation models of tribovibroacoustical phenomena in machines ...                               | 49         |
| 3.2.1    | Failure life.....                                                                                  | 50         |
| 3.2.2    | Model of diagnostic observation of an object-<br>vibroacoustical signal .....                      | 51         |
| 3.2.3    | Measures of vibroacoustical signals-<br>symptoms, discriminants .....                              | 52         |
| 3.2.4    | Observation area of vibroacoustical processes<br>in machinery diagnostics .....                    | 54         |
| 3.3      | Selection of the diagnostically useful vibroacoustical processes .....                             | 56         |
| 3.3.1    | A tribological model of the generation<br>and propagation of vibroacoustical phenomena .....       | 57         |
| 3.3.2    | Generation of diagnostic signals .....                                                             | 59         |
| 3.3.3    | Selection of the observed vibroacoustical<br>process as the source of diagnostic information ..... | 61         |
| 3.4      | Selection of vibroacoustical signals .....                                                         | 66         |
| 3.4.1    | Spatial selection .....                                                                            | 67         |
| 3.4.2    | Time selection of vibroacoustical signals.....                                                     | 68         |
| 3.4.3    | Spectral selection .....                                                                           | 69         |
| 3.4.4    | Selection of vibroacoustical signal by demodulation .....                                          | 73         |
| 3.4.5    | Decomposition of signals<br>and periodic adaptational filtration .....                             | 76         |
| 3.5      | Diagnostic measures of vibroacoustical<br>signals and their application .....                      | 80         |
| 3.5.1    | Introduction .....                                                                                 | 80         |
| 3.5.2    | Amplitudes of noise and vibration<br>in the diagnostics of simple machines .....                   | 81         |
| 3.5.3    | Special point estimators of vibroacoustical processes .....                                        | 87         |
| 3.5.4    | Spectral and kinematic analyses<br>in vibroacoustical diagnostics .....                            | 92         |
| 3.5.5    | Special functional spectral measures of<br>vibroacoustical processes .....                         | 98         |
| 3.5.6    | Spectral sensitivity of the measures<br>of vibroacoustical processes .....                         | 103        |
| 3.6      | Summary .....                                                                                      | 105        |
| <b>4</b> | <b>Diagnostic inference .....</b>                                                                  | <b>107</b> |
| 4.1      | Introduction .....                                                                                 | 107        |

|          |                                                                                                                       |            |
|----------|-----------------------------------------------------------------------------------------------------------------------|------------|
| 4.2      | Diagnostic models and decisions concerning<br>the condition of mechanical objects .....                               | 108        |
| 4.2.1    | Diagnostic regression model.....                                                                                      | 108        |
| 4.2.2    | Covert model of image type .....                                                                                      | 111        |
| 4.2.3    | Probabilistic diagnostic model of a mechanical object.....                                                            | 113        |
| 4.2.4    | Accuracy of diagnostic decisions .....                                                                                | 118        |
| 4.3      | The limit value of the symptom of the first class condition .....                                                     | 121        |
| 4.3.1    | Introduction .....                                                                                                    | 121        |
| 4.3.2    | Life curve of object and limit value of symptom .....                                                                 | 121        |
| 4.3.3    | Limit value in the passive diagnostic experiment.....                                                                 | 123        |
| 4.4      | Simple and generalized condition symptoms—<br>filtration of disturbance .....                                         | 126        |
| 4.4.1    | Introduction .....                                                                                                    | 126        |
| 4.4.2    | Linear averaging in respect to<br>utilization time and the object's span .....                                        | 127        |
| 4.4.3    | Geometrical averaging—cumulants .....                                                                                 | 131        |
| 4.5      | Condition prognosis .....                                                                                             | 137        |
| 4.5.1    | Introduction .....                                                                                                    | 137        |
| 4.5.2    | Prognosis according to a known condition —<br>symptom model.....                                                      | 139        |
| 4.5.3    | Condition prognosis with an unknown trend model .....                                                                 | 143        |
| 4.6      | Summary .....                                                                                                         | 147        |
| <b>5</b> | <b>Examples of the implementation of diagnostics in industry .....</b>                                                | <b>149</b> |
| 5.1      | Introduction .....                                                                                                    | 149        |
| 5.2      | General scheme of the implementation<br>of vibroacoustical diagnostics .....                                          | 149        |
| 5.3      | Diagnostics of high-power fans in power engineering .....                                                             | 151        |
| 5.4      | Diagnostics of diesel traction engines .....                                                                          | 155        |
| 5.5      | Diagnostics of godets of textile machines .....                                                                       | 158        |
| 5.6      | Diagnostics of electric motors .....                                                                                  | 159        |
| 5.7      | Summary .....                                                                                                         | 159        |
| <b>6</b> | <b>Advanced problems of vibroacoustical diagnostics .....</b>                                                         | <b>161</b> |
| 6.1      | Introduction .....                                                                                                    | 161        |
| 6.2      | Diagnostic experiments .....                                                                                          | 161        |
| 6.3      | Discrimination of vibroacoustical condition<br>characteristics and classification in a passive experiment .....       | 163        |
| 6.3.1    | BEDIND—algorithm of discrimination and classification.....                                                            | 164        |
| 6.3.2    | Discrimination of characteristic features<br>by the orthogonalization method of<br>observation vector components..... | 170        |
| 6.4      | Recognition of condition .....                                                                                        | 171        |
| 6.5      | Discrimination of failure signals .....                                                                               | 173        |
| 6.5.1    | Adaptive noise cancelling .....                                                                                       | 174        |
| 6.5.2    | Orthogonal filtration of signals.....                                                                                 | 176        |
| 6.5.3    | Diagnostic filtration of signals .....                                                                                | 178        |

|                         |                                                            |     |
|-------------------------|------------------------------------------------------------|-----|
| 6.6                     | Summary .....                                              | 181 |
| <b>Appendices</b>       |                                                            |     |
| A1                      | Important standards of machine vibration diagnostics ..... | 183 |
| A2                      | Diagnostic chart of rotary motion machines .....           | 188 |
| A3                      | Criteria of rotor balance .....                            | 195 |
| A4                      | Computation nomogram of harmonic vibrations .....          | 196 |
| <b>Conclusion</b> ..... |                                                            | 199 |
| <b>References</b> ..... |                                                            | 201 |
| <b>Index</b> .....      |                                                            | 209 |