

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).	

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**Puja Mehta**



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## **Table of Contents Iso 1940 1**

1. Understanding the eBook Iso 1940 1
  - The Rise of Digital Reading Iso 1940 1
  - Advantages of eBooks Over Traditional Books
2. Identifying Iso 1940 1
  - Exploring Different Genres
  - Considering Fiction vs. Non-Fiction
  - Determining Your Reading Goals
3. Choosing the Right eBook Platform
  - Popular eBook Platforms
  - Features to Look for in an Iso 1940 1
  - User-Friendly Interface
4. Exploring eBook Recommendations from Iso 1940 1

- Personalized Recommendations
- Iso 1940 1 User Reviews and Ratings
- Iso 1940 1 and Bestseller Lists
- 5. Accessing Iso 1940 1 Free and Paid eBooks
  - Iso 1940 1 Public Domain eBooks
  - Iso 1940 1 eBook Subscription Services
  - Iso 1940 1 Budget-Friendly Options
- 6. Navigating Iso 1940 1 eBook Formats
  - ePub, PDF, MOBI, and More
  - Iso 1940 1 Compatibility with Devices
  - Iso 1940 1 Enhanced eBook Features
- 7. Enhancing Your Reading Experience
  - Adjustable Fonts and Text Sizes of Iso 1940 1
  - Highlighting and Note-Taking Iso 1940 1
  - Interactive Elements Iso 1940 1
- 8. Staying Engaged with Iso 1940 1
  - Joining Online Reading Communities
  - Participating in Virtual Book Clubs
  - Following Authors and Publishers Iso 1940 1
- 9. Balancing eBooks and Physical Books Iso 1940 1
  - Benefits of a Digital Library
  - Creating a Diverse Reading Collection Iso 1940 1
- 10. Overcoming Reading Challenges
  - Dealing with Digital Eye Strain
  - Minimizing Distractions
  - Managing Screen Time
- 11. Cultivating a Reading Routine Iso 1940 1
  - Setting Reading Goals Iso 1940 1
  - Carving Out Dedicated Reading Time
- 12. Sourcing Reliable Information of Iso 1940 1

- Fact-Checking eBook Content of Iso 1940 1
  - Distinguishing Credible Sources
13. Promoting Lifelong Learning
- Utilizing eBooks for Skill Development
  - Exploring Educational eBooks
14. Embracing eBook Trends
- Integration of Multimedia Elements
  - Interactive and Gamified eBooks

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