

# Contents

Page

Foreword	vii
9.6.5 Rotodynamic (Centrifugal and Vertical) Pumps for Condition Monitoring	1
9.6.5.0 Scope	1
9.6.5.0.1 Purpose	1
9.6.5.0.2 Use of this document	1
9.6.5.0.3 Monitoring frequency	2
9.6.5.0.4 Control limits	3
9.6.5.1 Power monitoring	4
9.6.5.1.1 Introduction	4
9.6.5.1.2 Means of power monitoring	4
9.6.5.1.3 Power monitoring frequency	5
9.6.5.1.4 Power control limits	5
9.6.5.2 Temperature monitoring	5
9.6.5.2.1 Introduction	5
9.6.5.2.2 Means of monitoring temperature	5
9.6.5.2.3 Specific applications of temperature monitoring	5
9.6.5.2.4 Sealless pump liquid temperature	6
9.6.5.2.5 Temperature monitoring frequency	7
9.6.5.2.6 Temperature control limits	7
9.6.5.3 Corrosion monitoring	7
9.6.5.3.1 Introduction	7
9.6.5.3.2 Means of corrosion monitoring	7
9.6.5.3.3 Corrosion monitoring frequency	8
9.6.5.3.4 Corrosion parameter control limits	8
9.6.5.4 Leakage monitoring	9
9.6.5.4.1 Introduction	9
9.6.5.4.2 Means of monitoring leakage	9
9.6.5.4.3 Leakage monitoring frequency	10
9.6.5.4.4 Leakage control limits	11
9.6.5.4.5 Leakage control limits for gas seal consumption	11
9.6.5.5 Pressure monitoring	11
9.6.5.5.1 Introduction	11
9.6.5.5.2 Means of pressure monitoring	11
9.6.5.5.3 Pressure monitoring frequency	11
9.6.5.5.4 Pressure control limits	11

9.6.5.6	Vibration monitoring . . . . .	12
9.6.5.6.1	Introduction . . . . .	12
9.6.5.6.2	Means of vibration monitoring . . . . .	12
9.6.5.6.3	Vibration monitoring frequency . . . . .	13
9.6.5.6.4	Vibration control limits . . . . .	13
9.6.5.7	Periodic lubricant analysis . . . . .	13
9.6.5.7.1	Introduction . . . . .	13
9.6.5.7.2	Measuring metal particles from wear . . . . .	13
9.6.5.7.3	Measuring contamination of lubricant . . . . .	14
9.6.5.7.4	Measuring lubricant degradation . . . . .	15
9.6.5.7.5	Lubricant sampling techniques . . . . .	15
9.6.5.7.6	Lubricant monitoring frequency . . . . .	15
9.6.5.7.7	Lubricant control limits . . . . .	15
9.6.5.8	Shaft position monitoring . . . . .	15
9.6.5.8.1	Introduction . . . . .	15
9.6.5.8.2	How to monitor shaft position . . . . .	16
9.6.5.8.3	Shaft monitoring frequency . . . . .	16
9.6.5.8.4	Shaft control limits . . . . .	16
9.6.5.9	Rate-of-flow monitoring . . . . .	16
9.6.5.9.1	Introduction . . . . .	16
9.6.5.9.2	Measuring rate of flow . . . . .	16
9.6.5.9.3	Rate-of-flow monitoring frequency . . . . .	16
9.6.5.9.4	Rate-of-flow control limits . . . . .	16
9.6.5.10	Maintenance inspection . . . . .	17
9.6.5.10.1	Introduction . . . . .	17
9.6.5.10.2	Maintenance inspection practice . . . . .	17
9.6.5.10.3	Maintenance inspection frequency . . . . .	19
9.6.5.11	Speed (rpm) monitoring . . . . .	19
9.6.5.11.1	Introduction . . . . .	19
9.6.5.11.2	Speed measurement methods . . . . .	19
9.6.5.11.3	Speed monitoring frequency . . . . .	20
9.6.5.11.4	Speed control limits . . . . .	20
9.6.5.12	Bearing wear monitoring of plain bearings in sealless pumps . . . . .	20
9.6.5.12.1	Introduction . . . . .	20
9.6.5.12.2	Means of detecting bearing wear . . . . .	20
9.6.5.12.3	Bearing wear monitoring frequency . . . . .	21
9.6.5.12.4	Bearing wear control limits . . . . .	21

9.6.5.13	Preinstallation hydrostatic test . . . . .	21
9.6.5.13.1	Introduction . . . . .	21
9.6.5.13.2	Means of conducting a preinstallation hydrostatic test . . . . .	22
9.6.5.13.3	Hydrostatic test monitoring frequency. . . . .	22
9.6.5.13.4	Hydrostatic test control limits . . . . .	22
9.6.5.14	Design review . . . . .	22
9.6.5.14.1	Introduction . . . . .	22
9.6.5.14.2	Design review practice . . . . .	22
9.6.5.14.3	Design review frequency. . . . .	24
Appendix A	Condition Monitoring, Failure Modes . . . . .	25
Appendix B	Condition Monitoring Indicators . . . . .	31
Appendix C	Definitions . . . . .	36
Appendix D	Index . . . . .	38
Tables		
9.6.5.0.3a	— Severity levels . . . . .	2
9.6.5.0.3b	— Frequency of monitoring. . . . .	3
9.6.5.4.2.6	— Application guidelines for leakage monitoring systems' mechanical seals . . . . .	10
A.1	— Condition monitoring failure modes . . . . .	25
A.2	— Additional failure modes for sealless pumps and pumps with journal bearings . . . . .	30
B.1	— Condition monitoring indicators. . . . .	31