

- Dedication p. iii
- Preface p. v
- Acknowledgments p. vii
- Part 1 Primer on Rotor Vibration
- 1. Vibration Concepts and Methods p. 1
- 1. The One-Degree-of-Freedom Model p. 1
- 1.1 Assumption of Linearity p. 2
- 1.2 Unforced System p. 2
- 1.3 Self-Excited Dynamic-Instability Vibrations p. 4
- 1.4 Steady-State Sinusoidally Forced Systems p. 4
- 1.5 Undamped Natural Frequency: An Accurate Approximation p. 6
- 1.6 The One-Degree-of-Freedom Model as an Approximation p. 8
- 2. Multi-Degree-of-Freedom Models p. 9
- 2.1 Two-Degree-of-Freedom Models p. 10
- 2.2 Matrix Bandwidth and Zeros p. 13
- 2.3 Standard Rotor Vibration Analyses p. 15
- 3. Modes, Excitation, and Stability of Multi-DOF Models p. 15
- 3.1 Modal Decomposition p. 16
- 3.2 Modal Damping p. 20
- 3.3 Forced Systems Decoupled in Modal Coordinates p. 22
- 3.4 Harmonic Excitation of Linear Multi-DOF Models p. 23
- 3.5 Dynamic Instability: The Complex Eigenvalue Problem p. 24
- 4. Summary p. 26
- Bibliography p. 26
- 2. Lateral Rotor Vibration Analysis Models p. 27
- 1. Introduction p. 27
- 2. Simple Linear Models p. 30
- 2.1 Point-Mass 2-DOF Model p. 30
- 2.2 Jeffcott Rotor Model p. 31
- 2.3 Simple Nontrivial Model p. 33
- 3. Formulations for RDA Software p. 46
- 3.1 Basic Rotor Finite Element p. 47
- 3.2 Shaft Element Lumped Mass Matrix p. 49
- 3.3 Shaft Element Distributed Mass Matrix p. 50
- 3.4 Shaft Element Consistent Mass Matrix p. 51
- 3.5 Shaft Element Stiffness Matrix p. 53
- 3.6 Shaft Element Gyroscopic Matrix p. 53
- 3.7 Addition of Nonstructural Mass and Inertia to Rotor Element p. 54
- 3.8 Matrices for Complete Free-Free Rotor p. 54
- 3.9 Radial-Bearing and Bearing-Support Models p. 56
- 3.10 Completed RDA Model Equations of Motion p. 61
- 4. Insights into Linear Lateral Rotor Vibrations p. 61
- 4.1 Systems with Nonsymmetric Matrices p. 62
- 4.2 The Isotropic Model p. 67
- 4.3 Physically Consistent Models p. 69
- 4.4 Bearing and Seal Model with Combined Radial and Misalignment Motions p. 70

- 5. Nonlinear Dynamics of Flexible Multibearing Rotors p. 71
- 5.1 Large-Amplitude Vibration Sources that Yield Nonlinear Effects p. 72
- 5.2 Journal Bearing Nonlinear Dynamic Effects p. 73
- 6. Summary p. 81
- Bibliography p. 81
- 3. Torsional Rotor Vibration Analysis Models p. 83
- 1. Introduction p. 83
- 2. Rotor-Based Spinning Reference Frames p. 85
- 3. Single Uncoupled Rotor p. 85
- 3.1 Lumped and Distributed Mass Matrices p. 87
- 3.2 Stiffness Matrix p. 89
- 4. Coupled Rotors p. 91
- 4.1 Coaxial Same-Speed Coupled Rotors p. 91
- 4.2 Unbranched Systems with Rigid and Flexible Connections p. 92
- 4.3 Branched Systems with Rigid and Flexible Connections p. 98
- 5. Examples p. 101
- 5.1 High-Capacity Fan for Large-Altitude Wind Tunnel p. 101
- 5.2 Four-Square Gear Tester p. 103
- 5.3 Large Steam Turbogenerator Sets p. 105
- 6. Summary p. 108
- Bibliography p. 109
- Part 2 Rotor Dynamic Analyses
- 4. RDA Code for Lateral Rotor Vibration Analyses p. 111
- 1. Getting Started p. 111
- 2. Unbalance Steady-State Response Computations p. 113
- 2.1 Three-Mass Rotor Model with Two Bearings and One Disk p. 115
- 2.2 Phase Angle Explanation and Direction of Rotation p. 119
- 2.3 Three-Mass Rotor Model with Two Bearings/Pedestals and One Disk p. 122
- 2.4 Anisotropic Model: Three-Mass Rotor with Two Bearings/Pedestals and One Disk p. 126
- 2.5 Elliptical Orbits p. 128
- 3. Instability Self-Excited-Vibration Threshold Computations p. 134
- 3.1 Symmetric Three-Mass Rotor with Two Anisotropic Bearings (Same) and One Disk p. 136
- 3.2 Symmetric Three-Mass Rotor with Two Anisotropic Bearings (Different) and One Disk p. 140
- 4. Additional Sample Problems p. 142
- 4.1 Symmetric Three-Mass Rotor with Two Anisotropic Bearing and Two Pedestals p. 142
- 4.2 Nine-Stage Centrifugal Pump Model with 17 Mass Stations, Two Bearings p. 143
- 4.3 Nine-Stage Centrifugal Pump Model with Five Mass Stations, Two Bearings p. 147
- 5. Summary p. 148
- Bibliography p. 148
- 5. Bearing and Seal Rotor Dynamics p. 149
- 1. Introduction p. 149
- 2. Liquid-Lubricated Fluid-Film Journal Bearings p. 150

- 2.1 Reynolds Lubrication Equation p. 150
- 2.2 Journal Bearing Stiffness and Damping Formulations p. 153
- 2.3 Journal Bearing Stiffness and Damping Data and Resources p. 157
- 2.4 Journal Bearing Computer Codes p. 159
- 2.5 Fundamental Caveat of LRV Analyses p. 160
- 3. Experiments to Measure Dynamic Coefficients p. 161
- 3.1 Mechanical Impedance Measurement Approaches p. 163
- 3.2 Mechanical Impedance Method with Impact Excitation p. 167
- 3.3 Instability Threshold Based Approach p. 169
- 4. Annular Seals p. 171
- 4.1 Seal Dynamic Data and Resources p. 174
- 4.2 Ungrooved Annular Seals for Liquids p. 174
- 4.3 Circumferentially Grooved Annular Seals for Liquids p. 182
- 4.4 Annular Gas Seals p. 184
- 5. Rolling-Contact Bearings p. 188
- 6. Squeeze-Film Dampers p. 193
- 6.1 Dampers with Centering Springs p. 194
- 6.2 Dampers Without Centering Springs p. 196
- 6.3 Limitations of Reynolds Equation Based Solutions p. 196
- 7. Summary p. 197
- Bibliography p. 198
- 6. Turbomachinery Impeller and Blade Effects p. 201
- 1. Centrifugal Pumps p. 201
- 1.1 Static Radial Hydraulic Impeller Force p. 201
- 1.2 Dynamic Radial Hydraulic Impeller Forces p. 205
- 2. Centrifugal Compressors p. 210
- 2.1 Overall Stability Criteria p. 211
- 2.2 Utilizing Interactive Force Modeling Similarities with Pumps p. 212
- 3. High-Pressure Steam Turbines and Gas Turbines p. 213
- 3.1 Steam Whirl p. 213
- 3.2 Partial Admission in Steam Turbine Impulse Stages p. 219
- 3.3 Combustion Gas Turbines p. 220
- 4. Axial Flow Compressors p. 220
- 5. Summary p. 221
- Bibliography p. 222
- Part 3 Monitoring and Diagnostics
- 7. Rotor Vibration Measurement and Acquisition p. 225
- 1. Introduction to Monitoring and Diagnostics p. 225
- 2. Measured Vibration Signals and Associated Sensors p. 229
- 2.1 Accelerometers p. 229
- 2.2 Velocity Transducers p. 231
- 2.3 Displacement Transducers p. 232
- 3. Vibration Data Acquisition p. 237
- 3.1 Continuously Monitored Large Multibearing Machines p. 237
- 3.2 Monitoring Several Machines at Regular Intervals p. 239
- 3.3 Research Laboratory and Shop Test Applications p. 240

- 4. Signal Conditioning p. 241
- 4.1 Filters p. 241
- 4.2 Amplitude Conventions p. 242
- 5. Summary p. 243
- Bibliography p. 243
- 8. Vibration Severity Guidelines p. 245
- 1. Casing and Bearing Cap Vibration Displacement Guidelines p. 246
- 2. Standards, Guidelines and Acceptance Criteria p. 248
- 3. Shaft Displacement Criteria p. 249
- 4. Summary p. 250
- Bibliography p. 251
- 9. Signal Analysis and Identification of Vibration Causes p. 253
- 1. Introduction p. 253
- 2. Vibration Trending and Baselines p. 253
- 3. FFT Spectrum p. 254
- 4. Rotor Orbit Trajectories p. 256
- 5. Bode, Polar, and Spectrum Cascade Plots p. 263
- 6. Wavelet Analysis Tools p. 267
- 7. Chaos Analysis Tools p. 271
- 8. Symptoms and Identification of Vibration Causes p. 276
- 8.1 Rotor Mass Unbalance Vibration p. 276
- 8.2 Self-Excited Instability Vibrations p. 277
- 8.3 Rotor-Stator Rub-Impacting p. 282
- 8.4 Misalignment p. 285
- 8.5 Resonance p. 285
- 8.6 Mechanically Loose Connections p. 286
- 8.7 Cracked Shafts p. 287
- 8.8 Rolling-Element Bearing, Gears, and Vane/Blade Passing Effects p. 288
- 9. Summary p. 288
- Bibliography p. 289
- Part 4 Troubleshooting Case Studies
- 10. Rotor Unbalance and Critical Speed Case Studies p. 291
- 1. Introduction p. 291
- 2. HP Turbine Passage Through a Critical Speed p. 292
- 3. Boiler Feed Pumps: Critical Speed at Operating Speed p. 294
- 4. Summary p. 299
- Bibliography p. 300
- 11. Self-Excited Rotor Vibration Case Studies p. 301
- 1. Introduction p. 301
- 2. Swirl Brakes Cure Steam Whirl in a 1,300 MW Unit p. 301
- 3. Bearing Unloaded by Nozzle Forces Allows Steam Whirl p. 304
- 4. Misalignment Causes Oil-Whip/Steam-Whirl "Duet" p. 306
- 5. Summary p. 308
- Bibliography p. 308
- 12. Additional Rotor Vibration Problem Cases and Topics p. 309
- 1. Introduction p. 309

- 2. Vertical-Rotor Machines p. 309
- 3. "Vector Turning" from Synchronously Modulated Rubs p. 312
- 4. Impact Tests for Vibration Problem Diagnoses p. 319
- 5. Bearing Looseness Effects p. 320
- 5.1 Bearing Looseness and Poor Geometry (350 MW Steam Turbogenerator) p. 320
- 5.2 Boiler Feed Pump 4000 Horsepower Electric Motor p. 321
- 5.3 LP Turbine Bearing Looseness on a 750 MW Steam Turbogenerator p. 321
- 6. Tilting-Pad Versus Fixed-Surface Journal Bearings p. 323
- 6.1 A Return to the Machine of the Case Study of Sec. 4, Chapter 11 p. 324
- 7. Base-Motion Excitations from Earthquake and Shock p. 325
- 8. Parametric Excitation: Nonaxisymmetric Shaft Stiffness p. 326
- 9. Magnetic Bearings p. 327
- 9.1 Unique Operating Features of Active Magnetic Bearings p. 328
- 9.2 Present Shortcomings of Magnetic Bearings p. 329
- 10. Rotor Balancing p. 331
- 10.1 Static Unbalance, Dynamic Unbalance and Rigid-Rotor Category p. 332
- 10.2 Flexible Rotors p. 333
- 10.3 Influence Coefficient Method p. 336
- 10.4 Balancing Computer Code Examples and the Importance of Modeling p. 337
- 10.5 Case Study of 430 MW Turbogenerator p. 342
- 10.6 Continuous Automatic In-Service Rotor Balancing p. 344
- 11. Summary and Bibliography p. 345
- Bibliography p. 345
- Index p. 349