

TD-106-1
Rev. 5

Form No.



PRODUCT STANDARD
RUNOUT MEASURING MACHINE
HYDERABAD

TC 65302

REV No.: 00

Page 1 of 3

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COMP. FILE NAME

TITLE	RUNOUT MEASURING MACHINE
CUSTOMER	BHARAT HEAVY ELECTRICALS LTD
PLANT	COMPRESSOR QUALITY CONTROL

Ref. Doc.

Prepared KKS <i>S.K.S.</i>	Checked BKR <i>BKR</i>	Approved MKG <i>MKG</i> Mrinal Kanti Ghosh अपर महा प्रबंधक/टेस्टिंग (सी व जी टी) Addl. General Manager/Testing (TC & GT) बी एच ई एल, हैद/ BHEL, HYD-502 032	Date 02-05-14 <i>06/09/14</i>
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Page 2 of 3

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1.0 Scope

The run out measurement kit is required for measuring combined run out (electrical plus mechanical run out) present at vibration probe locations of Turbine and Compressor rotors. This is usually done with the rotor positioned either in V-blocks or in a lathe. While measuring the run out the rotors are manually rotated in v- blocks and at very low speed on Lathe machine.

American Petroleum Institute (API) Standard 670 recommends that "the combined total electrical and mechanical run out does not exceed 25 percent of the maximum allowed peak to peak vibration amplitude or 0.25 mil (6 micrometers), whichever is greater."

2.0 Features:

1. The Scope meter shall read the signal amplitude.
2. The scope meter shall indicate the Peak to Peak value in digits along with waveform.
3. The scope meter shall have the hold mode.
4. Scope meter shall Save or print the entire waveform or entire screen.
5. Transfer the data to the PC based software for viewing, storage and printing.

3.0 Accessories:

1. 2 channel Fluke scope meter with PC & Printer Interface.
2. Optical Phase measurement/reference kit (Optional).
3. Eddy current Probe system.
4. 24v DC Power Supply suitable to source voltage of 1-Ph, 230 V AC.
5. Gauss meter (-10 to +10 Guass)
6. Required Softwares in CD.
7. Magnetic mounts and vise grips.
8. Carrying case

4.0 BHEL material code: TC9765302010.**5.0 Documents and software:**

Three sets of Manuals and test certificates shall be submitted in hard copies along with a softcopy in CD.

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Page 3 of 3

6.0 Scheme:

