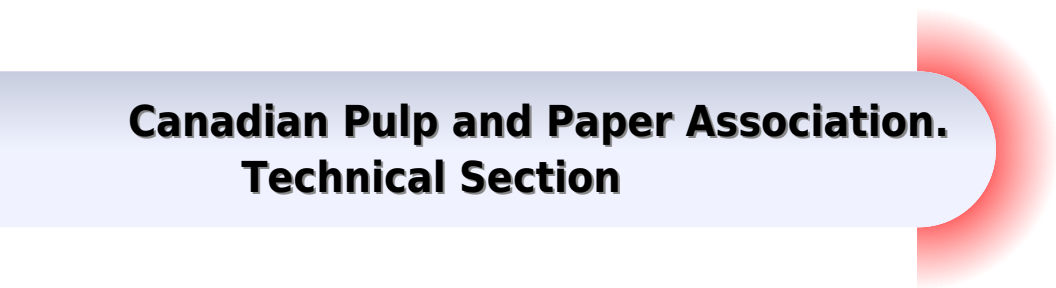


| Standard                                     | NEMA MG1 2006                                                             | API 547                                                                                                                                                                                                                                 | API 541 3 <sup>rd</sup> Edition                                                                                                                                                               | API 541 4 <sup>th</sup> Edition                                                                                                                                                                                                         |
|----------------------------------------------|---------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| Bearing Journal Runouts                      | Not mentioned                                                             | Not mentioned                                                                                                                                                                                                                           | To limit the vibration values                                                                                                                                                                 | To limit the vibration values                                                                                                                                                                                                           |
| Non Contacting Eddy Current Probe Fit Runout | Not mentioned                                                             | 25% of unfiltered p-p or 0.25 mil total                                                                                                                                                                                                 | 30% of unfiltered p-p or 0.25 mil total                                                                                                                                                       | 25% of unfiltered p-p or 0.25 mil total                                                                                                                                                                                                 |
| Forged Shaft                                 | Not mentioned                                                             | Not mentioned                                                                                                                                                                                                                           | Yes - 2 pole and Operating speed > 1 <sup>st</sup> Lateral critical speed                                                                                                                     | Yes - Special requirements                                                                                                                                                                                                              |
| Seamless End Connectors                      | Not mentioned                                                             | Not mentioned                                                                                                                                                                                                                           | Required for speed > 1500 RPM                                                                                                                                                                 | Required for speed > 1000 RPM                                                                                                                                                                                                           |
| Tight Rotor Bars                             | Not mentioned                                                             | Not mentioned                                                                                                                                                                                                                           | Yes                                                                                                                                                                                           | Yes                                                                                                                                                                                                                                     |
| Center Locked Rotor Bars                     | Not mentioned                                                             | Not mentioned                                                                                                                                                                                                                           | Yes                                                                                                                                                                                           | Yes                                                                                                                                                                                                                                     |
| Induction Brazed End Rings                   | Not mentioned                                                             | Brazing material must be phosphorous free                                                                                                                                                                                               | Yes allowed and other methods too                                                                                                                                                             | Yes allowed and other methods too                                                                                                                                                                                                       |
| End Rings Symmetrically Brazed               | Not mentioned                                                             | Not mentioned                                                                                                                                                                                                                           | Yes                                                                                                                                                                                           | Yes                                                                                                                                                                                                                                     |
| Step Balance                                 | Not mentioned                                                             | Not mentioned                                                                                                                                                                                                                           | Yes                                                                                                                                                                                           | Yes                                                                                                                                                                                                                                     |
| Balance Spec                                 | Not mentioned                                                             | Not mentioned                                                                                                                                                                                                                           | Unbalance $\leq 4W/N$                                                                                                                                                                         | Unbalance $\leq 4W/N$                                                                                                                                                                                                                   |
| Full Speed Balancing                         | Not mentioned                                                             | Not mentioned                                                                                                                                                                                                                           | No                                                                                                                                                                                            | No                                                                                                                                                                                                                                      |
| Air Gap Tolerance                            | Not mentioned                                                             | Not mentioned                                                                                                                                                                                                                           | $\pm 10\%$                                                                                                                                                                                    | $\pm 10\%$                                                                                                                                                                                                                              |
| Foot Flatness                                | Not mentioned                                                             | <ul style="list-style-type: none"> <li>○ All feet in the same horizontal plane within 0.005 inch</li> <li>○ Flatness of each foot within 0.0005 inch per foot</li> <li>○ Mounting planes parallel within 0.002 inch per foot</li> </ul> | <ul style="list-style-type: none"> <li>○ All feet in the same horizontal plane within 0.005 inch</li> <li>○ Each foot parallel to same horizontal plane within 0.002 inch per foot</li> </ul> | <ul style="list-style-type: none"> <li>○ All feet in the same horizontal plane within 0.005 inch</li> <li>○ Flatness of each foot within 0.0005 inch per foot</li> <li>○ Mounting planes parallel within 0.002 inch per foot</li> </ul> |
| Trim Balancing Allowed                       | Not mentioned                                                             | Same as API 541 if probes required                                                                                                                                                                                                      | Yes, but not for thermal compensation                                                                                                                                                         | Yes, but not for thermal compensation                                                                                                                                                                                                   |
| Hot Vibration Measurement                    | Not mentioned                                                             | Same as API 541 if probes required                                                                                                                                                                                                      | No change > 50 % of the allowable limit from hot to cold                                                                                                                                      | No change of 1X > 0.6 mil on shaft and 0.05 ips on housing from hot to cold                                                                                                                                                             |
| Modulation                                   | Not mentioned                                                             | Not Mentioned                                                                                                                                                                                                                           | 15 minutes for 2 pole                                                                                                                                                                         | 15 minutes for 2 pole                                                                                                                                                                                                                   |
| Mounted on Massive Foundation                | Yes, at machine feet, vibration < 25% of max velocity at bearing housings | Not Mentioned                                                                                                                                                                                                                           | Yes, at machine feet, vibration < 30% of max velocity at bearing housings                                                                                                                     | $\pm 20\%$ of 1 and 2X and 20% of 1 and 2 LF                                                                                                                                                                                            |
| Frame Resonance                              | $\pm 10\%$ of 1X RPM, $\pm 5\%$ of 2X RPM and 1X and 2X LF                | $N = nN_{op} \pm 0.25N_{op} (1)$                                                                                                                                                                                                        | $N = nN_{op} \pm 0.20N_{op} (1)$                                                                                                                                                              | $N = nN_{op} \pm 0.15N_{op} (1)$                                                                                                                                                                                                        |
| Balance with Key                             | Not mentioned                                                             | Not mentioned                                                                                                                                                                                                                           | Yes                                                                                                                                                                                           | Yes                                                                                                                                                                                                                                     |

# Petrochemical Ac Induction Motor Standards A Comparison

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