



**UNIVERSITI TEKNIKAL MALAYSIA MELAKA**

# **Design and Development of Shimless Pump Footing System**

Report submitted in accordance with the requirements of the Universiti Teknikal  
Malaysia Melaka for the Bachelor Degree of Manufacturing Engineering in  
Manufacturing Process

By

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Faculty of Manufacturing Engineering

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**UNIVERSITI TEKNIKAL MALAYSIA MELAKA**
**BORANG PENGESAHAN STATUS LAPORAN PSM**

JUDUL:

**An Experimental Study of The Impact of Surface Grinding Parameter  
On Flatness**

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 Saya **Mohd Faiz Abdul Haji**

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Date : .....25 March 2008.....

## **APPROVAL**

This PSM submitted to the senate of UTeM and has been as partial fulfillment of the requirements for the degree of Bachelor of Manufacturing Engineering (Manufacturing Process). The member of the supervisory committee is as follow:

.....  
Mr. Mohd Shahir Kasim  
Project Supervisor  
Faculty of Manufacturing Engineering

## ABSTRACT

This project proposes the design of shimless footing system to overcome the misalignment arise from the soft foot. Then, an analysis of the effectiveness of the shimless unit will be compared to conventional shim in rectifying misalignment problem. The soft foot happened when there is a gap between a machine foot and the foundation. The machine frame will actually distort from its resting position as the hold-down bolts are tighten to secure the machine in place. Soft foot also creates stress lines in the frame as a short foot is pinned to the foundation by the hold-down bolt. A classic example of the soft foot is; bar table with one short leg; which occurs when the machine naturally rests on three legs and the fourth leg is short. If it does properly corrected before beginning the actual alignment, it is difficult or impossible to achieve acceptable results. A shimless footing system will be design in order to overcome the soft foot problem. Solidwork were used in the designing stage. By using SolidWork, a shimless system can be easily developed and observed to make sure that it will able to overcome the soft foot problem. The system should be able to provide a new foundation that does not relies on shims in alignment machinery. Then, after a system has been designed, an analysis done to study the effect on soft foot during the alignment process. It will observe whether the system is effective by comparing to the conventional shim. The design should make the alignment process easier and overcome the soft foot problem from arise. There are two basic methods to identified soft foot, which are frame distortion index and the laser soft foot locator. It is predicted that the soft foot problem can be eliminated as the misalignment will not happen again.

## ABSTRAK

Projek ini bertujuan untuk mengkaji masalah 'soft foot' yang menyebabkan susunan system pam mesin menjadi tidak lurus. Setelah itu, sebuah rekaan sistem kaki yang tidak ber'shim' akan direka untuk mengatasi masalah 'soft foot' ini. 'Soft foot' ini terjadi apabila ada jarak di antara kaki pam mesin dan tapak asasnya. Pam mesin ini akan bergerak dari kedudukan asalnya walaupun nat telah diketatkan untuk mengelakkannya. 'Soft foot' juga menghasilkan garis tekanan pada mesin kerana kaki yang pendek diikat pada tapak asa dengan menggunakan nat. sekiranya ia tidak diperbaiki, hasil yang dihasilkan menjadi tidak berkualiti. Proses rekaan ini akan menggunakan CAD, iaitu Solidwork. Dengan menggunakan perisian ini, sistem tidak ber'shim' ini dapat dihasilkan dan diperhatikan untuk memastikan ia boleh mengatasi 'soft foot'. Sistem ini juga perlu mempunyai tapak asas supaya ia tidak lagi bergantung pada 'shim' untuk meluruskan system pam mesin. Rekaan ini memudahkan proses pelurusan dan masalah 'soft foot' dapat dikurangkan. Kemudian, selepas system ini telah reka, ia akan di analisis untuk mengkaji kesannya ke atas 'soft foot' ketika proses meluruskan. Pemerhatian akan dibuat sama ada system ini berkesan ataupun tidak dibandingkan dengan 'shim' biasa. Ada dua cara asas untuk mengesan 'soft foot' akan digunakan iaitu 'frame distortion index' and 'the laser soft foot locator'. Ia meramalkan yang masalah 'soft foot' boleh dihapuskan dimana 'misalingment' tidak akan berlaku lagi.

## **DEDICATION**

*My parents,*

*Haji Abdul Haji Md Dangi*

*Hajah Sarah Abd Wahab*

*My beloved sibling,*

*Lily Harnisa Abdul Haji*

*Hanis Yusri Abdul Haji*

*Hairul Faizi Abdul Haji*

*Norazizi Abdul Haji*

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Mohd Faiz Abdul Haji



# TABLE OF CONTENT

|                       |     |
|-----------------------|-----|
| Declaration.....      | i   |
| Approval.....         | ii  |
| Abstract.....         | iii |
| Dedication.....       | v   |
| Acknowledgement.....  | vi  |
| Table of content..... | vii |
| List of Figures.....  | xii |
| List of Table.....    | xiv |

## 1.0 INTRODUCTION

|   |    |
|---|----|
| 1.1 Introduction.....   | 1  |
| 1.2 Objective.....  | 2  |
| 1.3 Scope of Study.....                                       | 2  |
| 1.4 Report Organization.....                                  | 3  |
| 1.5 Flow Chart  | 3  |
| 1.6 Gantt Chart.....  | 5  |
| 1.7 Problem statement.....                                    | 7  |
| 1.7.1 The effect of Soft Foot on Alignment.....               | 7  |
| 1.7.2 The minimum thickness shimless for soft foot.....       | 8  |
| 1.7.3 Difficulties in performing alignment.....               | 8  |
| 1.7.4 Cost of Alignment.....                                  | 11 |
| 1.7.5 Material.....   | 11 |
| 1.8 Overview.....   | 12 |
| 1.8.1 The relation between soft foot and shaft alignment..... | 12 |
| 1.8.2 Software selection for the project (SolidWorks).....    | 13 |

## 2.0 LITERATURE REVIEW

|   |    |
|---|----|
| 2.1 Introduction.....                               | 14 |
| 2.2 Types of soft foot.....                         | 15 |
| 2.2.1 Deflection and damage cause by soft foot..... | 17 |
| 2.2.2 Soft foot Checks and Corrections.....         | 19 |
| 2.2.2.1 Soft Foot Checks.....                       | 19 |
| 2.2.2.2 Soft Foot Corrections.....                  | 21 |
| 2.2.3 Other method to Check Soft Foot .....         | 23 |
| 2.2.3.1 Frame distortion index.....                 | 23 |
| 2.2.3.2 Laser soft foot locator.....                | 24 |
| 2.3 Vibration.....                                  | 26 |
| 2.4 Shaft Alignment.....                            | 29 |
| 2.4.1 Basic of shaft alignment.....                 | 29 |
| 2.4.2 Shaft alignment procedure.....                | 30 |
| 2.4.3 Importance of alignment.....                  | 31 |
| 2.4.3.1 Rough soft foot correction.....             | 31 |
| 2.4.3.2 Rough alignment.....                        | 32 |
| 2.4.3.3 Final soft foot correction.....             | 32 |
| 2.4.3.4 Final alignment.....                        | 32 |
| 2.4.3.5 Problem arising from poor alignment.....    | 33 |
| 2.4.3 Offset alignment.....                         | 34 |
| 2.4.4 Angular alignment.....                        | 36 |
| 2.4.5 Harmonic force.....                           | 37 |
| 2.4.6 Bearing life.....                             | 38 |
| 2.5 Pump.....                                       | 39 |
| 2.6 The shim.....                                   | 39 |
| 2.6.1 Application of shim.....                      | 41 |
| 2.6.2 Limitation / Disadvantage of Shim.....        | 43 |
| 2.7 Design matrix.....                              | 45 |
| 2.8 CAD and CAM software.....                       | 45 |

|                                    |    |
|------------------------------------|----|
| 2.8.1 The SolidWorks approach..... | 46 |
| 2.9 Mild steel.....                | 48 |

### **3.0 METHODOLOGY**

|                                      |    |
|--------------------------------------|----|
| 3.1 Methodology.....                 | 53 |
| 3.2 Design.....                      | 54 |
| 3.3 Method used for the project..... | 55 |
| 3.3.1 Project planning.....          | 56 |
| 3.3.2 Design analysis.....           | 57 |
| 3.3.3 Conceptual design.....         | 58 |
| 3.3.3.1 Concept 1.....               | 58 |
| 3.3.3.2 Concept 2.....               | 59 |
| 3.3.3.3 Concept 3.....               | 60 |
| 3.3.4 Design selection.....          | 61 |
| 3.3.5 Selection material.....        | 61 |
| 3.4 Software CAD (SolidWorks).....   | 62 |
| 3.5 Process Flow.....                | 63 |
| 3.5.1 Material preparation.....      | 63 |
| 3.5.2 EDM Machine.....               | 67 |

### **4.0 RESULT**

|                                   |    |
|-----------------------------------|----|
| 4.1 Result.....                   | 72 |
| 4.2 Part 1 .....                  | 73 |
| 4.2.1 Design analysis Part 1..... | 74 |
| 4.3 Part 2.....                   | 79 |
| 4.3.1 Design analysis Part 2..... | 80 |
| 4.4 Part 3.....                   | 84 |
| 4.4.1 Design analysis Part 3..... | 85 |

|   |            |
|---|------------|
| 4.5 Assembly .....                          | 89         |
| 4.6 Calculation movement.....               | 92         |
| 4.6.1 Vertical and horizontal movement..... | 92         |
| <b>5.0 DISCUSSION</b>                       |            |
| 5.1 Introduction.....                       | 93         |
| 5.2 Design.....                             | 93         |
| 5.3 Material.....                           | 94         |
| 5.4 Calculation.....                        | 94         |
| 5.5 Vibration.....                          | 95         |
| 5.6 Machining.....                          | 95         |
| 5.7 Advantage.....                          | 96         |
| <b>6.0 CONCLUSION</b>                       |            |
| 6.1 Conclusion.....                         | 97         |
| 6.2 Recommendation.....                     | 98         |
| <b>REFERENCE.....</b>                       | <b>99</b>  |
| <b>APPENDIX A.....</b>                      | <b>103</b> |

## LIST OF FIGURES

|      |  |    |
|------|--|----|
| 1.1  | Process flowchart  | 4  |
| 1.2  | Show the reading on of the pump  | 7  |
| 1.3  | Show the angular misalignment  | 9  |
| 1.4  | Effect on shaft caused by misalignment   | 10 |
|      |  |    |
| 2.1  | Common Types of Soft Foot  | 15 |
| 2.2  | Types of soft foot   | 16 |
| 2.3  | Soft foot remedies   | 17 |
| 2.4  | An example of preload on the bearings  | 18 |
| 2.5  | Parallel Soft Foot   | 19 |
| 2.6  | Angular Soft Foot  | 19 |
| 2.7  | Reading dial indicator   | 20 |
| 2.8  | Measure soft foot with feeler gauge and fill gap completely  | 21 |
| 2.9  | Checking for softfoot  | 22 |
| 2.10 | Step shimming  | 22 |
| 2.11 | Measurement of vertical shift  | 24 |
| 2.12 | Before the loosening sequence  | 27 |
| 2.13 | After the loosening sequence   | 27 |
| 2.14 | Phase relationship can show differences between vertical measurements on the bolt,<br>machine foot, base plate or base | 28 |
| 2.15 | Flow chart for shaft alignment process   | 30 |
| 2.16 | Soft foot to be corrected  | 32 |
| 2.17 | Offset misalignment  | 35 |
| 2.18 | Example of an acceptable misalignment for an 1800 rpm machine  | 36 |
| 2.19 | Angular misalignment   | 37 |
| 2.20 | A, B, C, D size shims  | 40 |

|      |   |    |
|------|---|----|
| 2.21 | Stainless steel precut shim packs                               | 41 |
| 2.22 | Relief valve  | 42 |
| 2.23 | Shim mounting   | 43 |
| 2.24 | Baseplate Grouting  | 44 |
| 2.25 | Screen shot captured from a SolidWorks top down design approach | 47 |
|      |   |    |
| 3.1  | High-level problem solving during early design                  | 54 |
| 3.2  | Flow chart important steps in design                            | 56 |
| 3.3  | The importance of material selection in product development     | 61 |
| 3.4  | Final design  | 63 |
| 3.5  | Before cutting  | 63 |
| 3.6  | Machine set up according to dimension                           | 64 |
| 3.7  | The workpiece was clamped properly                              | 64 |
| 3.8  | Control the speed rate  | 65 |
| 3.9  | Cutting the length of workpiece                                 | 65 |
| 3.10 | Finished workpiece  | 66 |
| 3.11 | Cutting the width of workpiece                                  | 66 |
| 3.12 | Oiling the material   | 67 |
| 3.13 | EDM Machine   | 67 |
|      |   |    |
| 4.1  | Isometric drawing   | 73 |
| 4.2  | Isometric drawing   | 74 |
| 4.3  | Front view  | 75 |
| 4.4  | Right view  | 76 |
| 4.5  | Top view  | 76 |
| 4.6  | Bottom view   | 77 |
| 4.7  | Isometric view  | 78 |
| 4.8  | Isometric drawing   | 79 |
| 4.9  | Isometric drawing   | 80 |

|      |                   |    |
|------|-------------------|----|
| 4.10 | Front view        | 81 |
| 4.11 | Right view        | 81 |
| 4.12 | Top view          | 82 |
| 4.13 | Bottom view       | 82 |
| 4.14 | Isometric view    | 83 |
| 4.15 | Isometric drawing | 84 |
| 4.16 | Isometric drawing | 85 |
| 4.17 | Front view        | 86 |
| 4.18 | Right view        | 86 |
| 4.19 | Top view          | 87 |
| 4.20 | Bottom view       | 87 |
| 4.21 | Isometric view    | 88 |
| 4.22 | Isometric view    | 89 |
| 4.23 | Front view        | 90 |
| 4.24 | Right view        | 90 |
| 4.25 | Top view          | 91 |
| 4.26 | Bottom view       | 91 |

## LIST OF TABLES

|     |                                   |    |
|-----|-----------------------------------|----|
| 1.1 | Gantt chart                       | 5  |
| 2.1 | Laser Soft Foot Locator Results   | 25 |
| 2.2 | Table of Maximum Allowable Offset | 35 |
| 2.3 | Maximum Allowable Angularity      | 37 |
| 3.1 | Characteristic of design          | 57 |



# CHAPTER 1

## INTRODUCTION

### 1.1 Introduction

In theory, machine alignment is a straightforward process, but in real world applications, it is often compounded by structural faults such as soft foot, piping strain, induced frame distortion, excessive bearing clearance or shaft rubs.

For this project, it will examine how to eliminate soft foot which is some of the typical reasons why alignments are unsuccessful. In theory, machine alignment is a very straightforward process. With some type of measuring device extended across the coupling, the shafts are rotated to several positions (at least three) to determine the relative position between them (Skeirik R. D., 1997). Since alignment is an iterative process, which meaning that the misalignment should continuously decrease with each machine move, it is theoretically only a matter of sufficiently repeating alignment corrections until an acceptable solution is achieved.

Soft foot poses a challenge for plant operations and maintenance personnel. The common term for machine frame distortion, soft foot is caused when one or more feet of a machine are shorter, longer or angle some way different than the rest of the feet (Hamnernick I., 2006). This non-uniformity causes stress on the machinery when the foot is force into place by tightening the hold-down bolt.

In fact, quality alignment is not dependent on the type of measurement system used but dependent on how to solve problems happen in the alignment. Any good dial indicator set or laser system should be sufficient method to perform quality alignments.

To prevent any soft foot problems occur, the installed of the shim must done by personnel that has enough trained in mechanical seal installation practices. The other definitely limitation or disadvantages of shim such as material properties that using to construct the shim. Regarding to material properties, influence corrosion factor is very important to keep up the material strength in good condition. Stated that not all type of materials can be used for shimmed the pump. Although the steel materials are very strong but there are some type of steels can be easily become corrosion. This can limit the performance function for shim (Goulds Pumps (2002)).

## **1.2 Objective**

- a) Analyse effect on softfoot during alignment process.
- b) Study and develop shimless system that can overcome the problem.

## **1.3 Scope of study**

There are many problems can occur during alignment process. Firstly in this project, the main scope of study is to study the problem of softfoot and effect on alignment to understand the concept of shaft alignment. In other words, the important steps in design and develop shimless footing system that must be recognise and identify the problems that may arise during the constructions of the shimless footing system. Finally, to

analyse the effectiveness of shimless unit compare to conventional shim in rectifying misalignment problem.

## **1.4 Report Organization**

This thesis consists of six chapters:

Chapter 1: Introduces of Shaft Alignment, the effect of soft foot on alignment, problem arises in industry which drive to develop the better shimless, objective and scope of this project.

Chapter 2: Literature review from journal, books and internet. The area covered including principle for shaft alignment, method in alignment, procedures, tolerance etc.

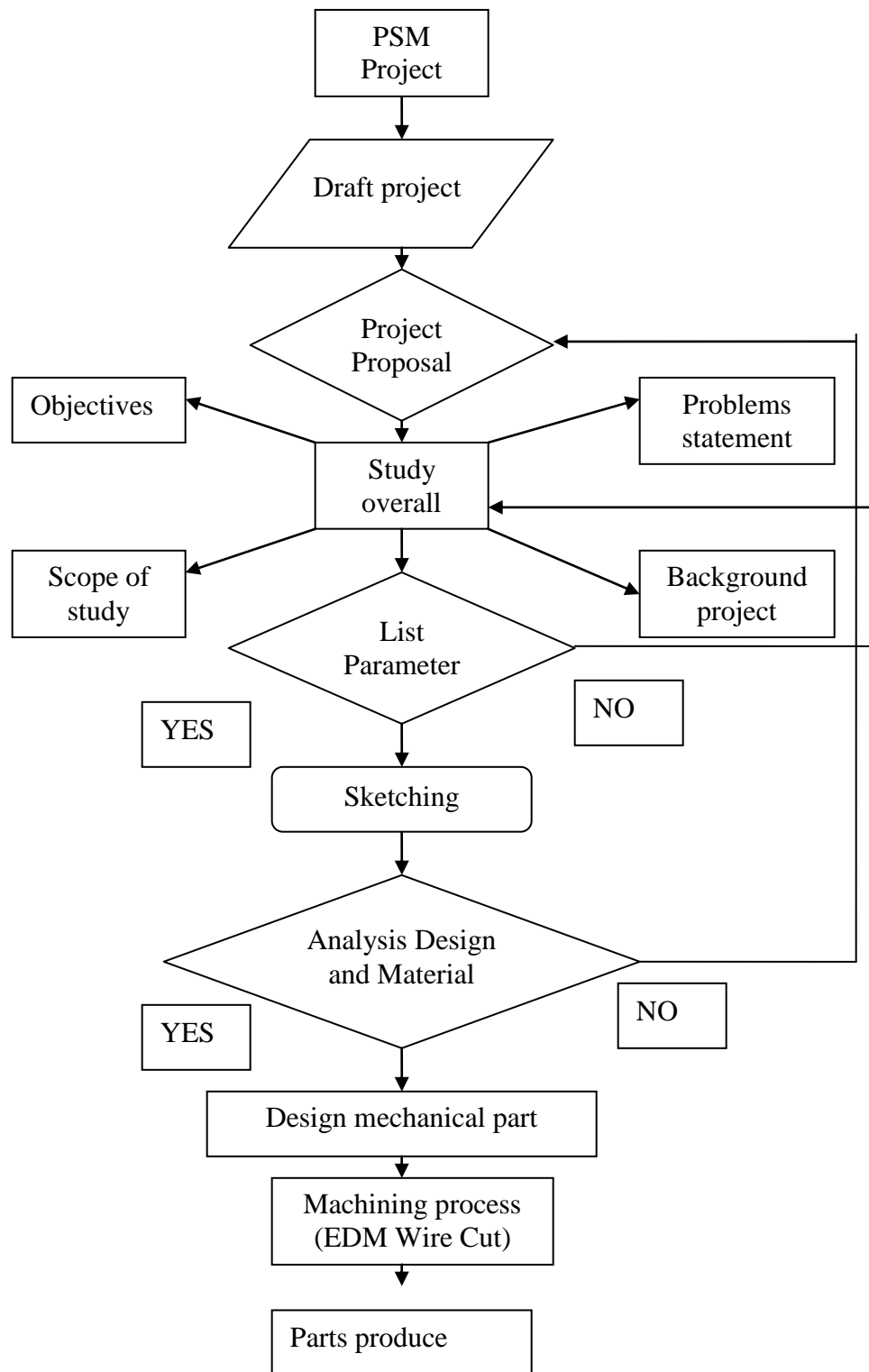
Chapter 3: Describes methodology to develop the system, the requirement to ensure the design of shimless, selection material etc.

Chapter 4: Result of design that has been obtained.

Chapter 5: Discussion on reliability of product design and improvement.

Chapter 6: Conclusion for the whole project and recommendation for future work.

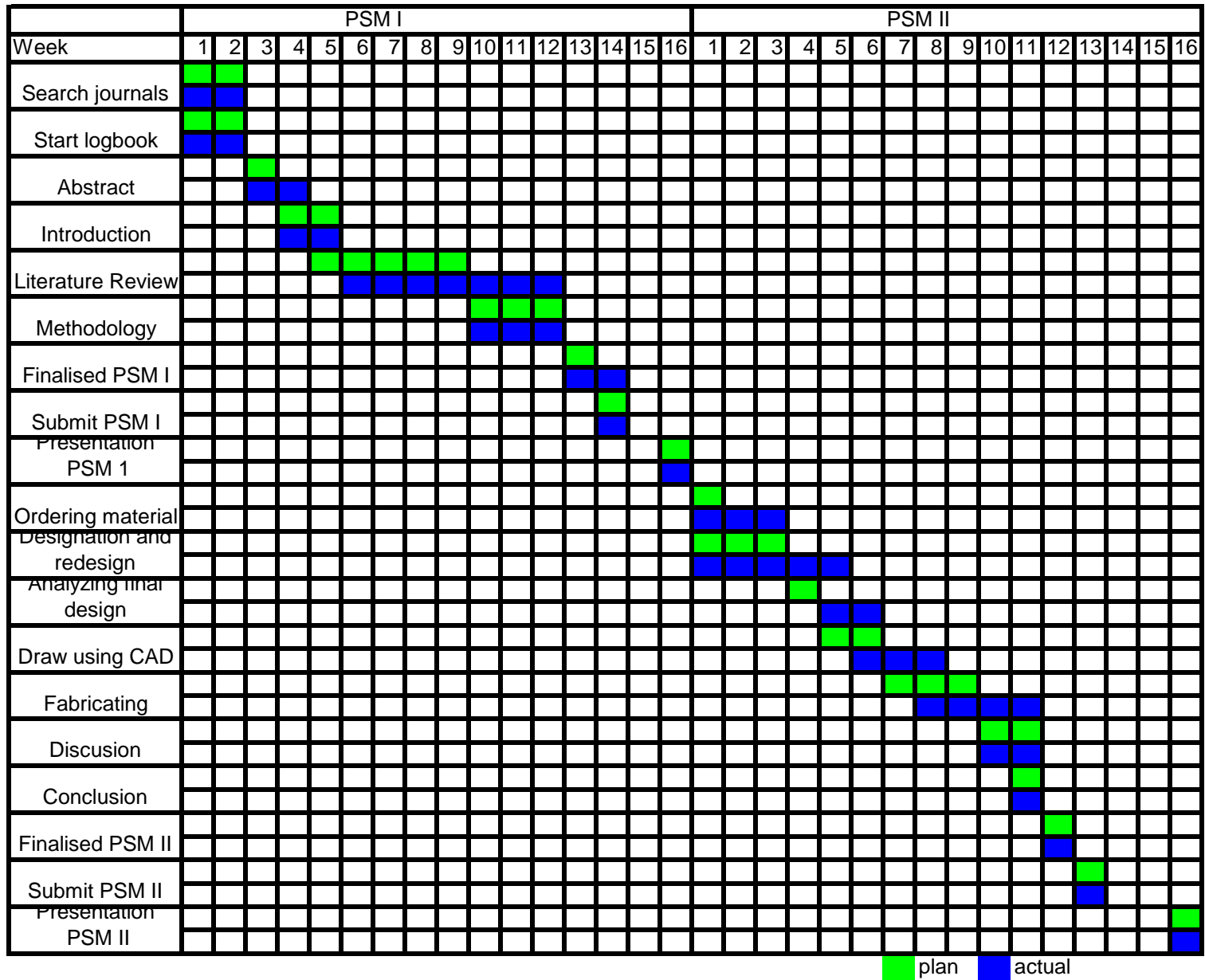
## **1.5 Flow Chart**



**Figure 1.1: Process flowchart**

## **1.6 Gantt Chart**

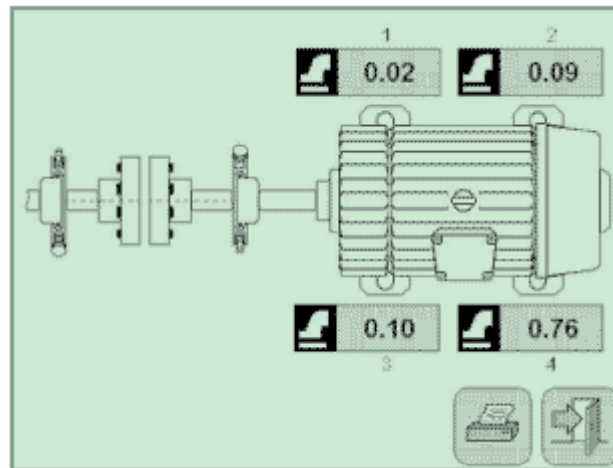
**Table 1.1 Gantt Chart**



## 1.7 Problem Statement

### 1.7.1 The Effect of Soft Foot on Alignment

The soft foot is one of the problems and challenges for plant operations and maintenance personnel. It is the common term for machine frame distortion, soft foot is caused when one or more feet of machine are shorter, longer or angled somewhat different than the rest of the feet. This non-uniformity causes stress on the machinery when the foot is forced into place by tightening the hold-down bolt (Hamernick I., 2006). The missing shims under a foot, a bent foot, or deteriorating base plate or foundation can cause this condition.



**Figure 1.2: Show the reading on of the pump (McNally Institute (2005))**

Besides that, the soft foot condition also can causes many of the failed bearings, broken shafts, and high vibration readings associated with misalignment.

### **1.7.2 The minimum thickness shimless for soft foot**

The bottoms of the machine feet shall rest on the base or foundation with 90 percent contact of the footprint (Wowk V., 2000). A 0.003 inch thick shim shall not penetrate under any foot with all hold down bolts loose. This is an unforeseen condition and will require more time to correct (Wowk V., 2000). Resonant foundations or bases are dynamic structural defects. This will cause high vibration at specific speeds. Resonances are not detectable during static alignment measurements.

A dial indicator, or other measuring devices, shall be fixture to measure the vertical rise at each foot as the hold down bolt is loosened. According to Wowk V. (2000), all other bolts shall remain tight. A rise of less than 0.002 inch is acceptable. A rise of more than 0.002 inch shall be corrected by adding shims. After shim changes are made, the above test shall be repeated at all feet until less than 0.002 inch rise is measured at each foot. If shim changes cannot adjust the rise, then the base will need to be ground or machined.

### **1.7.3 Difficulties in performing alignment**

The shaft-to-shaft residual misalignment is acceptable when the intersection point of the two shafts is within the coupling area and the included angle between the shaft centerlines is small. These two criteria must be applied in two orthogonal directions, typically horizontal and vertical for convenience, and normalized to speed. That is, slow-speed machines are allowed a larger tolerance. High-speed machines are required to be better aligned (Wowk V., 2000). The intersection point of the two shafts is considered to be within the coupling area when the separation of the shaft centerlines at the center of the coupling is less than the tolerance values.