

Table 1 — Guidance for balance quality grades for rotors in a constant (rigid) state

Machinery types: General examples	Balance quality grade G	Magnitude $e_{per} \cdot \Omega$ mm/s
Crankshaft drives for large slow marine diesel engines (piston speed below 9 m/s), inherently unbalanced	G 4000	4 000
Crankshaft drives for large slow marine diesel engines (piston speed below 9 m/s), inherently balanced	G 1600	1 600
Crankshaft drives, inherently unbalanced, elastically mounted	G 630	630
Crankshaft drives, inherently unbalanced, rigidly mounted	G 250	250
Complete reciprocating engines for cars, trucks and locomotives	G 100	100
Cars: wheels, wheel rims, wheel sets, drive shafts Crankshaft drives, inherently balanced, elastically mounted	G 40	40
Agricultural machinery Crankshaft drives, inherently balanced, rigidly mounted Crushing machines Drive shafts (cardan shafts, propeller shafts)	G 16	16
Aircraft gas turbines Centrifuges (separators, decanters) Electric motors and generators (of at least 80 mm shaft height), of maximum rated speeds up to 950 r/min Electric motors of shaft heights smaller than 80 mm Fans Gears Machinery, general Machine-tools Paper machines Process plant machines Pumps Turbo-chargers Water turbines	G 6,3	6,3
Compressors Computer drives Electric motors and generators (of at least 80 mm shaft height), of maximum rated speeds above 950 r/min Gas turbines and steam turbines Machine-tool drives Textile machines	G 2,5	2,5
Audio and video drives Grinding machine drives	G 1	1
Gyroscopes Spindles and drives of high-precision systems	G 0,4	0,4
NOTE 1	Typically completely assembled rotors are classified here. Depending on the particular application, the next higher or lower grade may be used instead. For components, see Clause 9.	
NOTE 2	All items are rotating if not otherwise mentioned (reciprocating) or self-evident (e.g. crankshaft drives).	
NOTE 3	For limitations due to set-up conditions (balancing machine, tooling), see Notes 4 and 5 in 5.2.	
NOTE 4	For some additional information on the chosen balance quality grade, see Figure 2. It contains generally used areas (service speed and balance quality grade G), based on common experience.	
NOTE 5	Crankshaft drives may include crankshaft, flywheel, clutch, vibration damper, rotating portion of connecting rod. Inherently unbalanced crankshaft drives theoretically cannot be balanced; inherently balanced crankshaft drives theoretically can be balanced.	
NOTE 6	For some machines, specific International Standards stating balance tolerances may exist (see Bibliography).	

# Iso 1940 1

**Camilla Rothe**



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