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Some Worthy Signal Processing Techniques for Mechanical Fault Diagnosis

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May 30, 2002, Korea

Super-Worthy Signal Processing Techniques

Outline

1. Introduction – Background and Structure
2. Time-Frequency Distribution
3. Wavelet Analysis
4. Bispectrum Analysis
5. Cyclostationary Signal Processing
6. Nonlinear Signal Analysis
7. Blind Source Separation
8. Conclusion




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Super-Worthy Signal Processing Techniques

1. Introduction – Background and Structure
2. Time-Frequency Distribution
3. Wavelet Analysis
4. Bispectrum Analysis
5. Cyclostationary Signal Processing
6. Nonlinear Signal Analysis
7. Blind Source Separation

1. Introduction

– Background and Structure



Super-Worthy Signal Processing Techniques

Condition Monitoring and Fault Diagnosis

Mechanical condition monitoring and fault diagnosis is

- ✦ A developing subject, and supported by many other subjects
- ✦ A technique related closely to the modern industry
- ✦ A research hot point in mechanical engineering area

Key Point: exploit the fault diagnosis theory, method and available technology

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Research Direction

The significant research direction in mechanical fault diagnosis area:

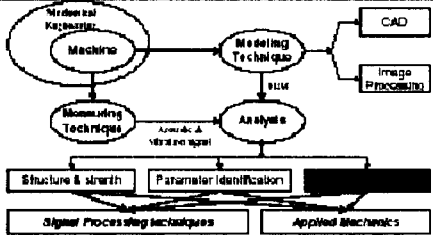
- ✦ Theories and approaches for fault feature extracting and fault classification, identification
- ✦ Complicated fault generating mechanism and its model
- ✦ Intelligent fault diagnosis system (including the expert system and network based remote diagnosis system)

One of the Key Points: Fault feature extracting techniques based on (modern) signal processing

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Super-Worthy Signal Processing Techniques

Technique Structure



```

    graph TD
      subgraph Mechanical_Knowledge
        Mech[Mechanics]
        MT[Mechanical Testing Techniques]
      end
      Mech --> Modeling[Modeling Techniques]
      Modeling --> Analysis[Analysis]
      Analysis --> Structure[Structure & Strength]
      Analysis --> Param[Parameter Identification]
      Analysis --> Fault[Fault]
      Param --> Fault
      Structure --> Fault
      Param --> Fault
      Fault --> CAD[CAD]
      Fault --> Image[Image Processing]
      Param --> DSP[Digital Processing Techniques]
      Param --> MechMech[Applied Mechanics]
  
```

• Fault Signal Theory (FST), • Condition • Fault Logic, • Diagnosis
 • High Order Water (HOM), • Neural Networks (NN), • Wavelet Transform
 • Spectral Analysis (SA), • Time-Frequency Coherence (TFC),
 • Signal Entropy, • Nonlinear Analysis, • Hough Transform
 • Safety
 • Control
 • Product

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Modern Signal Processing Techniques

Signal Processing

Signal processing technique is the basis of fault diagnosis, and is the necessary and essential tool for feature extracting

- The traditional signal processing still play an important role
- In recent year, the modern signal processing technique has shown its strength

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Modern Signal Processing Techniques

Traditional signal processing

Feature Extracting Techniques

PSD

Correlation

Transfer Function

FFT (Fast Fourier Transform)

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Modern Signal Processing Techniques

Modern Signal Processing

The inbeing of modern signal processing can be recapitulated as a prefix "non-", that is to research:

- Non-linear, non-causal, non-minimum phase system
- Non-Gaussian, non-stationary, non-integral dimension (fractal) signal
- Non-white additive noise

To obtain fault feature accurately and available, it's necessary to develop the fault diagnosis theories and methods based on non-Gaussian, non-stationary and non-linear signal analysis

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Modern Signal Processing Techniques

Modern Signal Processing

feature extracting techniques

Time-Frequency Distribution Wavelet Transformation

Higher-Order Statistics SuperGaussian

Fractal Correlation Dimension

non-stationary

non-Gaussian

nonlinear

modern signal processing

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1. Introduction
2. Time-Frequency Distribution
3. Wavelet Analysis
4. Spectral Analysis
5. Time-Frequency Distribution
6. Nonlinear Signal Analysis
7. Fractal Signal Analysis

2. Time-Frequency Distribution

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Why Time-Frequency Distribution

- When fault occurs in a running machine, the vibration or acoustic signals are usually time-variant nonstationary
- So, we need to characterize signals via a joint function of time and frequency, but not just on time or frequency domain

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Wavelet Signal Processing Techniques

Classification of TFD

Linear		Non-linear		
Wigner Wigner (WV)	Short-time Fourier transform (STFT)	Time-frequency striping method (TFM) (Choi)	Time-scale striping method (TSM) (Choi)	Radial-Gaussian kernel distribution (RGKD)

Fault condition usually corresponds to the energy change of the measured signal
 For feature extracting, since our purpose is to describe a signal's Time-Frequency (T-F) energy distribution (that is, the Instantaneous PSD), while wavelet transform is not in meaning of T-F (but in time-scaling) & don't corresponds to the energy, therefore, the C₁ class is selected

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Wavelet Signal Processing Techniques

Examples

Chirp Signals - time-varying frequency sinusoid:

$$s(t) = A_1 \sin(2\pi(f_1 + \alpha t)) + A_2 \sin(2\pi(f_2 + \alpha t)) + n(t)$$

Magnitude: $A_1 = A_2 = 1$
 Initial frequency: $f_1 = 1, f_2 = 4$
 Rate of linearly increasing frequency: $\alpha = 0.1 \text{ Hz}$
 Random noise: $n(t) \sim N(0, 1)$
 Sampling frequency: $f_s = 100 \text{ Hz}$
 Data length in time-domain: $N = 256$

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Results - Pseudo Wigner distribution

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Wavelet Signal Processing Techniques

Results - Choi-Williams distribution

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Wavelet Signal Processing Techniques

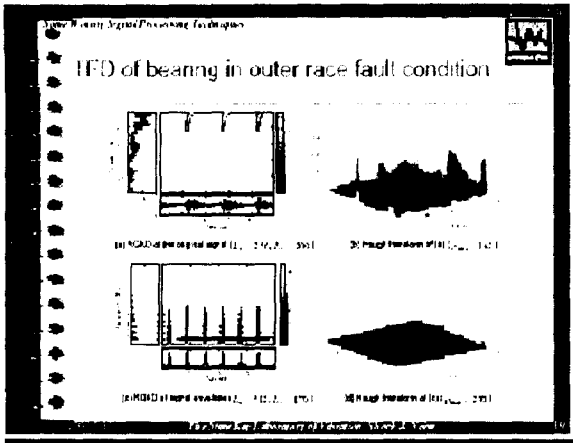
Results - Short-time Fourier Transform

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Results - RGKD with $\alpha = 2$

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Time-Varying Signal Processing Techniques

1. Introduction to Signal Processing
 2. Time-Varying Signal Processing
3. Wavelet Analysis
 4. Time-Varying Signal Processing
 5. Time-Varying Signal Processing

3. Wavelet Analysis

Time-Varying Signal Processing Techniques

Basic Concept

The Time-Frequency resolution of wavelet transform is various on the whole time-frequency plane

- At high-frequency, the time range is small
- At low-frequency, the frequency band is narrow

Base Function Resolution on T-F Plane

The Time-Varying Signal Processing Techniques

Time-Varying Signal Processing Techniques

Wavelet Transform

- Continuous wavelet transform $W_{a,b}(t) = \int s(t) \cdot \psi_{a,b}^*(t) dt$ $\psi_{a,b}(t) = \frac{1}{\sqrt{a}} \psi\left(\frac{t-b}{a}\right)$
- Discrete wavelet transform $W_{a,b}(n, l) = \int s(t) \cdot \psi_{a,b}^*(t) dt$ $\psi_{a,b}(l) = 2^{-\frac{n}{2}} \psi\left(\frac{l-b}{2^n}\right)$
- Dyadic wavelet transform $W_{a,b}(2^n, l) = \int s(t) \cdot \psi_{a,b}^*(t) dt$ $\psi_{a,b}(l) = 2^{-\frac{n}{2}} \psi\left(\frac{l-b}{2^n}\right)$
- Wavelet Packet algorithm

$$c_j^{(k)}(l) = \frac{1}{2} \sum c_j^{(k)}(l) \chi^k(l-2k)$$

$$c_j^{(k)}(l) = \frac{1}{2} \sum c_j^{(k)}(l) \chi^k(l-2k)$$

The Time-Varying Signal Processing Techniques

Time-Varying Signal Processing Techniques

Continuous wavelet transform

Using the continuous wavelet transform to analyze the signal and estimate the weak period pulses and noise.

Effect of the weak period pulses raised in the signal by the continuous wavelet transform.

The Time-Varying Signal Processing Techniques

Time-Varying Signal Processing Techniques

Scaling and phase spectrum analysis

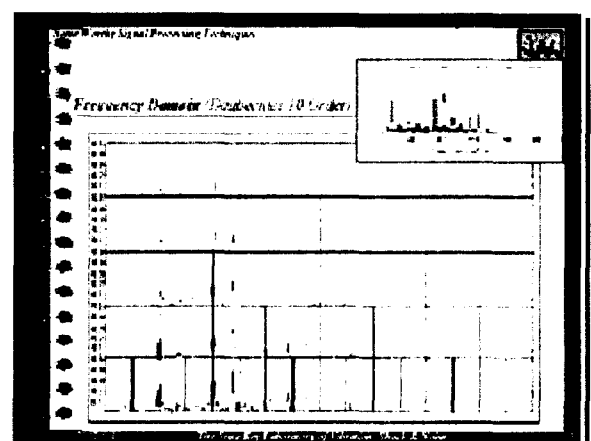
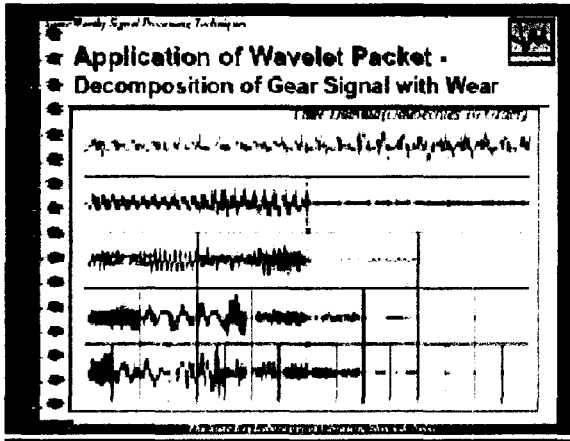
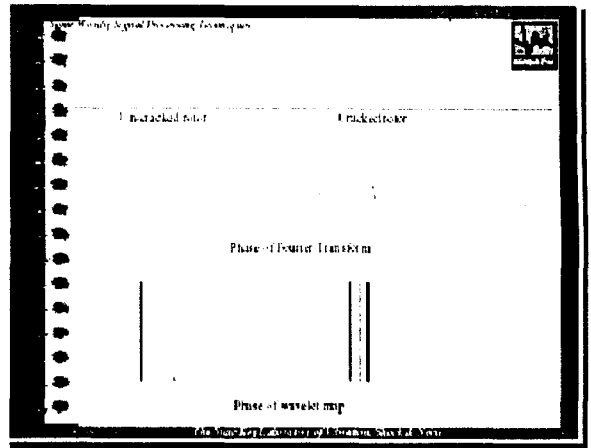
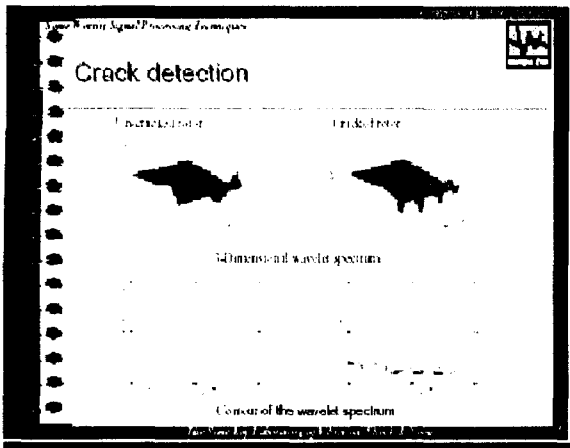
Time wave

Power spectrum

Scaling spectrum

Phase spectrum

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1. Introduction - The Application of Statistics
 2. Fundamentals of Statistics
 3. Fourier Analysis
 4. **Discrete Spectrum Analysis**
 5. Discontinuity Signal Processing
 6. Non-linear Signal Analysis
 7. Introduction to Spectral

4. Bispectrum Analysis

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Non-parametric bispectrum analysis

Basically The non-parametric bispectral analysis is defined as

$$c_{\tau_1, \tau_2} = \text{cov}(x(n), x(n + \tau_1), x(n + \tau_2)) - E[x(n)x(n + \tau_1)x(n + \tau_2)]$$

↓

$$B_s(\omega_1, \omega_2) = \sum_{n=-\infty}^{\infty} \sum_{\tau_1, \tau_2} c_{\tau_1, \tau_2} e^{j(\omega_1 \tau_1 + \omega_2 \tau_2)}$$

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Properties of bispectrum

- $B_x(\omega_1, \omega_2)$ is generally a complex

$$B_x(\omega_1, \omega_2) = |B_x(\omega_1, \omega_2)| \exp[j\phi_x(\omega_1, \omega_2)]$$
- $B_x(\omega_1, \omega_2)$ is double periodic and the period is 2π , i.e.

$$B_x(\omega_1, \omega_2) = B_x(\omega_1 + 2\pi, \omega_2) = B_x(\omega_1, \omega_2 + 2\pi)$$
- $B_x(\omega_1, \omega_2)$ holds the following symmetry:

$$\begin{aligned} B_x(\omega_1, \omega_2) &= B_x^*(\omega_2, \omega_1) = B_x^*(-\omega_2, -\omega_1) = B_x^*(-\omega_1, -\omega_2) \\ &= B_x^*(\omega_1, \omega_2) = B_x^*(\omega_2, \omega_1) \\ &= B_x^*(\omega_1, \omega_2) = B_x^*(\omega_2, \omega_1) \end{aligned}$$

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Simulation analysis

$$x(t) = \cos(2\pi f_x t + \theta_x) + \cos(2\pi f_y t + \theta_y) + \cos(2\pi f_z t + \theta_z) + n(t)$$

$$y(t) = \cos(2\pi f_x t + \theta_x) - \cos(2\pi f_y t + \theta_y) + \cos(2\pi f_z t + \theta_z) + n(t)$$

where: let

- $f_x = 0.15 f_{max}$
- $f_y = 0.25 f_{max}$
- $f_z = f_x + f_y = 0.40 f_{max}$
- θ_x and θ_y are the uniformly distributed random number in region $[0, 2\pi]$ and they are mutually independent.
- $\theta_z = \theta_x + \theta_y$, is uniformly distributed random number in region $[0, 2\pi]$
- $n(t) \sim N(0, 0.1)$

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Identification of frequency coupling

Results of $X(t)$

Results of $Y(t)$

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Detection of quadratic harmonics

$$x(t) = \cos(2\pi f_x t) - 0.1 \cos(2\pi f_y t) + n(t)$$

where $f_x = 100 \text{ Hz}$, $f_y = 200 \text{ Hz}$, $n(t) \sim N(0, 2.0)$, $f_s = 2 f_{max}$, and $f_{max} = 400 \text{ Hz}$.

Ten times average

One hundred times average

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projection of Bi-Sp

Input vector for LVC:
4 x 8 Peak values of projection of Bispectrum

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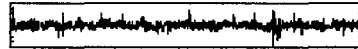
- 1. Introduction to signal processing
- 2. Discrete-time and continuous-time signals
- 3. Discrete-time Fourier transform
- 4. Cyclostationary Signal Processing
- 5. Multirate Signal Analysis
- 6. Adaptive Signal Processing

5. Cyclostationary Signal Processing



Basic Concept

- ^ A Cyclostationary signal is a special kind of non-stationary signal with underlying periodicities. Its statistic properties exhibit periodical stationary, or its statistic function vary with time periodically or polyperiodically (with multiple incommensurate periods)
- ^ The vibration signals measured from the rotating machinery especially when some faults occur are typical examples of regular variant signals.



Algorithm of sine-wave generation

- ^ A cyclostationary signal is such a signal that the finite-strength additive sine-wave components may be generated via nonlinear transformation, while the signal itself contains typically no any finite-strength additive sine-wave component
- ^ The minimum order of nonlinear transformation needed for generating sine waves is called the cyclostationary order of the signal, while the generated frequency of sine wave is named cyclic frequency and all the cyclic frequencies compose a cyclic frequency set

$$\hat{E}^{(k)}[g(t)] = \sum_{n \in \mathbb{Z}} R_n e^{j2\pi n t} \quad \text{where } R_n = \lim_{T \rightarrow \infty} \frac{1}{T} \int_0^T g(t) e^{-j2\pi n t} dt = R_0 e^{j2\pi n t}$$



Basic algorithm

- ^ Cyclic mean

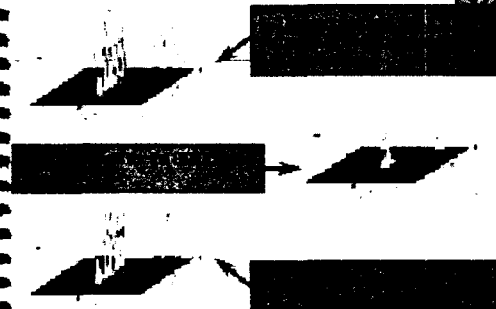
$$M_n^c = E\{m_c(t) \exp(-j2\pi n t)\}$$

- ^ Cyclic auto-correlation function

$$R_n^c(\tau) = \frac{1}{T} \int_0^T R_n(t, t+\tau) \exp(-j2\pi n t) dt$$

- ^ Spectral correlation density function

$$S_n^c(f) = \frac{1}{T} \int_0^T R_n^c(\tau) \exp(-j2\pi f \tau) d\tau$$



SCD - Spectral correlation density
BPSK signal - Binary Phase-Shift Keyed signal



Numerical simulations

$$x(t) = \sum_{p=1}^P a_p(t) e^{j(\omega_p t + \phi_p)} + B(t); \quad t = 0, 1, \dots, N-1$$

Assume that:

- (1) $\{\omega_1, \omega_2, \dots, \omega_P\}$ are distinct in $(-\pi, 0) \cup (0, \pi)$;
- (2) $\{\phi_1, \phi_2, \dots, \phi_P\}$ are deterministic constants in $(-\pi, \pi]$, and mutually independent with $\{\omega_1, \omega_2, \dots, \omega_P\}$;
- (3) $\{a_1(t), a_2(t), \dots, a_p(t)\}$ and $\{B(t)\}$ are mutually independent, stationary, and mixing processes.

Example-1

$$x(t) = \cos(\omega_1 t + \phi_1) + \cos(\omega_2 t + \phi_2) + \cos(\omega_3 t + \phi_3) + n(t)$$

where, $\omega_1 = -2.5, \phi_1 = -1.5, \omega_2 = 1.5, \phi_2 = 0.0, \omega_3 = 1.0, \phi_3 = -0.9, n(t)$ stands for the noise with zero mean normalized distribution, that is, $n(t) \sim N(0, 1)$.

(a) PSD (b) First order cyclic mean

Example-2

$$x(t) = a_1(t)\cos(\omega_1 t + \phi_1) + a_2(t)\cos(\omega_2 t + \phi_2) + a_3(t)\cos(\omega_3 t + \phi_3) + n(t)$$

where, $a_i(t), (\theta = 1, 2, 3)$ represent the pure random noises that obey $a_i(t) \sim N(0, 1)$, the rest parameters are the same with example-1.

(a) PSD (b) BIF first order cyclic mean

Example-3

$$x(t) = a_1(t)\cos(\omega_1 t + \phi_1) \quad \text{where, } \omega_1 = 0.5, \phi_1 = 0, \text{ and } a_1(t) = 1.8n(t) + 0.9n(t-1)$$

here, $n(t) \sim N(0, 1)$.

(a) PSD (b) Second order cyclic cumulant

Example-4

$$x(t) = a_1(t)\cos(\omega_1 t + \phi_1) + a_2(t)\cos(\omega_2 t + \phi_2)$$

where, $a_1(t) \sim N(0, 1), \omega_1 = 1.5, \phi_1 = 0, \text{ and } a_2(t) = 2.0n(t) + 1.5n(t-1), \omega_2 = 1.0, \phi_2 = 0$

Here, the $a_1(t)$ and $a_2(t)$ represent the random noises with the exponential distributions of 4, 1.0 and 1.0, respectively while $n(t)$ represents the normalized mean 0 and variance 1, i.e., $n(t) \sim N(0, 1)$.

(a) PSD (b) Second order cyclic cumulant

(T=4096) (T=512)

Example-5: Demodulation

Assume the amplitude modulated signal is

$$x(t) = [1 + \sin(2\pi f_1 t)]\sin(2\pi f_2 t)$$

where

$$f_1 = 200\text{Hz} \quad f_2 = 1000\text{Hz} \quad f_3 = 5120\text{Hz}$$

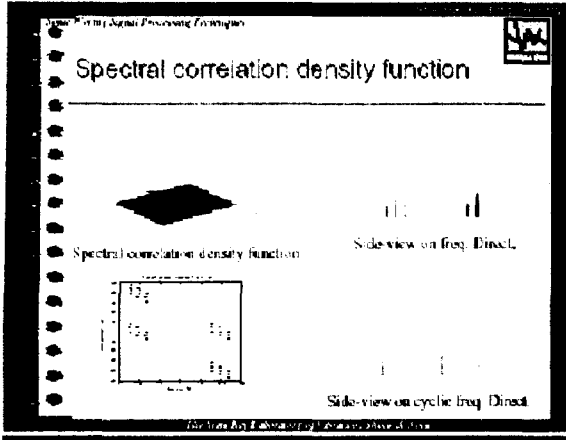
Time wave PSD

Cyclic auto-correlation function

Side-view on Time Lag Direct

Cyclic auto-correlation function

Side-view on cyclic mod. Direct. Slice at $\tau = 0$



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- ### Application
- ▲ Rolling element bearing
 - Type: GB6203 (ball bearing)
 - Pitch diameter: 28.5mm,
 - diameter of balls: 6.747mm,
 - contact angle: 0
 - ▲ Measuring condition
 - working speed: 1800 r/min,
 - sampling frequency: 5120Hz,
 - data length: 1024
 - ▲ Feature (characteristic) frequencies
 - inner race: 129.86Hz,
 - outer race: 80.14Hz,
 - ball: 59.81Hz.
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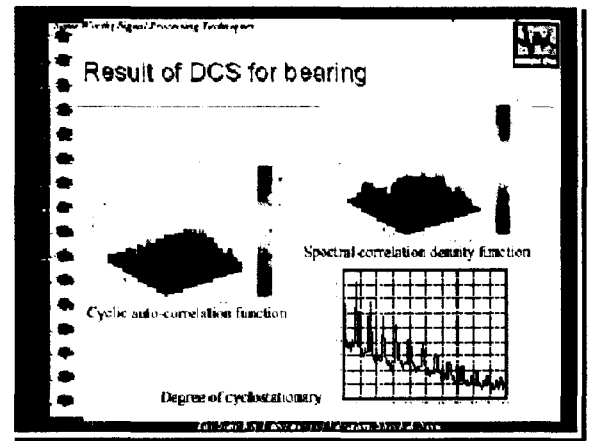
Degree of Cyclostationary (DCS)

▲ The definition of DCS

$$DCS^m = \frac{\sum_r |R_r^m(\tau)|^2}{\sum_r |R_r^m(0)|^2} \quad R_r^m(\tau) = \left\langle \frac{1}{T} x(t + \frac{\tau}{2}) x^*(t - \frac{\tau}{2}) e^{j2\pi m \tau} \right\rangle$$

$$DCS^m = \frac{\sum_r |S_r^m(f)|^2}{\sum_r |S_r^m(0)|^2} \quad S_r^m(f) = \int_{-\infty}^{\infty} R_r^m(\tau) e^{-j2\pi f \tau} d\tau$$

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1. Introduction to Signal Processing
 2. Linear Frequency Modulation
 3. Wavelet Analysis
 4. Cyclostationary Analysis
 5. Cyclostationary Signal Processing
 6. **Nonlinear Signal Analysis**
 7. Time Series Analysis
- ## 6. Nonlinear Signal Analysis
-
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- ### State space reconstruction
- N-point time series, $\{x_1, x_2, \dots, x_N\}$
- $$y_j = [x_j, x_{j+\tau}, \dots, x_{j+(m-1)\tau}]^T, \quad j=1, 2, \dots, N_m$$
- where $x_j \in \mathbb{R}^m$ ($m \geq 1$), y_j is the reconstructed state space vector, m is the embedding dimension, τ is the lag time measured in units of sampling interval.
- To ensure that the components of y_j are independent, the lag time should be selected carefully.
 - Instead of choosing the m and τ separately, the embedding window length $r_m = (m-1)\tau$ should chosen. And, setting $r_m > r_p$, where r_p is the mean orbital-period that is equal to the mean time between peaks (top) of the raw time series.
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Topic: Faulty Signal Processing Techniques

G-P algorithm

the dimension can be written as

$$D_q = \frac{1}{q-1} \lim_{\delta \rightarrow 0} \frac{\ln \sum p_i(\delta)}{\ln \delta}, \quad q \neq 1$$

$$D_1 = \lim_{\delta \rightarrow 0} \frac{\sum p_i(\delta) \ln p_i(\delta)}{\ln \delta}, \quad q = 1$$

where for $q = 0$, the D_0 is the fractal dimension and in general it is identical to the capacity and the Hausdorff dimension. D_1 is the information dimension and D_2 is the correlation dimension.

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$$C_{xx}(r) = \frac{2}{N_x(N_x-1)} \sum_{i=1}^{N_x-r} (i-r) x_i x_{i+r}$$

$$r_x = |x - \bar{x}| = \left[\sum_{i=1}^N (x_i - \bar{x})^2 \right]^{1/2}$$

$$D_2(0.01) = \lim_{r \rightarrow 0} \frac{\partial \ln C_{xx}(r)}{\partial \ln r}$$

$$r_{xy} = |y - \bar{y}| = \left[\sum_{i=1}^N (y_i - \bar{y})^2 \right]^{1/2}$$

$$r_{xy} = |y - \bar{y}| \cos \theta, \quad \theta = |\theta_1 - \theta_2|$$

$$C_{xy}(r) = \sum_{i=1}^{N-r} (x_i - \bar{x})(y_{i+r} - \bar{y}) = r_{xy} - |x - \bar{x}| |y - \bar{y}| \cos \theta$$

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Topic: Faulty Signal Processing Techniques

Principle of noise deduction by SSA

It is plausible to assume the system state space is rather high dimensional and the noise fills in low dimensional state space more or less uniformly

$$B = A^T A = \frac{1}{N} \sum_{i=1}^N y_i^T y_i, \quad A = [y_1^T, y_2^T, \dots, y_N^T]$$

$$= \frac{1}{N} \begin{bmatrix} \sum_{i=1}^N x_{i1}^2 & \dots & \sum_{i=1}^N x_{i1} x_{i2} & \dots & \sum_{i=1}^N x_{i1} x_{iN} \\ \sum_{i=1}^N x_{i2} x_{i1} & \dots & \sum_{i=1}^N x_{i2}^2 & \dots & \sum_{i=1}^N x_{i2} x_{iN} \\ \vdots & \vdots & \vdots & \ddots & \vdots \\ \sum_{i=1}^N x_{iN} x_{i1} & \dots & \sum_{i=1}^N x_{iN} x_{i2} & \dots & \sum_{i=1}^N x_{iN}^2 \end{bmatrix}$$

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Topic: Faulty Signal Processing Techniques

Principle of noise deduction by SSA

- Presupposition: The first several eigenvalues (say M in all) of the covariance matrix almost arise from the signal (maybe slightly contaminated); the remaining $L-M$ eigenvalues arise from the noise
- So it is possible to find a "noise floor" that arises from noise
- Then by removing those extra eigenvalues, a great amount of noise can be reduced

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Topic: Faulty Signal Processing Techniques

Shaft orbit and pseudo-phase portrait

Oil whirl fault

(a) PR reconstructed from the signal (b) PR reconstructed from the signal

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Topic: Faulty Signal Processing Techniques

Shaft orbit and pseudo-phase portrait

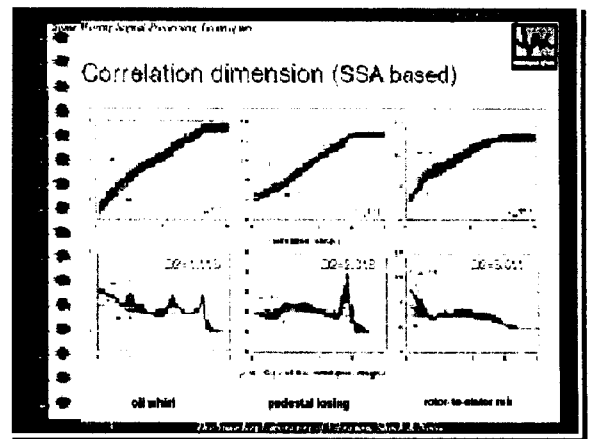
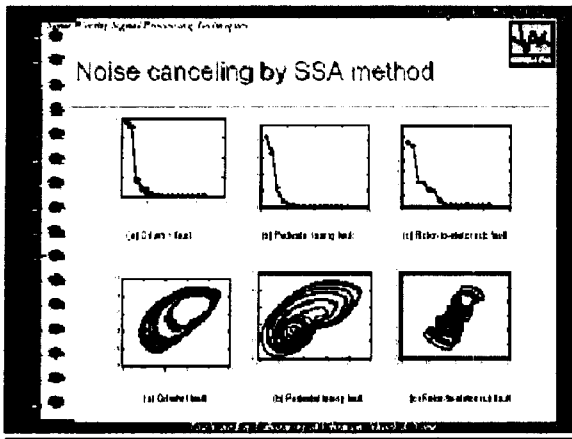
pedestal loading fault

(a) PR reconstructed from the signal (b) PR reconstructed from the signal

rotor-to-stator rub fault

(a) PR reconstructed from the signal (b) PR reconstructed from the signal

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Signal Processing Techniques

1. Introduction - Background and Motivation
2. Time Series Analysis: Introduction
3. Wavelet Analysis
4. Regression Analysis
5. Spectral Analysis: Signal Processing
6. Nonlinear Signal Analysis
7. Blind Source Separation

7. Blind Source Separation

Signal Processing Techniques

Basic Idea

- A technique of that under the condition of unknowing the mixed coefficients and probabilities of multiple source signals, find the independent source signals from the mixed signal. That is, in case of knowing only the output of a system, find the input and the system.
- It is developed based on MUSIC (Multiple Signal Classification) - a signal subspace method of auto-correlation matrix for eigenvalue problem

Signal Processing Techniques

Basic Concept

- Blind Source Separation -- a technique that under the condition of unknowing the transfer function, the mixed coefficients and probabilities of sources, to obtain (via separation) the independent sources based on a set of measured mixed signals

Signal Processing Techniques

Application area of blind source separation techniques

- Wave recovering and signal reconstructing
- Estimating to Direction of arrive (DOA)

- Till now, the Blind source separation technique has already received widely applications in radar, sonar, telecommunication, biomedicine, image processing, and physical geography, etc.

Widely Signal Processing Techniques

Computing approaches

- For narrow-band signal, There exist many blind source separation algorithms, such as:
 - maximum likelihood
 - signal subspace
 - higher-order spectrum
 - maximum entropy
 - Adaptive
 - Joint Approximate Diagonalization of Eigen-matrices (JADE)

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Widely Signal Processing Techniques

Strategy for wide-band and correlation sources

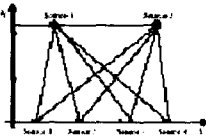
- The wide-band signal can be divided up to several un-overlapped narrow-band signals, and then the above algorithms can be employed
- For correlation sources, the following techniques can be utilized:
 - Space smooth technique
 - Frequency domain smooth technique

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Widely Signal Processing Techniques

Simulations

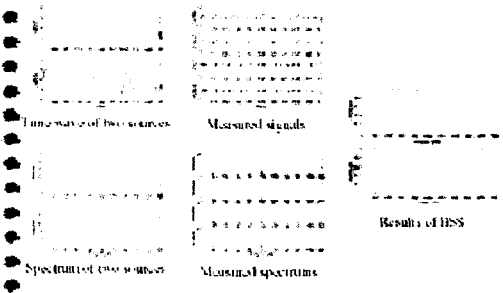
- Suppose there are two sources, and four sensors are used to measure the mixed signals. The parameters are as follows:
 - Sampling frequency: 3200Hz
 - Source location: $s1 = [0.3 \ 1.6]$; $s2 = [0.6 \ 1.4]$
 - Sensor positions: $[0.1 \ 0]$; $[0.25 \ 0]$; $[0.4 \ 0]$; $[0.55 \ 0]$



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Widely Signal Processing Techniques

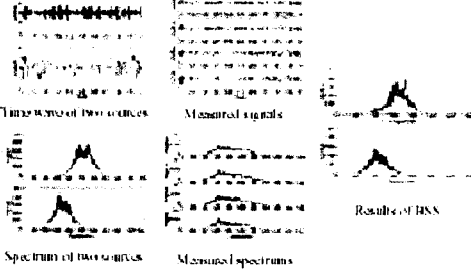
Narrow band signals



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Widely Signal Processing Techniques

Wide band signals

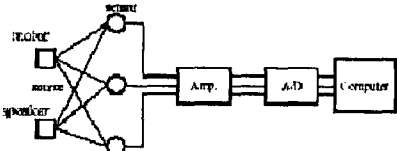


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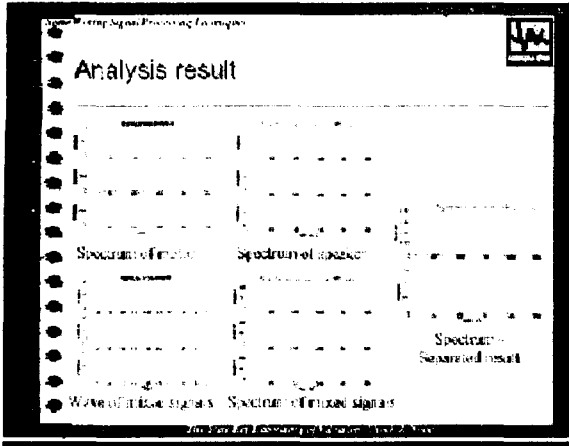
Widely Signal Processing Techniques

Experiment

- Two sources: motor running at 3000r/min, speaker with 175Hz signal
- Three sensors
- Sampling frequency: 5000Hz



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8. Conclusion

- Modern Signal Processing Techniques
- ### Conclusion
- Mechanical fault diagnosis is an active research area
 - Feature extracting is one of the most important directions in mechanical fault diagnosis
 - The signal processing techniques, especially the modern signal processing techniques provide many important and available tools for fault feature extracting
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The End