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(54) Title: PORTABLE SYSTEM FOR IMMOTIVE MULTIPHASIC MOTIVE FORCE ELECTRICAL MACHINE TESTING

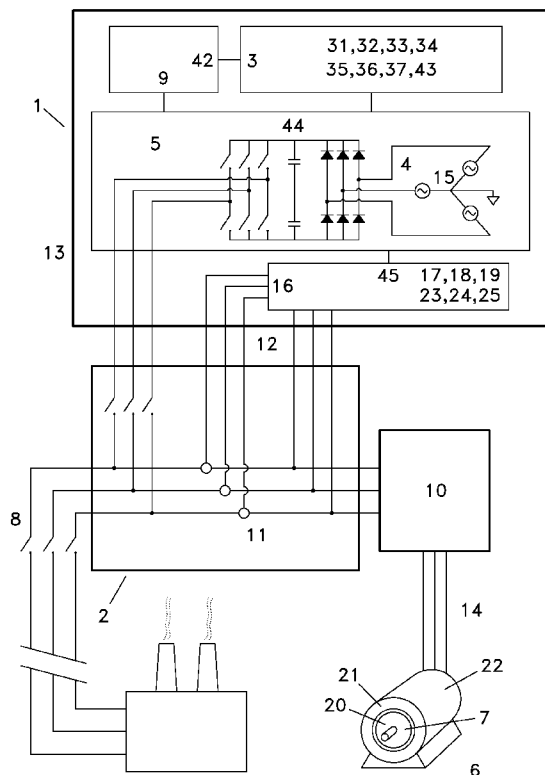


Fig. 1

(57) Abstract: A portable test device (1) can be configured as a rotor conductivity anomaly tester, a magnetic core anomaly tester, or a rotational eccentricity fault tester for a multiphase motive force electrical machine (6) by providing an immotive multiphase motive force electrical machine test signal from a plurality of multiphase motive force electrical machine signal generators (4) through a detachable electrical power connectivity (2) and by having a multiphase motive force electrical machine fault analyzer (16) that can sense responses and discern the existence of a fault. Control of the test signal can be accomplished by an immotive multiphase test signal controller (3) that varies frequency and achieves incremental movement or to achieve stator magnetization plane angle changes or movement that tests angular relationships.



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Portable System for Immotive Multiphasic Motive Force Electrical Machine Testing

TECHNICAL FIELD

The present invention relates to methods and devices to test electric machine circuitry. Specifically it relates to systems providing a portable device to test for various faults in a multiphasic motive force electrical machine, such as moves or rotates through the application of multiple phases of power in normal operation. Separately, the invention also relates to designs for unique rotor conductivity anomaly testers, magnetic core anomaly testers, and rotational eccentricity fault testers.

BACKGROUND

Electric machines, such as electric motors or the like play a critical role in our society. They often provide operations which many times cannot be interrupted. Continued, uninterrupted operation is often critical to the devices for which they are a component. Oftentimes, they cannot be permitted to fail. Unfortunately, their operation can at times be attended by internal faults and weakened components. These weaknesses can exist in a stator, in a rotor or other moving component, or in the configuration of a rotating device.

Considering the stator of an induction machine as one example, it can be understood that the stator core of an induction machine is often built from thin insulated, silicon-steel (Si-Fe) laminations to minimize the hysteresis and eddy current losses for high efficiency operation. The individual lamination sheets are usually deburred and coated with insulation material to prevent conduction between the sheets to reduce the risk of inter-laminar eddy currents. The laminations are usually held tightly together and shorted to the frame for structural rigidity (prevention of vibration) and safety. The laminations may be welded together for small machines, and may be interlocked with the axial frame bars and clamped, for larger machines.

The stator core loss can account for roughly 20% of induction machine losses at rated load. It can increase due to any type of defect in the stator core caused by excessive thermal, electrical, mechanical, or environmental stresses. Since the

interlaminar insulation material is subject to deterioration and damage, shorts between laminations can be introduced due to a number of reasons listed including:

- Stator-rotor contact due to machine mechanical defects,
- Core overheating during rewind (burnout oven), or due to ground current flow or cooling defects,
- Defects, damage, or foreign materials introduced during manufacturing, inspection, or repair, and
- Abrasion due to vibration (core looseness or machine vibration).

If the laminations are shorted for any reason such as those listed above, a circulating interlaminar eddy current larger than that compared to normal operation can be induced in the core. The increase in eddy current can result in additional losses and can decrease the efficiency of the machine. Localized heating due to the fault current can also damage the stator winding insulation leading to ground failure. For large machines, the core fault can gradually progress in severity and can even result in melting of the stator core. In addition to the increase in eddy current losses, thermal stress or mechanical stress on the laminations due to compressive stress/ physical abuse can increase the hysteresis losses. Exposure to excessive thermal or mechanical stresses can alter the magnetic properties of the lamination (decrease in permeability), and can result in an increase in hysteresis losses.

When motors are operated with pulse width modulated (PWM) inverters, the stator core and inter laminar insulation can be exposed to higher thermal and electrical stresses. The high frequency voltage and current harmonic components due to PWM switching operation can cause higher capacitive leakage and can cause circulating eddy currents to flow in the stator core, which may result in additional heating. The cooling efficiency of the motor can also be reduced under low speed operation since the cooling fan speed can be reduced. This can result in operation at a higher temperature when the motor is driven with an inverter. The electrical (high dv/dt) and thermal (increased temperature) stresses can accelerate the degradation of the stator interlaminar insulation and core, and can increase the chances of failure. Although the above relates primarily to stator failures, it can be extended to rotor and other failures.

It can be seen from the discussion above that any type of defect in the stator core can increase the core losses (decrease in efficiency) and can increase the chances of machine failure (decrease in reliability). Since increase in core loss can be a symptom of stator core degradation leading to failure, it is important to monitor the core quality (losses) for reliable and efficient motor operation. It can also be seen that stator core condition monitoring is even more important for inverter-fed machines, since they are exposed to increased thermal and electrical stresses.

Unfortunately the available means of detecting core problems when the machine is in service has been to use chemical monitoring such as core monitors or tagging compounds to detect hot spots in the stator core. Although chemical monitoring is effective for detecting core problems on-line, it is only considered cost-effective for very large machines.

The most effective tests for detecting local damage in the stator core due to inter laminar insulation failure are the core ring test (loop test) and the low energy core tests.

In the core ring test, an external winding is formed around the yoke of the core after rotor removal to excite the yoke of the stator core at 80~100% of rated flux. After core excitation, an infrared *IR* thermal imaging camera is usually used to detect hot spots in the stator bore due to interlaminar fault currents. Low energy core tests can use the same excitation configuration, but may allow testing at 3~4% rated flux level. In these tests, a flux sensing probe is scanned in the axial direction along the inner surface of the core to detect irregular flux patterns caused by inter laminar fault current. Although these tests are effective for detecting and locating local core problems, they require rotor removal and specialized test equipment. These tests are usually applied to generators or large motors rated above tens of megawatts. Tests may also use a probe such as described in a patent of one of the current inventors, US Patent No. 6,847,224, hereby incorporated by reference.

For motors rated up to several megawatts, which often fall in the range of inverter-fed induction machines, the core loss test is the most commonly used test for stator core quality assessment. The stator core loss test setup is often identical to the core ring test above, where the yoke of the stator core is excited at near rated flux (often $\approx 1.32T$). The power input (stator core loss) may be measured to monitor problems in

the stator core and its insulation that result in an increase in core losses. This test can provide a good indication of the overall stator core condition, but it usually requires motor disassembly and rotor removal for testing.

The core loss can also be measured without motor disassembly if the loss segregation test procedure in IEEE STD. 112B is used. In this test method, the no load loss, which consists of the stator I^2R loss, P_s , stator core loss, $P_{c,s}$, and friction & windage loss, $P_{f\&w}$, is measured at a number of input voltages, often up to about 125% rated voltage. If the no load loss minus P_s is plotted as a function of the voltage squared at a number of voltage levels and the curve is extrapolated to zero voltage, the intercept of the curve at zero voltage represents $P_{f\&w}$. The stator core loss, $P_{c,s}$, can be obtained by subtracting P_s and $P_{f\&w}$ from the no load loss measurement. This test is also effective for monitoring the overall (average) condition of the core, but, it requires the motor to be operated at no load with a variable sinusoidal voltage source.

From the existing techniques, it can be seen that there are limitations to applying the currently available on-line and off-line core test methods to inverter-fed machines. On-line chemical monitoring cannot be justified for use in inverter-fed machines due to the cost involved in implementation. The off-line core ring test or low energy core tests could be used, but are not considered cost-effective for the machines rated below several megawatts. The core loss test is relatively simple and effective for monitoring core problems, but it usually can only be performed during a major outage since it requires machine disassembly and rotor removal. The no load loss segregation method does not require motor disassembly, but usually requires the motor to be run with the load removed at a number of voltage levels. It can be seen that all the core test methods are off-line tests that do not allow frequent monitoring of the core, and usually require motor disassembly or operation at no load. In addition, the tests suitable for inverter-fed machines can require specialized equipment for testing and may be only capable of testing the overall (or average) condition of the core.

Another type of fault is that of a rotor conductivity fault. Broken rotor bars (as one type of rotor conductivity fault), can account for 5~10% of induction machine failures. These can be caused by gradual deterioration due to a combination of thermal, mechanical, electromagnetic, dynamic, environmental operating stresses or

design/manufacturing defects. Often a crack is usually initiated between the bar and end ring connection. If a bar breaks, the rotor becomes electromagnetically asymmetric due to the absence of current in the broken bar.

There are both off-line and on-line methods available for detecting broken bars and some methods available include the single phase rotation test, growler test, magnetic imaging test, fluorescent dye penetration test, rated flux test, and the hot spot methods. The single phase rotation test is the only off-line method which does not require motor disassembly. In this test, though, two phases of the motor are excited with a single phase supply to produce a fluctuating field. The rotor is gradually rotated and the variation of the stator current is observed to detect the presence of rotor bars. This test is inconvenient because it requires proximity to the motor and the rotor shaft to be rotated, which could be very difficult depending on the motor and its operating environment.

The on-line methods analyze the spectrum of the speed, vibration, torque, flux, or current measurement to observe a particular speed dependent rotor bar characteristic frequency to detect asymmetry in the flux pattern due to asymmetric rotor current. On-line methods are convenient since bars can be monitored when the motor is energized. However, the cost is high because dedicated monitoring equipment must be installed for each motor. Since it relies on the speed dependent frequency, a speed measurement or estimate is required and it is difficult to use in applications where the speed varies rapidly due to variable load or speed command. Broken bar signatures can also be confused with load problems, and it is difficult to detect this frequency for low slip (light load/high efficiency) applications. Therefore, it is desirable to have a new method that can detect broken bars off-line remotely without disassembling the machine. Thus, it is desirable to test both stator core and rotor components more frequently without motor disassembly, motor operation, or specialized equipment. It is also desired to have improved sensitivity to detect local core and other problems. Given the importance of stator core, rotor, or other monitoring for inverter-fed machines, and the limitations of applying the existing techniques, it is a goal of the present invention to provide new testing approaches suitable for inverter-fed machines and that may provide a sensitive stator core and rotor quality assessment technique that

can be implemented for frequent monitoring without motor disassembly/operation, or additional hardware. Unfortunately none of the above techniques fulfill these criteria.

DISCLOSURE OF THE INVENTION

The present invention provides a portable test device to monitor identify faults
5 in a stator, rotor, or in eccentricity of a multiphasic motive force electrical machine without removal of components, in situ, and in a way that is more convenient than most existing techniques. It provides a fundamentally new technique that overcomes many of the problems of existing methods. In a variety of embodiments the present invention presents a new understanding through which different types of faults can be detected.

10 Accordingly, it is an objective of embodiments of the present invention to provide techniques that overcome the limitations of the most existing test methods. An objective is to provide a system that can be implemented in situ for an existing multiphasic motive force electrical machine.

Naturally, other objectives are presented throughout the specification and
15 claims, and the above list is not to be construed as limiting.

BRIEF DESCRIPTION OF THE DRAWINGS

-Figure 1 is a block diagram of a multiphasic motive force electrical machine test device according to one embodiment of the present invention.

-Figure 2 is a plot showing relative losses as a percent of load that can exist for a
20 typical breakdown of a multiphasic motive force induction powered device such as a rotating electrical motor.

-Figure 3 is a cross sectional depiction of a rotating multiphasic motive force electrical machine depicting the flux vector location as θ and a magnetic core fault location as θ_f .

-Figure 4 is a plot comparing a power measurement as a function of angle and
25 comparing faulty and healthy magnetic core components for a rotating multiphasic motive force electrical machine according to one embodiment of the invention.

-Figure 5 is a plot similar to that of Figure 4 with a normalized loss ($\% \Delta P_{in}$) that shows the comparison of losses for two different frequencies of test signal (f_1 and f_2).

-Figure 6 is a schematic depiction of an equivalent circuit as may exist when there is a
30 rotor conductivity anomaly present in a multiphasic motive force electrical machine.

-Figure 7 is a cross sectional depiction of a rotor of a multiphasic motive force electrical machine showing the angular relation of the collection of rotobars in such a machine and depicting a field location that is 90° apart from the rotobar fault.

-Figure 8 is a cross sectional depiction as in Figure 7 depicting a field location that is 0° apart from the rotobar fault.

-Figure 9 is a plot of impedance as a function of field position for faulty and healthy rotor components.

-Figure 10 is a plot similar to that of Figure 9 showing parameters of power for a constant voltage excitation by an immotive multiphasic test signal at different angular locations.

-Figure 11 is a depiction of a representative stator core fault in a rotating multiphasic motive force electrical machine.

-Figures 12 (a, left, and b, right) are depictions of a stator core for a loss test in visual and infrared depictions.

-Figure 13 shows experimental results of temperature increase over time for the above stator core.

-Figure 14 shows experimental results of core loss as a function of yoke flux density comparing a healthy and two faulty cores.

-Figure 15 shows experimental results of no load power loss as a function of input voltage and also comparing a healthy and two faulty cores.

-Figure 16 shows experimental results of power loss as a function of applied magnetic field angle for a test signal having a 1000Hz frequency and also comparing a healthy and two faulty cores.

-Figure 17 shows experimental results of percentage increase in power as a function of applied magnetic field angle for a test signal having a 1000Hz frequency for two faulty cores.

-Figure 18 shows experimental results similar to those depicted in Figure 17 but with a 500Hz frequency for two faulty cores.

MODE(S) FOR CARRYING OUT THE INVENTION

The present invention includes a variety of aspects, which may be combined in different ways. The following descriptions are provided to list actions and elements and

to describe some of the embodiments of the present invention. These elements are listed with initial embodiments, however it should be understood that they may be combined in any manner and in any number to create additional embodiments. The variously described examples and preferred embodiments should not be construed to
5 limit the present invention to only the explicitly described systems, techniques, and applications. Further, this description should be understood to support and encompass descriptions and claims of all the various embodiments, systems, techniques, methods, devices, and applications with any number of the disclosed elements, with each element alone, and also with any and all various permutations and combinations of all
10 elements in this or any subsequent application.

In order to understand the techniques of the present invention, it is helpful to understand both a basic machine or motor circuitry system. Figure 1 illustrates a basic design according to an embodiment of the present invention. The test device (1) may connect to a machine or motor circuitry system including a multiphasic motive force
15 electrical machine (6) that may be powered by an electrical supply (14) perhaps leading all the way back to a power plant. From this diagram, it be understood that the electrical supply (14) can be very expansive. The power plant or other effective source may be located miles and even hundreds of miles from the actual machine or motor itself, although testing is preferred to be accomplished proximate to the multiphasic
20 motive force electrical machine (6) itself for practical and economic reasons. As may be understood from Figure 1, the multiphasic motive force electrical machine (6) may be controlled by a motor control center (10). Since the multiphasic motive force electrical machine (6) is designed to provide a motive force, it will typically have some type of movement element (7). Naturally the multiphasic motive force electrical
25 machine (6) can be a rotating electrical motor. As an electrical motor, the multiphasic motive force electrical machine (6) can have a rotor (20), a stator (22), and a magnetic core (21).

At any point along the electrical supply (14), a test device (1) can have an insert. This insert can be a detachable electrical power connectivity (2), so that one can
30 detachably electrically connect the test device (1). The test device (1) can be designed to issue an immotive test signal for a multiphasic motive force electrical machine. This

specific type of test signal can be designed for different purposes in order to detect different faults. In this fashion, the test device (1) can be configured as a conductivity anomaly tester, a magnetic core anomaly tester, or a rotational eccentricity fault tester.

One aspect that can be important to understand is that the test device (1) can be portable. The test device can be contained with a housing or even a vehicle or trailer that can serve as a portable test device containment (13). The portability can be important because it can facilitate the step of accepting, a multiphasic motive force electrical machine in situ in its regular working environment. Disassembly and perhaps relocation to a laboratory facility or the like is unnecessary. Thus, by positioning a portable test device proximate to an electrical supply for the multiphasic motive force electrical machine (6), the test device (1) can be used at differing locations and on differing machines. The detachable electrical power connectivity (2) can issue from the test device (1) so it can be easily plugged it into the electrical supply (14) at any selected location. This detachable electrical power connectivity (2) can contain sensor elements (11) and other componentry to facilitate the test operations. The connection location of the detachable electrical power connectivity (2) can be before or after or even into the motor control center (10). Thus, the connectivity (2) can serve as a multiphasic motive force electrical machine in situ connectivity, and can serve to apply the immotive test signal to a rotor, a stator, or otherwise in situ. When appropriately configured, the test device (1) can be moved from site to site and can provide a signal that can be applied to a stator in situ or to a rotor in situ without any disassembly or interruption of machine operation.

As mentioned, the detachable electrical power connectivity (2) can issue from the test device (1). Test device (1) can contain signal generators such as multiphasic motive force electrical machine signal generators (4) that can establish an immotive multiphasic test signal. Multiphasic test signal can be supplied to the multiphasic motive force electrical machine (6). Test containment supply circuitry (5) can issue from the signal generators (4) and can supply the signal through the detachable electrical power connectivity (2) to the electrical supply (14). These multiphasic motive force electrical machine signal generators (4) can be controlled to conduct specific operations. This can be accomplished by an immotive multiphasic test signal

controller (3). Similarly, within the test device (1) there can be included analyzer capability to read the signal sensed by the sensor elements (11), and make appropriate determinations. Through appropriate design or configuration, the analyzer can serve as a multiphasic motive force electrical machine fault analyzer (16).

5 As mentioned above, the multiphasic motive force electrical machine signal generators (4) can be established within the test device containment (13) so that the test signal can be applied to at least a portion of the electrical supply (14). Naturally as may be understood, the signals can be generated by some type of inverter. The test device (1) may include harder may be a multiple phase test signal inverter (44) that
10 actually generates the signals. Thus, any type of a multiple signal output for a multiphasic machine can be considered as a providing multiphasic motive force electrical machine signal generators (4).

An important aspect of embodiments of the invention is that the signal that is output is actually an immotive multiphasic test signal. This immotive multiphasic test
15 signal is an electrical output that in spite of it being connected to the phases of a multiphase machine does not cause significant motion in the motive force electrical machine. This is accomplished by providing multiphasic signals whose relative amplitudes are selected so that the phase combination merely causes a pulse and not a rotational or other movement event. The significance of this type of a test signal can
20 be understood in context of the energy losses in induction machines.

The typical breakdown in a multiphasic motive force electrical machine (6) can often be characterized as five types of induction machine losses: the stator and rotor I^2R loss, P_s and P_r , core loss, P_c , friction and windage losses, $P_{f\&w}$, and stray loss, P_{stray} , are shown in Fig. 2 as a function of % rated load. It can be seen in the figures that P_{core} and
25 $P_{f\&w}$ are insensitive to load variation, whereas the I^2R and stray losses increase significantly with load for fixed frequency operation. The losses in the stator and rotor conductors, P_s and P_r , can be expressed as shown in,

$$P_s = 3I_s^2 R_s, \quad (\text{eq1})$$

$$P_r = 3I_r^2 R_r, \quad (\text{eq2})$$

30 where R_s and R_r represent the stator and rotor resistance, and I_s and I_r represent the stator and rotor current, respectively. It can be seen in (eq1)-(eq2) that the conductor

losses increase proportionally with the square of the current. The losses in the stator and rotor core, $P_{c,s}$ and $P_{c,r}$, consist of hysteresis and eddy current losses, P_h and P_e . They can be expressed analytically as shown in (eq3)-(eq4), respectively, as a function of the peak flux density, B_{peak} , and excitation frequency, f .

$$P_h = k_h B_{peak}^m f \quad (\text{eq3})$$

$$P_e = k_e B_{peak}^2 f^2 \quad (\text{eq4})$$

Constants k_h and k_e depend on the geometrical dimensions and physical properties of the lamination material, and superscript m in (eq3) is a constant between 1.5 and 2.5 that depends on the lamination material. It can be seen in (eq3)-(eq4) that both P_h and P_e increase with the flux density and excitation frequency, and most of the core losses are in the stator ($P_{c,s} \gg P_{c,r}$) under motor operation since the excitation frequency in the rotor is very low compared to that of the stator. The friction and windage losses occur due to the friction in the bearings and wind resistance between the rotating components (cooling fan, rotor stirrer, etc) and air, and can be approximated as

$$P_{f\&w} = k_f \omega_m^2 + k_w \omega_m^3, \quad (\text{eq5})$$

where k_f and k_w are constants and ω_m is the motor speed. It can be seen in (eq5) that the friction and windage losses increase with motor speed. The stray loss represents the portion of the total loss in the machine that is not accounted for in the P_s , P_r , P_c , $P_{f\&w}$ losses described above.

When performing the core loss test, the measured input power includes only the stator core loss, if the excitation winding loss is compensated for in the loss measurement. In the loss segregation test under no load, P_s and $P_{f\&w}$ must be separated from the input power measurement to obtain the stator core loss, as can be seen in Fig. 2.

The main concept of using the test device (1) as a magnetic core anomaly tester, a rotor conductivity anomaly tester, or a rotational eccentricity fault tester involves using the inverter to test the stator core, the rotor, or the overall eccentricity characteristics whenever the motor is not in use, namely, by applying a immotive multiphasic test signal. The inverter is operated to excite the machine using the stator winding or rotor elements with a pulsating AC magnetic field at a set of fixed locations, as shown in Fig. 3, by making the machine be stationary or when the machine is at

standstill or stationary. The change in the input power can be measured to monitor the increase a fault such as in the core loss due to core problems, and as in the core loss or loss segregation test. Since the stator core or rotor quality can be tested whenever the motor is stopped, it can provide frequent testing compared to existing off-line tests performed during a major outage (typically once every 3-6 years). This can be significant when it is understood that faults can propagate rapidly once they arise. It can be applied to improve the reliability and efficiency of the multiphasic motive force electrical machine (6) since an increase in the losses due to core or stator or rotor problems can be detected at an early stage before such progress to a failure. This is a significant improvement in the maintenance strategy compared to existing test methods since the core or stator or rotor can be tested frequently without motor disassembly or motor operation. Frequent testing also results in savings in the maintenance cost since prioritization and scheduling of machine maintenance can be performed in a more efficient manner, and specialized test equipment is not required (core tester can even be built-in to the inverter). Embodiments can also be configured to be capable of detecting local core problems with high sensitivity. By using a fixed angular condition immotive multiphasic test signal waveform signal generator as one or more of the multiphasic motive force electrical machine signal generators (4) in the test device (1), the test device (1) can generate a fixed angular condition immotive multiphasic test signal that does not cause a force about an axis or along a line as in a linear actuator. The signal itself can prevent movement and can be an immotive multiphasic test signal by simply selecting the amplitudes for a typical multiphasic signal.

To apply an immotive multiphasic test signal, test device (1) can include an immotive multiphasic test signal controller (3). This multiphasic test signal controller (3) can cause an immotive signal to go through the test containment supply circuitry (5) and onto the multiphasic motive force electrical machine (6). A variety of controller configurations can achieve a variety of test functionalities. Voltage, current, or other variations can be made through the multiphasic test signal controller (3). For instance, controller can serve as an immotive multiphasic test signal voltage variation controller, an immotive multiphasic test signal current variation controller, or an immotive multiphasic test signal magnitude variation controller. With respect to

varying a magnitude of the signal, it can be understood that the controller can achieve its immotive functionality by making sure that each of the multiphasic signals have proper amplitudes so that the combination of each of them yields no rotation or other movement result. Relative amplitudes between the multiple signals (three are shown in the figure for illustrative purposes only; there may be any number, of course) can be varied proportionally so that no motion occurs or they can be varied differentially so that some limited amount of motion can occur, or such as when incrementing the device or magnetization plane to a different test location. Thus, in some embodiments, the controller can also serve as an immotive multiphasic test signal relative amplitude variation controller (37). Frequency variations can also be made and so the controller can serve as an immotive multiphasic test signal frequency variation controller.

By varying the test signal, additional information can be discerned. The test device (1) can include, or the controller can be configured as an immotive multiphasic test signal variation controller (31) that can vary the immotive multiphasic test signal. This variation can be of voltage, magnitude, relative magnitude, frequency, or other attributes of the test signal. As discussed below, in some embodiments, a frequency variation can yield significant information from which fault determinations can be made.

As mentioned above, the test signal needs to be an immotive test signal, namely, one that does not cause substantial motion. In keeping with this desire, the test device (1) can have a requirement that can help to assure that movement elements (7) are established in a substantially stationary state. This requirement can be met by an operator or can be automated, such as by having multiphasic machine operation shutdown switches (8) controlled by a capability within the test device (1). It should be understood that the multiphasic machine operation shutdown switches (8) are shown apart from the detachable electrical power connectivity (2) only to anticipate operational standards whereby power would normally be disconnected in order to connect a portable device's connector. Thus, it can be understood that the rotor or other movement element (7) can be de-energized by a separate operation or perhaps by operating multiphasic machine operation shutdown switches (8) through a test device capability, perhaps such as a separate deenergization controller or even by having the

immotive multiphasic test signal controller (3) serve as a deenergization controller. All that may be necessary is to or shut off power to the multiphasic motive force electrical machine (6). By establishing a substantially stationary state, the rotor or other movement element (7) can either be fully stopped or its movement can be small
5 relative to the test event so that individual features can be discerned. This could exist, for example by superimposing a perhaps sub-hertz frequency movement signal and a significantly higher frequency of application of a test signal to discern the desired results. The deenergization requirement can be a test protocol or prior connection standard or it could be an operative command, of course.

10 As can be seen from figure 1, waveform signal generators can be interconnected. The interconnection (15) can be at the signal generators themselves, or it may exist within the multiphasic motive force electrical machine (6), in circuitry, or the like. This interconnection can assure proper voltage operation to cause a truly immotive signal to be applied.

15 As mentioned above, the test signal can be varied and reapplied to the multiphasic motive force electrical machine (6). By applying different signals, different information can be gleaned and it can be a comparison between the information that yields the proper analysis. For such embodiments, the test device (1) can include an immotive multiphasic test signal reapplication controller (32).

20 Reapplication controller (32) can act to regenerate an immotive multiphasic test signal. This regenerated test signal can be a test signal that has been varied in some fashion from the prior applied test signal. The test device (1) can operate to utilize the same type of response to the regenerated immotive multiphasic test signal. In this fashion, the test device (1) can multiply sense a plurality of responses. These differing
25 responses can be compared by some type of analysis capability, perhaps by having the multiphasic motive force electrical machine fault analyzer (16) configured as a comparative test signal response analyzer. In instances where the test signal is known, this can be compared with an output to yield the desired information. Thus, the multiphasic motive force electrical machine fault analyzer (16) can serve as an input-
30 output comparative test signal response analyzer.

Analysis can be conducted in many manners. Power, voltage, current, and other variations can be sensed and analyzed and perhaps compared, thus the multiphasic motive force electrical machine fault analyzer (16) can function as a power variation comparative test signal response analyzer, or a voltage variation comparative test signal response analyzer, a current variation comparative test signal response analyzer. Similarly, it can achieve analyzing a power effect variation, analyzing a voltage effect variation, analyzing a current effect variation, or the like. The analyzer can serve as a frequency effect comparative test signal response analyzer, an angular effect comparative test signal response analyzer, a rotor angle effect comparative test signal response analyzer, a stator magnetization plane effect comparative test signal response analyzer, and the like.

As may be appreciated from the above, a variety of test signals can be applied. The signal generator capability can be a sinusoidal waveform immotive multiphasic test signal generator, an about $\frac{1}{4}$ Hz immotive multiphasic test waveform signal generator, an about 10Hz immotive multiphasic test waveform signal generator, an about 500Hz immotive multiphasic test waveform signal generator, an about 1000Hz immotive multiphasic test waveform signal generator, a sub-hertz immotive multiphasic test waveform signal generator, and even a high and low frequency immotive multiphasic test waveform signal generator. In this latter embodiment, both a higher frequency, namely one that reveals effects such as a core fault more readily as well as a low frequency, namely one that reveals effects such as a rotobar fault or even a deeper rotobar fault more readily can be applied.

Naturally frequencies can be superimposed or applied separately. A multiple frequency immotive multiphasic test signal generator (34) can be included so that more than one frequency is applied to the machine at some point or points in time. Multiple frequencies can even be achieved by a frequency sweep immotive multiphasic test signal generator. Superimposed frequencies can exist as a saw tooth or other known waveform immotive multiphasic test signal generator, or even a Fourier transform determinate waveform immotive multiphasic test signal generator whereby the Fourier transform and thus frequency content of a signal is known a priori. As mentioned above, a very low frequency signal such as might cause incremental movement (as

opposed to a test) can be included. This can be superimposed as well with a high frequency immotive multiphasic test signal. In general, the test device (1) can cause generating a plurality of different frequency immotive multiphasic test signals, any or all of which can be separately issued or can be superimposed with each other or a movement signal.

One aspect that can be understood with respect to a rotor fault is the fact that depth indicia can exist. For example, lower frequency signals will penetrate a roto bar more deeply and thus can yield information – even if not quantitative -- about a deeper fault. Thus embodiments can include a variable depth immotive multiphasic test waveform signal generator. The signals can be tailored to the component or effect of interest and so there can be a rotor component immotive multiphasic test waveform signal generator, a stator component immotive multiphasic test waveform signal generator, a first component optimized immotive multiphasic test waveform signal generator, a second component optimized immotive multiphasic test waveform signal generator, a first effect indicative immotive multiphasic test waveform signal generator, a second effect indicative immotive multiphasic test waveform signal generator, a depth effect indicative immotive multiphasic test waveform signal generator, or the like.

With respect to the sensor element or elements (11), the response of the machine can be sensed by a current sensor, a voltage sensor, or otherwise, thus, the sensor element(s) can be a variety of devices that serve as a multiphasic motive force electrical machine response sensor element (11). The sensed information can be returned to the test device (1) by a wire or can be wireless, and either capability can act as the sensor return (12). When configured or read for different faults, these can be considered as a magnetic core response sensor element, a rotor conductivity response sensor element, or a rotational eccentricity response sensor element. Multiple parameters can be sensed as well. In considering the sensor, as one may appreciate, if the test signal is a voltage, it may be best to sense current, and vice versa. Thus, the step of generating a voltage source immotive multiphasic test signal or a like generator can be associated with a current response immotive multiphasic test signal sensor element or the step of sensing a current response. Similarly, the step of generating a current source immotive

multiphasic test signal or a like generator can be associated with a voltage response immotive multiphasic test signal sensor element or the step of sensing a voltage response. Sensing a power effect, sensing a voltage effect, sensing a current effect and similar elements should all be understood as within the ambit of this invention.

5 As mentioned, the multiphasic motive force electrical machine fault analyzer (16), can be configured to assess the existence of a fault in the multiphasic motive force electrical machine (6). It can be configured to sense any combination of or as any combination of a stator magnetization core fault analyzer (17), a rotor conductivity anomaly analyzer (18), or a rotational eccentricity fault analyzer (19). In observing
10 and assessing varying test signals, it can serve as a comparative test analyzer (25). These varied signals can be particularly revealing when the test device (1) includes an immotive multiphasic test signal frequency variation controller that can vary a frequency of the immotive multiphasic test signal. In this instance, the analyzer should be configured as a frequency variation effect analyzer (23) so as to be able to discern
15 the existence of a frequency variation effect. This frequency variation effect can be one that varies substantially with a frequency squared and so the analyzer can be configured as a frequency squared proportional effect analyzer. Similarly the analyzer can discern effects more subtle or less quantitative, such as discerning the existence of an effect that decreases with increasing frequency test signals or discerning the
20 existence of an effect that increases with increasing frequency test signals.

The invention can provide a magnetic core anomaly tester. To excite the core without inducing torque in the machine, a pulsating AC magnetic field can be applied using the inverter, as shown in Fig. 1. The inverter switches may be operated so that the voltage vector (flux vector) is alternated between θ and $\theta + \pi$ to produce a pulsating
25 field (if the flux vector angle, θ , is 0° , the flux vector pulsates between the 0° and 180° position). The flux vector may be applied to a set of fixed locations, as shown in Fig. 4, and the input power may be measured at each location. The pulsating field induces voltage in the rotor bars causing current flow in the rotor, but the motor does not rotate since there is no torque induced. This results in I^2R losses in the stator and rotor
30 conductors and core losses in the stator and rotor core. It should be noted that the core loss in the rotor, $P_{c,r}$, is comparable to that of the stator, $P_{c,s}$, since the rotor is at

standstill. For die-cast squirrel cage rotors, there will be significant inter laminar current flowing in the rotor laminations through the rotor bars and/or shaft, resulting in large rotor core losses. The input power, P_{in} , which is the sum of the loss components, can be calculated from the input voltage, v_{abcs} , and current, i_{abcs} , measurements as,

$$\begin{aligned} P_{in} &= P_s + P_r + P_{c,s} + P_{c,r} \\ &= v_{as} i_{as} + v_{bs} i_{bs} + v_{cs} i_{cs} = \frac{3}{2} (v_{qs} i_{qs} + v_{ds} i_{ds}) \end{aligned} \quad (eq6)$$

In a preferred embodiment of the magnetic core anomaly tester invention, P_{in} is calculated as a function of θ (ranging between 0 and 180 electrical degrees), and the pattern of P_{in} vs. θ is observed to detect core problems that result in increase in hysteresis or eddy current losses.

Since an objective can be to monitor the core quality from the core loss measurements, the excitation and computation may be performed so that the change in stator core loss can be observed with high sensitivity. To maximize $P_{c,s}$, it can be seen in (eq3)-(eq4) that it can be advantageous to excite the core at high frequency, f , with high B_{peak} , to increase P_h and P_e . This can improve the sensitivity of detecting an increase in $P_{c,s}$ due to core problems. For a given frequency, there is a limit to increasing B_{peak} (voltage) due to the stator current limit and since the dc link voltage is fixed. Therefore, the core can be excited at a frequency higher than rated frequency to improve the sensitivity (typically at 250Hz~1kHz). Increasing the excitation frequency further could improve the sensitivity unless magnetic skin effect limits flux penetration. However, it may also increase the hardware requirements for accurate P_{in} calculation (faster sampling frequency and increased computational burden). Therefore, the optimal excitation frequency could be determined based on the drive system specifications. Once P_{in} is obtained, the non-critical stator copper loss can be estimated and separated from P_{in} to improve the sensitivity to increase in core loss. This can be one way to eliminate non-critical effects and so embodiment can include a non-critical effect eliminator (45) or a resistance loss effect eliminator that can serve for separating out expected resistance loss effects or other noncritical effects such as a roto-bar effect that is not magnified due to rotation.

The value of P_s can be calculated from the current measurements and R_s estimate, as shown in (eq1). The R_s estimate can easily be obtained from a dc test

performed on the stator winding using the inverter. Since it is difficult to separate P_r or $P_{c,r}$, the compensated input, P'_{in} , consists of P_r , $P_{c,s}$, $P_{c,r}$, as shown in

$$\begin{aligned} P'_{in} &= P_r + P_{c,s} + P_{c,r} \\ &= P_{in} - \hat{R}_s (i_{as}^2 + i_{bs}^2 + i_{cs}^2) = P_{in} - \frac{3}{2} \hat{R}_s (i_{qs}^2 + i_{ds}^2), \end{aligned} \quad (\text{eq7})$$

where, $\hat{R}_s$ is the estimate of R_s .

- 5 To analyze the influence of an inter laminar stator core fault on the P'_{in} vs. θ distribution, the cross section of an induction motor shown in Fig. 3 can be considered. If it is assumed that the stator winding is sinusoidally distributed, the spatial flux density distribution of the pulsating field in the airgap, B_{gap} , can be expressed analytically as

$$B_{gap}(\omega t, \alpha, \theta) = B_{peak} \sin \omega t \cdot \cos(\alpha - \theta), \quad (\text{eq8})$$

- 10 where, B_{peak} is the peak flux density, θ is the flux vector electrical angle, and α is the electrical angle with respect to the as-axis, as shown in Fig. 3. If an interlaminar short is present in the stator core, it is the flux in the yoke of the core that induces the eddy current causing additional losses. For an airgap pulsating field shown in (eq8), the flux density distribution in the yoke, B_{yoke} , can be derived as

$$15 \quad B_{yoke}(\omega t, \alpha, \theta) = B'_{peak} \sin \omega t \cdot \sin(\alpha - \theta). \quad (\text{eq9})$$

- It can be seen in (eq9) that the peak of B_{yoke} is 90° (electrical) apart from the peak of the B_{gap} ; therefore, if the flux vector is pointing towards the fault, P'_{in} is at its minimum value since the yoke flux that induces the fault current is at its minimum. If the flux vector is pointing to a location 90° apart from the fault, P'_{in} is at its maximum value
20 since the yoke flux that induces fault current is at its maximum.

- For an ideal healthy machine, P'_{in} is constant and independent of the flux vector position (P'_{in0}), as shown in Fig. 4, since the motor is symmetrical. If an interlaminar stator core fault is present, the increase in P'_{in} , $\Delta P'_{in}$, depends on the relative location of the flux vector (θ) with respect to the fault (θ_f). Since the additional eddy current loss
25 due to the fault is proportional to the square of the yoke flux, an approximate analytical equation of P'_{in} can be derived from (eq4) and (eq9) as

$$\begin{aligned} P'_{in}(\theta) &= P'_{in0} + \Delta P'_{in}(\theta) \approx P'_{in0} + B_{peak}^2 \sin^2(\theta - \theta_f) \\ &\approx P'_{in0} + \frac{B_{peak}^2}{2} (1 - \cos 2(\theta - \theta_f)) \end{aligned} \quad (\text{eq10})$$

at a given excitation frequency. The P'_{in} measurements for a healthy core and a core with an interlaminar fault shown in Fig. 3, are shown in Fig. 4 as a function of θ . For a core fault located in the 210° location (Fig. 3), the peak of P'_{in} is located 90° apart from the fault (120°) as shown in Fig. 4 according to (eq10). It can be seen in the figure that

5 local problems in the stator core can not only be detected, but also located by observing the loss distribution. Since the spatial distribution of the loss can be monitored, local core problems can be detected with higher sensitivity compared to core tests that monitor the average core condition. This is another major advantage of embodiments over the existing core tests described in the art. In addition to interlaminar core faults,

10 any type of core problem that results in an increase in the core loss can be observed in the pattern of P'_{in} . Uniform deterioration in the laminations or inter laminar insulation would result in a uniform increase in P'_{in} .

Since it is the change in the P'_{in} from the healthy P'_{in0} that is being monitored, it is desirable to monitor the % increase in $P'_{in}(\theta)$, $\% \Delta P'_{in}(\theta)$, shown in (11) for core

15 quality assessment.

$$\% \Delta P'_{in}(\theta) = \frac{P'_{in}(\theta) - P'_{in0}}{P'_{in0}} \times 100\% \quad (\text{eq11})$$

Although it was assumed in (eq11) that $P'_{in0}(\theta)$ is constant, there is some small θ dependency in reality due to manufacturing imperfections and non-idealities in the core. Therefore, the P'_{in} distribution with respect to the baseline measurement ($P'_{in0}(\theta)$),

20 should be monitored whenever possible, to improve the sensitivity. The distribution of $P'_{in0}(\theta)$ and $P'_{in}(\theta)$ can be obtained for a fixed rotor position only if the test is performed off-line. The % increase in $P'_{in}(\theta)$, $\% \Delta P'_{in}(\theta)$, in this case can be expressed as shown in (eq12).

$$\% \Delta P'_{in}(\theta) = \frac{P'_{in}(\theta) - P'_{in0}(\theta)}{P'_{in0}(\theta)} \times 100\% \quad (\text{eq12})$$

25 As can be appreciated from the above mathematical analysis, embodiments of the invention can provide a magnetic core anomaly tester. This invention can discern the existence of a stator magnetization core fault by including a stator magnetization core fault analyzer (17) that is configured to assess the existence of a magnetic core anomaly such as by a galvanically disconnected component magnetic field

permeability fault analyzer. Such a fault can be sensed by a magnetic core response sensor element that can see responses of an interlaminar magnetic core fault. Such faults may even be discerned by the existence of a substantially frequency squared proportional effect as indicated in Fig. 5. Generally these faults may be manifested by a magnetic field loss effect or an eddy current effect.

The invention can also provide a rotor conductivity anomaly tester. Again, to excite the core without inducing torque in the machine, a pulsating AC magnetic field is applied using the inverter, as shown in Fig. 1. The responses can reveal the nature of the fault to be a rotor conductivity fault or the like. In this regard, it should be understood that as but one type of rotor conductivity fault, broken rotor bars, can account for 5~10% of induction machine failures. In the rotor conductivity invention, the inverter hardware can be used to excite the motor in a similar fashion as the stator core fault detector, but at a lower frequency. The equivalent circuit of the motor under this excitation can be derived as shown in Fig. 6 since the slip of the machine is equal to one. If the fluctuating field is 90 degrees apart relative to the location of the broken bar, as shown in Fig. 7, the current induced in the broken bar is supposed to be the largest, but will be missing. This results in an increase in the effective rotor resistance, R_2 , and leakage inductance, X_2 , when compared to a healthy rotor. This will increase the resistive and reactive components of the equivalent input impedance of the motor, $Z_{in}=V/I_1$, shown in Fig. 6. If the fluctuating field is 0 degrees apart relative to the location of the broken bar, as shown in Fig. 8, the current induced in the broken bar is close to zero. Therefore, the effective rotor resistance, R_2 , and leakage inductance, X_2 , and the resistive and reactive components of the equivalent input impedance of the motor, Z_{in} , will not change much (slight increase) compared to a healthy rotor.

The equivalent impedance and power can be calculated from the voltage and current measurements at each location of the field. Since the resistance and reactive components increase when the field is at 0 and 180 degrees, as shown in Fig. 7, and does not change much (slight increase) when the field is located at 90 degrees, as shown in Fig. 8, the pattern of the impedance plot as a function of field position can be predicted, as shown in Fig. 9. For a constant voltage excitation at different locations of θ , the current and power will decrease at 0 and 180 degrees since the impedance

increases, as shown in Fig. 10. Therefore, the real or imaginary part of the impedance, the magnitude, angle of the impedance, real or reactive power, or the current magnitude pattern as a function of field position can be used as an indicator of broken bar or other rotor conductivity problems.

5 As can be appreciated from the above, embodiments of the invention can provide a rotor conductivity anomaly tester. This invention can discern the existence of a rotor conductivity anomaly by including a rotor conductivity anomaly analyzer (18) that is configured to assess the existence of a rotor conductivity anomaly such as a broken rotobar, a rotor resistance anomaly, a rotor circuit resistance anomaly, a motor
10 brush imbalance anomaly, or even a a motor diode bridge anomaly. Such a fault can be sensed by a rotor conductivity response sensor element that can see responses of any of the above mentioned faults. Such faults may even be discerned by the existence of an effect that decreases with increasing frequency test signals and even by including a decrease with increasing frequency test signal effect analyzer. As mentioned earlier, a
15 rotobar fault depth indicia analyzer can include assessing the existence of some type of rotobar fault depth indicia.

Yet another type of tester that can be provided is a rotational eccentricity fault tester. This type of tester can assess rotor eccentricity, which is the state where the center of the rotor rotation and center of stator are not aligned in some manner. This
20 can be caused due to ovality of core, bent shaft, shaft misalignment, bearing damage, or unbalanced magnetic pull. There is always some degree of static eccentricity in a machine as an eccentricity within 10% is acceptable as manufacturing tolerance. Static eccentricity can lead to dynamic eccentricity, however, and can eventually cause stator-rotor rub, which will cause irreversible damage to the machine.

25 There are both off-line and on-line methods for detecting eccentricity faults. The single phase rotation test described for rotor bar detection can also be used for detecting eccentricity, but this test requires manual rotor rotation and a proximity to the motor, which makes it inconvenient. The feeler gauge “out-of-round “test, and total indicated reading (TIR) tests are also available for detecting eccentricity off-line with
30 the motor disassembled.

Since eccentricity causes permeance variation in the airgap, it results in an asymmetric flux in the airgap. Motor eccentricity can also be detected on-line by analyzing the spectrum of vibration, torque, flux, or current. The eccentricity characteristic frequency can be monitored in these waveforms to detect the problem.

5 However, the cost is high due to the requirement of permanently installing dedicated equipment to the machines, and because on-line methods often rely on speed information, and therefore are difficult to apply to rapidly varying load or speed applications. As in broken bar detection, eccentricity can be confused with load signatures.

10 Again the excitation method is from a device as shown in Fig 1 and is conceptually similar to the stator core fault and rotor conductivity detectors. These can be applied for detecting eccentricity since the spatial variation of airgap permeance due to eccentricity will cause variations in magnetizing and leakage inductances and magnetic saturation. Therefore, the spatial variations in impedance, power, or current
15 can be used for detecting static and dynamic eccentricity. A rotational eccentricity fault tester can discern the existence of an eccentricity fault by including a rotational eccentricity fault analyzer (19) that is configured to stimulate and then to analyze the existence of an eccentricity response. Such a fault can be sensed by a rotational eccentricity fault sensor element that can see responses due to an eccentricity fault.
20 Such faults may even be discerned by the existence of an effect that increases with increasing frequency test signals and as such embodiments may include an increase with increasing frequency test signal effect analyzer. The rotational eccentricity fault analyzer (19) may serve as a static eccentricity anomaly condition analyzer or a dynamic eccentricity anomaly condition analyzer.

25 As may be appreciated from the above, movement within the motive force electrical machine can be used to yield information. Movement can be of any component or merely of a field. The test device can include a movement signal generator (33) since the signal generator can achieve the movement. It can also include a locational variation effect analyzer (24) to determine the effect of the movement.
30 This can be facilitated by an immotive multiphasic machine angle test signal controller that acts to vary a machine angle, such as in a rotational machine, for the immotive

5 multiphasic test signal. This movement can occur in between applications of the test signal, and so the controller can serve as an interstitial angle change multiphasic machine angle test signal change controller (35) where movement occurs in between two applications of desired, perhaps identical test signals. Similarly movement can occur simultaneous to a perhaps much faster test. Thus embodiments can include a simultaneous angle change multiphasic machine angle test signal change controller (36) that can act during the application of test signals. Of course after such movement, the analyzer can serve as a comparative test analyzer (25) to see the differences due to such movement. For rotating electrical motors and the like, the controller can be configured as a multiphasic motive force electrical machine rotor movement controller (42). This movement can be sequential and can step around a half circle for example. Thus embodiments can include a sequential multiphasic motive force electrical machine magnetization location incrementor (9) and can provide for multiply incrementing a movement of a component. Movement can be only of the magnetization plane as well and the controller can be configured as an immotive multiphasic machine magnetization location change controller (43) that acts to change a magnetization location. This can be stepped around as well and so there can be the act of multiply incrementing a change of magnetization location. Increments can occur in a variety of steps such as: about five degree increments, about a rotor segment increment, about a stator segment increment, and about one hundred eighty degree total incremental movement.

Also the magnetic field can be varied by altering current or voltage or the like and such can be determined from known parameters of a particular test motor, test circuitry, or the like. Thus, the controller can be configured as an immotive multiphasic test signal magnetic field intensity factor variation controller which can be adapted to a specific machine, of course. Magnetic fields of 0.33T, 0.50T, 0.67T, 1.0T, or 1.33T can be generated.

To verify the validity of the proposed inventions, an experimental study was performed on a 4P, 380V, 10hp, aluminum die-cast squirrel cage rotor induction motor. A 600V, 15A inverter was constructed in the lab, and a commercial DSP (TMS320F2808) was used for controlling the inverter to excite the machine with

pulsating magnetic fields. To simulate interlaminar core faults, a number of faults with varying severity were introduced on the tooth tip by welding the stator bore, as shown in Fig. 11. Approximately half of the axial core length of 2 and 4 slots was welded at the 210° location (phase B winding slot in Fig. 3). The stator core was tested using the proposed technique before and after introducing the faults to observe the change in the pattern of $P'_{in}(\theta)$. In addition to the proposed technique, the core loss test and the IEEE 112B no load segregation test (with segregation of P_s) were also performed for comparison of results. When performing the core tests, the input power was calculated from the voltage and current measurements, and a commercial IR thermal imaging camera was used for measuring the temperature rise and distribution during the core loss test.

From this, a stator core loss (loop) test was performed on the motor with the core excited at 0.33, 0.66, 1.0, and 1.32T before and after inserting the two different types of faults, as shown in Fig. 12. The change in the temperature distribution at 1.32T was measured using an IR camera for 30 minutes in 1 minute intervals. The ambient (healthy) stator bore and maximum hot spot temperature under the 2 slot and 4 slot fault conditions are shown in Fig. 13. It can be seen that the temperature rise above ambient at the hot spot was approximately 20°C and 28°C for the two faults, respectively. The core loss was also calculated from the excitation coil input voltage and current after separating the stator I^2R loss, before and after fault insertion. The measured core loss as a function of yoke flux density for the healthy and faulty core is summarized in Fig. 14. It can be seen that the core loss increases with flux density and with fault insertion. The increase in core loss was 53.3% and 97.9% for 2 and 4 slot faults, respectively. Since it is recommended that a fault with a hot spot 10°C above ambient or 5% increase in core loss should be fixed, the inserted faults are serious defects that require immediate repair or replacement.

The input power loss under no load conditions was calculated from the stator input voltage and current after separating the stator I^2R loss, before and after fault insertion. The no load loss is shown in Fig. 15 as a function of stator voltage for the healthy and faulty stator core. It can be seen that the losses increase by 7.2% and 34.25% at rated voltage for 2 slot and 4 slot faults, respectively. The increase in the no

load loss (with P_s separated) indicates that there is a problem in the core that results in an increase in the losses. It can be seen that the core loss test is more sensitive than the no load test since it results in a larger % increase in losses under the same fault condition. This is because the P_s is the only type of loss being measured in the core loss test, whereas the $P_{f\&w}$ and P_{stray} that result from rotation are also measured in addition to P_s in the no load test. The results of the two tests clearly show that the fault inserted in the core results in an increase in the core loss.

To further test the proposed technique, the core was excited with 500Hz and 1kHz pulsating vectors. The inverter was operated with constant duty cycle bipolar PWM switching at 10kHz to produce the flux vectors. The pulsating flux vector angle was varied between 0 and 180 electrical degrees in 5 degree intervals, to observe the power loss as a function of flux position. The power loss was calculated from the phase, voltage, and currents and nominal stator resistance value based on (eq6)-(eq7). The input power, P'_{in} is shown in Fig. 16 for the healthy and faulty stator core as a function of flux vector angle when the excitation frequency is 1kHz. It can be seen that there is a noticeable increase in the power loss after fault insertion, and the pattern of the loss is as predicted in Fig. 4. The peak of P'_{in} is located at 120° (90° apart from the fault location), as predicted. It can also be seen that the power loss of the healthy stator core, P_θ , is not constant as a function of flux angle due to manufacturing imperfections in the motor.

The % increase in the power loss, $\% \Delta P'_{in}$, after fault insertion, is shown in Figs. 17-18 for 1 kHz and 500 Hz excitation, respectively. It can be clearly seen that local core problems that increase the core loss can be detected with high sensitivity by observing the magnitude and pattern of the power loss. The % increase in the power loss is small compared to the core loss and no load tests because the rotor I^2R loss and rotor core losses, P_r and $P_{c,r}$, are also included in the losses. Although the % increase in the fault indicator, $\% \Delta P'_{in}$, is smaller than that compared to existing techniques, additional information can be obtained from its pattern. Monitoring the pattern of the loss spatial distribution provides sensitive indications on local core problems compared to existing methods that monitor the average core condition.

As the above examples show, the inventive techniques for monitoring the existence, location, and severity of faults can be implemented based on the voltage and

current measurement. With these methods, the maintenance costs and safety risks can also be reduced. Embodiments can help improve the reliability, efficiency, and safety of the industrial facility. A simple technique for monitoring the quality of the stator core and rotor for inverter-fed induction machines is shown. By operating the inverter to excite the core or rotor with a set of high or low frequency pulsating fields at a set of fixed locations whenever the motor is at standstill information can be discerned. The power loss measured as a function of flux vector position is monitored to detect stator core problems that result in increase in core loss for stator core quality assessment.

The proposed inventions can be implemented in an inverter as a stand-alone diagnostics equipment for quality assurance (manufacturing) or machine inspection (machine shop/field). Whether implemented in an inverter or used as stand-alone equipment, the proposed technique has the following advantages over the core loss test or IEEE 112B loss segregation test that are currently accepted in industry:

- Frequent assessment of core condition: core can be tested automatically whenever motor is shutdown.
- Motor disassembly or rotor removal not required: testing can be performed with motor assembled
- Operation of motor not required: testing is performed at motor standstill
- Sensitive to local stator core problems: monitoring the loss spatial distribution provides a sensitive indication on local core problems compared to methods that monitor the average core condition
- Physical proximity to the motor not required: access to motor is not required for testing (this makes testing safe and convenient at hazardous locations)

The proposed technique is expected to help improve the reliability and efficiency of the motor and allow maintenance to be performed in a more flexible and efficient manner, since the core or rotor can be tested frequently whenever the motor is stopped.

As can be easily understood from the foregoing, the basic concepts of the present invention may be embodied in a variety of ways. It involves both test techniques as well as devices to accomplish the appropriate testing. In this application, the various techniques are disclosed as part of the results shown to be achieved by the various devices described and as steps which are inherent to utilization. They are

simply the natural result of utilizing the devices as intended and described. In addition, while some devices are disclosed, it should be understood that these not only accomplish certain methods but also can be varied in a number of ways. Importantly, as to all of the foregoing, all of these facets should be understood to be encompassed
5 by this disclosure.

The reader should be aware that the specific discussion may not explicitly describe all embodiments possible; many alternatives are implicit. It also may not fully explain the generic nature of the invention and may not explicitly show how each feature or element can actually be representative of a broader function or of a great
10 variety of alternative or equivalent elements. Again, these are implicitly included in this disclosure. Where the invention is described in device-oriented terminology, each element of the device implicitly performs a function. Apparatus claims may not only be included for the device described, but also method or process claims may be included to address the functions the invention and each element performs. Neither the
15 description nor the terminology is intended to limit the scope of the claims that will be included in any subsequent patent application.

It should also be understood that a variety of changes may be made without departing from the essence of the invention. Such changes are also implicitly included in the description. They still fall within the scope of this invention. A broad disclosure
20 encompassing both the explicit embodiment(s) shown, the great variety of implicit alternative embodiments, and the broad methods or processes and the like are encompassed by this disclosure. With this understanding, the reader should be aware that this disclosure is to be understood to support any subsequently filed patent application that may seek examination of as broad a base of claims as deemed within
25 the applicant's right and may be designed to yield a patent covering numerous aspects of the invention both independently and as an overall system.

Further, each of the various elements of the invention and claims may also be achieved in a variety of manners. Additionally, when used or implied, an element is to be understood as encompassing individual as well as plural structures that may or may
30 not be physically connected. This disclosure should be understood to encompass each such variation, be it a variation of an embodiment of any apparatus embodiment, a

method or process embodiment, or even merely a variation of any element of these. Particularly, it should be understood that as the disclosure relates to elements of the invention, the words for each element may be expressed by equivalent apparatus terms or method terms -- even if only the function or result is the same. Such equivalent, broader, or even more generic terms should be considered to be encompassed in the description of each element or action. Such terms can be substituted where desired to make explicit the implicitly broad coverage to which this invention is entitled. As but one example, it should be understood that all actions may be expressed as a means for taking that action or as an element which causes that action. Similarly, each physical element disclosed should be understood to encompass a disclosure of the action which that physical element facilitates. Regarding this last aspect, as but one example, the disclosure of a "sensor" should be understood to encompass disclosure of the act of "sensing" -- whether explicitly discussed or not -- and, conversely, were there effectively disclosure of the act of "sensing", such a disclosure should be understood to encompass disclosure of a "sensor" and even a "means for sensing" Such changes and alternative terms are to be understood to be explicitly included in the description.

Any patents, publications, or other references mentioned in this application for patent are hereby incorporated by reference. Any priority case(s) claimed by this application is hereby appended and hereby incorporated by reference. In addition, as to each term used it should be understood that unless its utilization in this application is inconsistent with a broadly supporting interpretation, common dictionary definitions should be understood as incorporated for each term and all definitions, alternative terms, and synonyms such as contained in the Random House Webster's Unabridged Dictionary, second edition are hereby incorporated by reference. Finally, all references listed in the list of References To Be Incorporated By Reference In Accordance With The Provisional Patent Application or other information statement filed with the application are hereby appended and hereby incorporated by reference, however, as to each of the above, to the extent that such information or statements incorporated by reference might be considered inconsistent with the patenting of this/these invention(s) such statements are expressly not to be considered as made by the applicant(s).

Thus, the applicant(s) should be understood to have support to claim and make a statement of invention to at least: i) each of the test devices as herein disclosed and described, ii) the related methods disclosed and described, iii) similar, equivalent, and even implicit variations of each of these devices and methods, iv) those alternative designs which accomplish each of the functions shown as are disclosed and described, v) those alternative designs and methods which accomplish each of the functions shown as are implicit to accomplish that which is disclosed and described, vi) each feature, component, and step shown as separate and independent inventions, vii) the applications enhanced by the various systems or components disclosed, viii) the resulting products produced by such systems or components, ix) each system, method, and element shown or described as now applied to any specific field or devices mentioned, x) methods and apparatuses substantially as described hereinbefore and with reference to any of the accompanying examples, xi) the various combinations and permutations of each of the elements disclosed, xii) each potentially dependent claim or concept as a dependency on each and every one of the independent claims or concepts presented, and xiii) all inventions described herein. In addition and as to computer aspects and each aspect amenable to programming or other electronic automation, the applicant(s) should be understood to have support to claim and make a statement of invention to at least: xvi) processes performed with the aid of or on a computer as described throughout the above discussion, xv) a programmable apparatus as described throughout the above discussion, xvi) a computer readable memory encoded with data to direct a computer comprising means or elements which function as described throughout the above discussion, xvii) a computer configured as herein disclosed and described, xviii) individual or combined subroutines and programs as herein disclosed and described, xix) the related methods disclosed and described, xx) similar, equivalent, and even implicit variations of each of these systems and methods, xxi) those alternative designs which accomplish each of the functions shown as are disclosed and described, xxii) those alternative designs and methods which accomplish each of the functions shown as are implicit to accomplish that which is disclosed and described, xxiii) each feature, component, and step shown as separate and independent inventions, and xxiv) the various combinations and permutations of each of the above.

With regard to claims whether now or later presented for examination, it should be understood that for practical reasons and so as to avoid great expansion of the examination burden, the applicant may at any time present only initial claims or perhaps only initial claims with only initial dependencies. The office and any third persons interested in potential scope of this or subsequent applications should understand that broader claims may be presented at a later date in this case, in a case claiming the benefit of this case, or in any continuation in spite of any preliminary amendments, other amendments, claim language, or arguments presented, thus throughout the pendency of any case there is no intention to disclaim or surrender any potential subject matter. It should be understood that if or when broader claims are presented, such may require that any relevant prior art that may have been considered at any prior time may need to be re-visited since it is possible that to the extent any amendments, claim language, or arguments presented in this or any subsequent application are considered as made to avoid such prior art, such reasons may be eliminated by later presented claims or the like. Both the examiner and any person otherwise interested in existing or later potential coverage, or considering if there has at any time been any possibility of an indication of disclaimer or surrender of potential coverage, should be aware that no such surrender or disclaimer is ever intended or ever exists in this or any subsequent application. Limitations such as arose in *Hakim v. Cannon Avent Group, PLC*, 479 F.3d 1313 (Fed. Cir 2007), or the like are expressly not intended in this or any subsequent related matter. In addition, support should be understood to exist to the degree required under new matter laws -- including but not limited to European Patent Convention Article 123(2) and United States Patent Law 35 USC 132 or other such laws-- to permit the addition of any of the various dependencies or other elements presented under one independent claim or concept as dependencies or elements under any other independent claim or concept. In drafting any claims at any time whether in this application or in any subsequent application, it should also be understood that the applicant has intended to capture as full and broad a scope of coverage as legally available. To the extent that insubstantial substitutes are made, to the extent that the applicant did not in fact draft any claim so as to literally encompass any particular embodiment, and to the extent otherwise applicable, the applicant should

not be understood to have in any way intended to or actually relinquished such coverage as the applicant simply may not have been able to anticipate all eventualities; one skilled in the art, should not be reasonably expected to have drafted a claim that would have literally encompassed such alternative embodiments.

5 Further, if or when used, the use of the transitional phrase “comprising” is used to maintain the “open-end” claims herein, according to traditional claim interpretation. Thus, unless the context requires otherwise, it should be understood that the term “comprise” or variations such as “comprises” or “comprising”, are intended to imply the inclusion of a stated element or step or group of elements or steps but not the
10 exclusion of any other element or step or group of elements or steps. Such terms should be interpreted in their most expansive form so as to afford the applicant the broadest coverage legally permissible. The use of the phrase, “or any other claim” is used to provide support for any claim to be dependent on any other claim, such as another dependent claim, another independent claim, a previously listed claim, a subsequently
15 listed claim, and the like. As one clarifying example, if a claim were dependent “on claim 20 or any other claim” or the like, it could be re-drafted as dependent on claim 1, claim 15, or even claim 715 (if such were to exist) if desired and still fall with the disclosure. It should be understood that this phrase also provides support for any combination of elements in the claims and even incorporates any desired proper
20 antecedent basis for certain claim combinations such as with combinations of method, apparatus, process, and the like claims.

Finally, any claims set forth at any time are hereby incorporated by reference as part of this description of the invention, and the applicant expressly reserves the right to use all of or a portion of such incorporated content of such claims as additional
25 description to support any of or all of the claims or any element or component thereof, and the applicant further expressly reserves the right to move any portion of or all of the incorporated content of such claims or any element or component thereof from the description into the claims or vice-versa as necessary to define the matter for which protection is sought by this application or by any subsequent continuation, division, or
30 continuation-in-part application thereof, or to obtain any benefit of, reduction in fees pursuant to, or to comply with the patent laws, rules, or regulations of any country or

treaty, and such content incorporated by reference shall survive during the entire pendency of this application including any subsequent continuation, division, or continuation-in-part application thereof or any reissue or extension thereon.

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CLAIMS

1. A method of testing for magnetic anomalies in a magnetic core of a multiphasic motive force electrical machine comprising the steps of:
- accepting a multiphasic motive force electrical machine in situ in a working environment;
 - positioning a portable test device proximate to an electrical supply for said multiphasic motive force electrical machine;
 - detachably electrically connecting said portable test device to said electrical supply for said multiphasic motive force electrical machine;
 - establishing movement elements of said multiphasic motive force electrical machine in a substantially stationary state;
 - generating an immotive multiphasic test signal from said portable test device;
 - applying said immotive multiphasic test signal to at least a portion of said electrical supply for said multiphasic motive force electrical machine; and
 - sensing at least one response of said multiphasic motive force electrical machine to said immotive multiphasic test signal; and
 - discerning the existence of a stator magnetization core fault from said response of said multiphasic motive force electrical machine to said immotive multiphasic test signal.
2. A method of testing for magnetic anomalies in a magnetic core as described in claim 1 or any other claim wherein the step of discerning the existence of a stator magnetization core fault from said response of said multiphasic motive force electrical machine to said immotive multiphasic test signal comprises the step of discerning the existence of a galvanically disconnected component magnetic field permeability fault.
3. A method of testing for magnetic anomalies in a magnetic core as described in claim 2 or any other claim wherein said step of discerning the existence of an

galvanically disconnected component magnetic field permeability fault comprises the step of discerning the existence of an interlaminar magnetic core fault.

- 5 4. A method of testing for magnetic anomalies in a magnetic core as described in claim 3 or any other claim wherein said step of discerning the existence of a stator magnetization core fault from said response of said multiphasic motive force electrical machine to said immotive multiphasic test signal comprises the step of discerning the existence of a frequency variation effect.
- 10
5. A method of testing for magnetic anomalies in a magnetic core as described in claim 4 or any other claim wherein said step of discerning the existence of a frequency variation effect comprises the step of discerning the existence of a substantially frequency squared proportional effect.
- 15
6. A method of testing for magnetic anomalies in a magnetic core as described in claim 1 or any other claim wherein discerning the existence of a stator magnetization core fault from said response of said multiphasic motive force electrical machine to said immotive multiphasic test signal comprises the step
- 20 of discerning the existence of a magnetic field loss effect.
7. A method of testing for magnetic anomalies in a magnetic core as described in claim 6 or any other claim wherein said step of discerning the existence of a magnetic field loss effect comprises the step of discerning the existence of an
- 25 eddy current effect.
8. A method of testing for magnetic anomalies in a magnetic core as described in claim 6 or any other claim wherein said step of discerning the existence of an eddy current effect comprises the step of discerning the existence of a
- 30 frequency variation effect.

9. A method of testing for magnetic anomalies in a magnetic core as described in claim 6 or any other claim wherein said step of discerning the existence of a frequency variation effect comprises the step of discerning the existence of a substantially frequency squared proportional effect.

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10. A method of testing for magnetic anomalies in a magnetic core as described in claim 1 or any other claim wherein said step of discerning the existence of a stator magnetization core fault from said response of said multiphasic motive force electrical machine to said immotive multiphasic test signal comprises the step of discerning the existence of a locational variation effect.

10

11. A magnetic core anomaly tester for a multiphasic motive force electrical machine comprising:

- a portable test device containment;
- 15 - a plurality of interconnected magnetic core test waveform signal generators established within said portable test device containment;
- an immotive multiphasic test signal controller to which said plurality of interconnected waveform signal generators are responsive;
- a multiphasic machine operation de-energization requirement to
- 20 establish said multiphasic motive force electrical machine in a substantially stationary state;
- test containment supply circuitry responsive to said immotive multiphasic test signal controller; and
- a detachable electrical power connectivity issuing from said portable
- 25 test device containment and electrically connected to said test containment supply circuitry;
- a magnetic core response sensor element;
- a sensor return connected to said magnetic core response sensor element;

- a stator magnetization core fault analyzer responsive to said magnetic core response sensor element and configured to assess the existence of a magnetic core anomaly in a multiphasic motive force electrical machine.

- 5 12. A magnetic core anomaly tester for a multiphasic motive force electrical machine as described in claim 1 wherein said detachable electrical power connectivity issuing from said portable test device containment and electrically connected to said test containment supply circuitry comprises a multiphasic motive force electrical machine in situ connectivity.
- 10 13. A magnetic core anomaly tester for a multiphasic motive force electrical machine as described in claim 12 wherein said test containment supply circuitry responsive to said immotive multiphasic test signal controller comprises a proximate multiphasic motive force electrical machine supply circuitry.
- 15 14. A magnetic core anomaly tester for a multiphasic motive force electrical machine as described in claim 1 wherein said stator magnetization core fault analyzer responsive to said magnetic core response sensor element and configured to assess the existence of a magnetic core anomaly in a multiphasic
- 20 motive force electrical machine comprises a galvanically disconnected component magnetic field permeability fault analyzer.
- 25 15. A magnetic core anomaly tester for a multiphasic motive force electrical machine as described in claim 14 wherein said galvanically disconnected component magnetic field permeability fault analyzer comprises an interlaminar magnetic core fault analyzer.
- 30 16. A magnetic core anomaly tester for a multiphasic motive force electrical machine as described in claim 15 wherein said stator magnetization core fault analyzer responsive to said magnetic core response sensor element and

configured to assess the existence of a magnetic core anomaly in a multiphasic motive force electrical machine comprises a frequency variation effect analyzer.

- 5 17. A magnetic core anomaly tester for a multiphasic motive force electrical machine as described in claim 16 wherein said a frequency variation effect analyzer comprises a substantially frequency squared proportional effect analyzer.
- 10 18. A magnetic core anomaly tester for a multiphasic motive force electrical machine as described in claim 1 wherein said stator magnetization core fault analyzer responsive to said magnetic core response sensor element and configured to assess the existence of a magnetic core anomaly in a multiphasic motive force electrical machine comprises a magnetic field loss effect analyzer.
- 15 19. A magnetic core anomaly tester for a multiphasic motive force electrical machine as described in claim 18 wherein said magnetic field loss effect analyzer comprises an eddy current effect analyzer.
- 20 20. A magnetic core anomaly tester for a multiphasic motive force electrical machine as described in claim 19 wherein said eddy current effect analyzer comprises a frequency variation effect analyzer.
- 25 21. A magnetic core anomaly tester for a multiphasic motive force electrical machine as described in claim 19 wherein said frequency variation effect analyzer anal a substantially frequency squared proportional effect analyzer.
- 30 22. A magnetic core anomaly tester for a multiphasic motive force electrical machine as described in claim 1 wherein said stator magnetization core fault analyzer responsive to said magnetic core response sensor element and configured to assess the existence of a magnetic core anomaly in a multiphasic motive force electrical machine comprises a locational variation effect analyzer.

23. A method for multiphasic motive force electrical machine testing comprising the steps of:

- detachably electrically connecting a portable test device to an electrical supply for a multiphasic motive force electrical machine;
- generating an immotive multiphasic test signal from said portable test device;
- sensing at least one response to said immotive multiphasic test signal; and
- analyzing said response to said immotive multiphasic test signal.

24. A method for multiphasic motive force electrical machine testing as described in claim 23 or any other claim wherein said step of generating an immotive multiphasic test signal from said portable test device comprises the step of generating an immotive multiphasic test signal for a multiphasic motive force electrical machine from said portable test device, and wherein said step of analyzing said response to said immotive multiphasic test signal comprises the step of analyzing said response to said immotive multiphasic test signal to test a condition of said multiphasic motive force electrical machine.

25. A method for multiphasic motive force electrical machine testing as described in claim 23 or any other claim and further comprising the step of varying said immotive multiphasic test signal.

26. A method for multiphasic motive force electrical machine testing as described in claim 25 or any other claim and further comprising the steps of:

- re-generating a differing immotive multiphasic test signal;
- sensing at least one response to said regenerated immotive multiphasic test signal; and

- comparing said response to said generated immotive multiphasic test signal with said response to said regenerated immotive multiphasic test signal.

5 27. A method for multiphasic motive force electrical machine testing as described in claim 25 or any other claim wherein said step of varying said immotive multiphasic test signal comprises the step of varying said immotive multiphasic test signal in a manner selected from a group consisting of:

- varying a voltage of said immotive multiphasic test signal;
- 10 - varying a current of said immotive multiphasic test signal;
- varying a magnitude of said immotive multiphasic test signal;
- varying a relative magnitude of said immotive multiphasic test signal;
- varying a frequency of said immotive multiphasic test signal; and
- all permutations and combination of the above.

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28. A method for multiphasic motive force electrical machine testing as described in claim 23 or 27 or any other claim wherein said step of generating an immotive multiphasic test signal from said portable test device comprises the step of generating an immotive multiphasic test signal selected from a group consisting of:

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- generating a sinusoidal waveform immotive multiphasic test signal;
- generating a multiple frequency immotive multiphasic test signal;
- generating a frequency sweep immotive multiphasic test signal;
- generating a sawtooth waveform immotive multiphasic test signal;
- 25 - generating a fourier transform determinate waveform immotive multiphasic test signal; and
- all permutations and combination of the above.

25

29. A method for multiphasic motive force electrical machine testing as described in claim 23 or 26 or any other claim and further comprising the step of varying a frequency of said immotive multiphasic test signal.

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30. A method for multiphasic motive force electrical machine testing as described in claim 29 or any other claim wherein said step of generating an immotive multiphasic test signal from said portable test device comprises the step of
5 generating an immotive multiphasic test signal selected from a group consisting of:

- generating an about $\frac{1}{4}$ Hz immotive multiphasic test signal;
- generating an about 10Hz immotive multiphasic test signal;
- generating an about 500Hz immotive multiphasic test signal;
- 10 - generating an about 1000Hz immotive multiphasic test signal;
- generating a sub-hertz immotive multiphasic test signal;
- generating both a high frequency and a low frequency immotive multiphasic test signal;
- generating a high frequency immotive multiphasic test signal with a
15 superimposed low frequency immotive multiphasic test signal;
- generating a plurality of different frequency immotive multiphasic test signals;
- generating an immotive multiphasic test signal with a superimposed movement signal;
- 20 - generating a variable depth effect immotive multiphasic test signal;
- generating a rotor component optimized immotive multiphasic test signal;
- generating a stator component optimized immotive multiphasic test signal;
- 25 - generating a first component optimized immotive multiphasic test signal;
- generating a second component optimized immotive multiphasic test signal;
- generating a first effect indicative immotive multiphasic test signal;
- 30 - generating a second effect indicative immotive multiphasic test signal;

- generating a depth effect indicative immotive multiphasic test signal;
and
- all permutations and combination of the above.

- 5 31. A method for multiphasic motive force electrical machine testing as described in claim 23, 26, 29 or any other claim and further comprising the step of varying an amplitude of said immotive multiphasic test signal.
- 10 32. A method for multiphasic motive force electrical machine testing as described in claim 31 or any other claim wherein the step of varying an amplitude of said immotive multiphasic test signal comprises the step of varying relative amplitudes of said immotive multiphasic test signal.
- 15 33. A method for multiphasic motive force electrical machine testing as described in claim 31 or any other claim wherein the step of varying an amplitude of said immotive multiphasic test signal comprises the step of varying a magnetic field intensity factor for said immotive multiphasic test signal.
- 20 34. A method for multiphasic motive force electrical machine testing as described in claim 33 or any other claim wherein said step of varying a magnetic field intensity factor for said immotive multiphasic test signal comprises the step of creating an immotive multiphasic test signal selected from a group consisting of:
- creating about a .33 tesla factor immotive multiphasic test signal;
 - 25 - creating about a .50 tesla factor immotive multiphasic test signal;
 - creating about a .67 tesla factor immotive multiphasic test signal;
 - creating about a one tesla factor immotive multiphasic test signal;
 - creating about a 1.33 tesla factor immotive multiphasic test signal; and
 - all permutations and combination of the above.
- 30 35. A portable multiphasic motive force electrical machine test device

comprising:

- a portable test device containment;
- a plurality of interconnected waveform signal generators established within said portable test device containment;
- 5 - an immotive multiphasic test signal controller to which said plurality of interconnected waveform signal generators are responsive;
- test containment supply circuitry responsive to said immotive multiphasic test signal controller; and
- a detachable electrical power connectivity issuing from said portable
- 10 test device containment and electrically connected to said test containment supply circuitry.

36. A portable multiphasic motive force electrical machine test device as described in claim 35 and further comprising:

- 15 - a multiphasic motive force electrical machine response sensor element;
- a sensor return connected to said multiphasic motive force electrical machine response sensor element;
- a multiphasic motive force electrical machine fault analyzer responsive to said sensor element and configured to assess the existence of a fault
- 20 in a multiphasic motive force electrical machine.

37. A portable multiphasic motive force electrical machine test device as described in claim 36 wherein said a plurality of interconnected waveform signal generators established within said portable test device containment comprises a

25 plurality of multiphasic motive force electrical machine signal generators,

38. A portable multiphasic motive force electrical machine test device as described in claim 35 wherein said immotive multiphasic test signal controller to which said plurality of interconnected waveform signal generators are responsive

30 comprises an immotive multiphasic test signal variation controller.

39. A portable multiphasic motive force electrical machine test device as described in claim 38 wherein said wherein said immotive multiphasic test signal controller to which said plurality of interconnected waveform signal generators are responsive comprises an immotive multiphasic test signal reapplication controller, and further comprising a multiphasic motive force electrical machine analyzer configured to assess the existence of a fault in said multiphasic motive force electrical machine.

40. A portable multiphasic motive force electrical machine test device as described in claim 38 wherein said immotive multiphasic test signal variation controller comprises an immotive multiphasic test signal variation controller selected from a group consisting of:

- an immotive multiphasic test signal voltage variation controller;
- an immotive multiphasic test signal current variation controller;
- an immotive multiphasic test signal magnitude variation controller;
- an immotive multiphasic test signal relative amplitude variation controller;
- an immotive multiphasic test signal frequency variation controller;
- .- all permutations and combination of the above.

41. A portable multiphasic motive force electrical machine test device as described in claim 35 or 40 wherein said a plurality of interconnected waveform signal generators established within said portable test device containment comprises an interconnected waveform signal generators selected from a group consisting of:

- a sinusoidal waveform immotive multiphasic test signal generator;
- a multiple frequency immotive multiphasic test signal generator;
- a frequency sweep immotive multiphasic test signal generator;
- a sawtooth waveform immotive multiphasic test signal generator;
- a fourier transform determinate waveform immotive multiphasic test signal generator;

- all permutations and combination of the above.

42. 35 or 39 wherein said an immotive multiphasic test signal controller to which said plurality of interconnected waveform signal generators are responsive comprises an immotive multiphasic test signal frequency variation controller.

43. A portable multiphasic motive force electrical machine test device as described in claim 42 wherein said a plurality of interconnected waveform signal generators established within said portable test device containment comprises an interconnected waveform signal generators selected from a group consisting of:

- an about $\frac{1}{4}$ Hz immotive multiphasic test waveform signal generator;
- an about 10Hz immotive multiphasic test waveform signal generator;
- an about 500Hz immotive multiphasic test waveform signal generator;
- an about 1000Hz immotive multiphasic test waveform signal generator;
- a sub-hertz immotive multiphasic test waveform signal generator;
- a high and low frequency immotive multiphasic test waveform signal generator;
- a superimposed high and low frequency immotive multiphasic test waveform signal generator;
- a plurality of different frequency immotive multiphasic test waveform signals generator;
- a superimposed immotive multiphasic test waveform signal and movement signal generator;
- a variable depth immotive multiphasic test waveform signal generator;
- a rotor component immotive multiphasic test waveform signal generator;
- a stator component immotive multiphasic test waveform signal generator;
- a first component optimized immotive multiphasic test waveform signal generator;

- a second component optimized immotive multiphasic test waveform signal generator;
- a first effect indicative immotive multiphasic test waveform signal generator;
- 5 - a second effect indicative immotive multiphasic test waveform signal generator;
- a depth effect indicative immotive multiphasic test waveform signal generator;
- all permutations and combination of the above.

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44. A portable multiphasic motive force electrical machine test device as described in claim 35, 39, or 42 wherein said immotive multiphasic test signal controller to which said plurality of interconnected waveform signal generators are responsive comprises an immotive multiphasic test signal amplitude variation controller.

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45. A portable multiphasic motive force electrical machine test device as described in claim 44 wherein said immotive multiphasic test signal amplitude variation controller comprises an immotive multiphasic test signal relative amplitude variation controller.

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46. A portable multiphasic motive force electrical machine test device as described in claim 44 wherein said immotive multiphasic test signal amplitude variation controller comprises an immotive multiphasic test signal magnetic field intensity factor variation controller.

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47. A portable multiphasic motive force electrical machine test device as described in claim 46 wherein said immotive multiphasic test signal magnetic field intensity factor variation controller comprises an immotive multiphasic test signal magnetic field intensity factor variation controller selected from a group consisting of:

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- an about .33 tesla factor immotive multiphasic test signal magnetic field intensity factor variation controller;
 - an about .50 tesla factor immotive multiphasic test signal magnetic field intensity factor variation controller;
 - 5 - an about .67 tesla factor immotive multiphasic test signal magnetic field intensity factor variation controller;
 - an about one tesla factor immotive multiphasic test signal magnetic field intensity factor variation controller;
 - an about 1.33 tesla factor immotive multiphasic test signal magnetic field intensity factor variation controller;
 - 10 - all permutations and combination of the above.
48. A method of testing for a rotor conductivity anomaly in a multiphasic motive force electrical machine comprising the steps of:
- 15 - accepting a multiphasic motive force electrical machine in situ in a working environment;
 - positioning a portable test device proximate to an electrical supply for said multiphasic motive force electrical machine;
 - detachably electrically connecting said portable test device to said electrical supply for said multiphasic motive force electrical machine;
 - 20 - establishing movement elements of said multiphasic motive force electrical machine in a substantially stationary state;
 - generating an immotive multiphasic test signal from said portable test device;
 - 25 - applying said immotive multiphasic test signal to at least a portion of said electrical supply for said multiphasic motive force electrical machine; and
 - sensing at least one response of said multiphasic motive force electrical machine to said immotive multiphasic test signal; and

- discerning the existence of a rotor conductivity anomaly from said response of said multiphasic motive force electrical machine to said immotive multiphasic test signal.

5 49. A method of testing for a rotor conductivity anomaly in a multiphasic motive
force electrical machine as described in claim 48 or any other claim wherein
said step of discerning the existence of a rotor conductivity anomaly from said
response of said multiphasic motive force electrical machine to said immotive
multiphasic test signal comprises the step of discerning the existence of a
10 rotobar fault.

50. A method of testing for a rotor conductivity anomaly in a multiphasic motive
force electrical machine as described in claim 48 or any other claim wherein
said step of discerning the existence of a rotor conductivity anomaly from said
15 response of said multiphasic motive force electrical machine to said immotive
multiphasic test signal comprises the step of discerning the existence of a
frequency variation effect.

51. A method of testing for a rotor conductivity anomaly in a multiphasic motive
20 force electrical machine as described in claim 50 or any other claim wherein
said step of discerning the existence of a frequency variation effect comprises
the step of discerning the existence of an effect that decreases with increasing
frequency test signals.

25 52. A method of testing for a rotor conductivity anomaly in a multiphasic motive
force electrical machine as described in claim 49 or any other claim and further
comprising the step of assessing the existence of a rotobar fault depth indicia,

53. A method of testing for a rotor conductivity anomaly in a multiphasic motive
30 force electrical machine as described in claim 48 or any other claim wherein
said step of discerning the existence of a rotor conductivity anomaly from said

response of said multiphasic motive force electrical machine to said immotive multiphasic test signal comprises the step of discerning the existence of a rotor conductivity anomaly selected from a group consisting of:

- discerning the existence of a rotor resistance anomaly;
- 5 - discerning the existence of a rotor circuit resistance anomaly;
- discerning the existence of a motor brush imbalance anomaly;
- discerning the existence of a motor diode bridge anomaly; and
- all permutations and combination of the above.

10 54. A method of testing for a rotor conductivity anomaly in a multiphasic motive force electrical machine as described in claim 48 or any other claim wherein said step of discerning the existence of a rotor conductivity anomaly from said response of said multiphasic motive force electrical machine to said immotive multiphasic test signal comprises the step of discerning the existence of a
15 locational variation effect.

55. A rotor conductivity anomaly tester for a multiphasic motive force electrical machine comprising:

- a portable test device containment;
- 20 - a plurality of interconnected rotor conductivity test waveform signal generators established within said portable test device containment;
- an immotive multiphasic test signal controller to which said plurality of interconnected waveform signal generators are responsive;
- a multiphasic machine operation de-energization requirement to
25 establish said multiphasic motive force electrical machine in a substantially stationary state;
- test containment supply circuitry responsive to said immotive multiphasic test signal controller; and
- a detachable electrical power connectivity issuing from said portable
30 test device containment and electrically connected to said test containment supply circuitry;

- a rotor conductivity response sensor element;
- a sensor return connected to said magnetic core response sensor element;
- a rotor conductivity anomaly analyzer responsive to said magnetic core response sensor element and configured to assess the existence of a rotor conductivity anomaly in a multiphasic motive force electrical machine.

56. A rotor conductivity anomaly tester for a multiphasic motive force electrical machine as described in claim 55 wherein said detachable electrical power connectivity issuing from said portable test device containment and electrically connected to said test containment supply circuitry comprises a multiphasic motive force electrical machine in situ connectivity.

57. A rotor conductivity anomaly tester for a multiphasic motive force electrical machine as described in claim 56 wherein said test containment supply circuitry responsive to said immotive multiphasic test signal controller comprises a proximate multiphasic motive force electrical machine supply circuitry.

58. A rotor conductivity anomaly tester for a multiphasic motive force electrical machine as described in claim 55 wherein said rotor conductivity anomaly analyzer responsive to said magnetic core response sensor element and configured to assess the existence of a rotor conductivity anomaly in a multiphasic motive force electrical machine comprises a rotobar fault analyzer.

59. A rotor conductivity anomaly tester for a multiphasic motive force electrical machine as described in claim 55 wherein said rotor conductivity anomaly analyzer responsive to said magnetic core response sensor element and configured to assess the existence of a rotor conductivity anomaly in a multiphasic motive force electrical machine comprises a frequency variation effect analyzer.

60. A rotor conductivity anomaly tester for a multiphasic motive force electrical machine as described in claim 59 wherein said a frequency variation effect analyzer comprises a decrease with increasing frequency test signal effect analyzer.

61. A rotor conductivity anomaly tester for a multiphasic motive force electrical machine as described in claim 58 wherein said rotor conductivity anomaly analyzer responsive to said magnetic core response sensor element and configured to assess the existence of a rotor conductivity anomaly in a multiphasic motive force electrical machine comprises a rotobar fault depth indicia analyzer.

62. A rotor conductivity anomaly tester for a multiphasic motive force electrical machine as described in claim 55 wherein said rotor conductivity anomaly analyzer responsive to said magnetic core response sensor element and configured to assess the existence of a rotor conductivity anomaly in a multiphasic motive force electrical machine comprises a rotor conductivity anomaly analyzer selected from a group consisting of:

- a rotor resistance anomaly analyzer;
- a rotor circuit resistance anomaly analyzer;
- a motor brush imbalance anomaly analyzer;
- a motor diode bridge anomaly analyzer; and
- all permutations and combination of the above.

63. A rotor conductivity anomaly tester for a multiphasic motive force electrical machine as described in claim 55 wherein said rotor conductivity anomaly analyzer responsive to said magnetic core response sensor element and configured to assess the existence of a rotor conductivity anomaly in a multiphasic motive force electrical machine comprises a locational variation effect analyzer.

64. A method of testing a rotating multiphasic motive force electrical machine for rotational eccentricity faults comprising the steps of:

- accepting a rotational multiphasic motive force electrical machine in
5 situ in a working environment;
- positioning a portable test device proximate to an electrical supply for
 said rotational multiphasic motive force electrical machine;
- detachably electrically connecting said portable test device to said
10 electrical supply for said rotational multiphasic motive force electrical
 machine;
- establishing movement elements of said rotational multiphasic motive
 force electrical machine in a substantially stationary state;
- generating an immotive multiphasic test signal from said portable test
 device;
- 15 - applying said immotive multiphasic test signal to at least a portion of
 said electrical supply for said rotational multiphasic motive force
 electrical machine; and
- sensing at least one response of said rotational multiphasic motive force
 electrical machine to said immotive multiphasic test signal; and
- 20 - discerning the existence of a rotational eccentricity fault for said
 multiphasic motive force electrical machine from said response to said
 immotive multiphasic test signal.

65. A method of testing a rotating multiphasic motive force electrical machine for
25 rotational eccentricity faults as described in claim 64 or any other claim
 wherein said step of discerning the existence of a rotational eccentricity fault
 for said multiphasic motive force electrical machine from said response to said
 immotive multiphasic test signal comprises the step of discerning the existence
 of a frequency variation effect.

66. A method of testing a rotating multiphasic motive force electrical machine for rotational eccentricity faults as described in claim 65 or any other claim wherein said step of discerning the existence of a rotational eccentricity fault for said multiphasic motive force electrical machine from said response to said
5 immotive multiphasic test signal further comprises the step of discerning the existence of a locational variation effect.
67. A method of testing a rotating multiphasic motive force electrical machine for rotational eccentricity faults as described in claim 65, 66 or any other claim
10 wherein said step of discerning the existence of a frequency variation effect comprises the step of discerning the existence of an effect that increases with increasing frequency test signals.
68. A method of testing a rotating multiphasic motive force electrical machine for
15 rotational eccentricity faults as described in claim 64 or any other claim wherein said step of discerning the existence of a rotational eccentricity fault for said multiphasic motive force electrical machine from said response to said immotive multiphasic test signal comprises the step of assessing the existence
20 of a static eccentricity anomaly condition.
69. A method of testing a rotating multiphasic motive force electrical machine for rotational eccentricity faults as described in claim 64 or any other claim wherein said step of discerning the existence of a rotational eccentricity fault for said multiphasic motive force electrical machine from said response to said
25 immotive multiphasic test signal comprises the step of assessing the existence of a dynamic eccentricity anomaly condition.
70. A method of testing a rotating multiphasic motive force electrical machine for
30 rotational eccentricity faults as described in claim 64 or any other claim wherein said step of discerning the existence of a rotational eccentricity fault for said multiphasic motive force electrical machine from said response to said

immotive multiphasic test signal comprises the step of discerning the existence of a locational variation effect.

71. A rotational eccentricity fault tester for a multiphasic motive force electrical machine comprising:

- a portable test device containment;
- a plurality of interconnected rotational eccentricity test waveform signal generators established within said portable test device containment;
- an immotive multiphasic test signal controller to which said plurality of interconnected waveform signal generators are responsive;
- a multiphasic machine operation de-energization requirement to establish said multiphasic motive force electrical machine in a substantially stationary state;
- test containment supply circuitry responsive to said immotive multiphasic test signal controller; and
- a detachable electrical power connectivity issuing from said portable test device containment and electrically connected to said test containment supply circuitry;
- a rotational eccentricity response sensor element;
- a sensor return connected to said magnetic core response sensor element;
- a rotational eccentricity fault analyzer responsive to said magnetic core response sensor element and configured to assess the existence of a rotational eccentricity fault in a multiphasic motive force electrical machine.

72. A rotational eccentricity fault tester for a multiphasic motive force electrical machine as described in claim 71 wherein said detachable electrical power connectivity issuing from said portable test device containment and electrically connected to said test containment supply circuitry comprises a multiphasic motive force electrical machine in situ connectivity.

73. A rotational eccentricity fault tester for a multiphasic motive force electrical machine as described in claim 72 wherein said test containment supply circuitry responsive to said immotive multiphasic test signal controller comprises a proximate multiphasic motive force electrical machine supply circuitry.

74. A rotational eccentricity fault tester for a multiphasic motive force electrical machine as described in claim 71 wherein said rotational eccentricity fault analyzer responsive to said magnetic core response sensor element and configured to assess the existence of a rotational eccentricity fault in a multiphasic motive force electrical machine comprises a frequency variation effect analyzer.

75. A rotational eccentricity fault tester for a multiphasic motive force electrical machine as described in claim 74 wherein said rotational eccentricity fault analyzer responsive to said magnetic core response sensor element and configured to assess the existence of a rotational eccentricity fault in a multiphasic motive force electrical machine comprises a locational variation effect analyzer.

76. A rotational eccentricity fault tester for a multiphasic motive force electrical machine as described in claim 74 or 75 wherein said frequency variation effect analyzer comprises an increase with increasing frequency test signal effect analyzer.

77. A rotational eccentricity fault tester for a multiphasic motive force electrical machine as described in claim 71 wherein said rotational eccentricity fault analyzer responsive to said magnetic core response sensor element and configured to assess the existence of a rotational eccentricity fault in a multiphasic motive force electrical machine comprises a static eccentricity anomaly condition analyzer.

78. A rotational eccentricity fault tester for a multiphasic motive force electrical machine as described in claim 71 wherein said rotational eccentricity fault analyzer responsive to said magnetic core response sensor element and configured to assess the existence of a rotational eccentricity fault in a multiphasic motive force electrical machine comprises a dynamic eccentricity anomaly condition analyzer.
79. A rotational eccentricity fault tester for a multiphasic motive force electrical machine as described in claim 71 wherein said rotational eccentricity fault analyzer responsive to said magnetic core response sensor element and configured to assess the existence of a rotational eccentricity fault in a multiphasic motive force electrical machine comprises a locational variation effect analyzer.
80. A method for multiphasic motive force electrical machine testing as described in claim 1, 48, or 64 or any other claim and further comprising the step of varying said immotive multiphasic test signal.
81. A method for multiphasic motive force electrical machine testing as described in claim 80 or any other claim and further comprising the step of varying a frequency of said immotive multiphasic test signal.
82. A method for multiphasic motive force electrical machine testing as described in claim 1, 48, or 64 or any other claim wherein said step of generating an immotive multiphasic test signal comprises the step of generating an immotive multiphasic test signal selected from a group consisting of:
- generating an about $\frac{1}{4}$ Hz immotive multiphasic test signal;
 - generating an about 10Hz immotive multiphasic test signal;
 - generating an about 500Hz immotive multiphasic test signal;
 - generating an about 1000Hz immotive multiphasic test signal;

- generating a sub-hertz immotive multiphasic test signal;
 - generating both a high frequency and a low frequency immotive multiphasic test signal;
 - generating a high frequency immotive multiphasic test signal with a superimposed low frequency immotive multiphasic test signal;
 - generating a plurality of different frequency immotive multiphasic test signals;
 - generating an immotive multiphasic test signal with a superimposed movement signal;
 - generating a variable depth effect immotive multiphasic test signal;
 - generating a rotor component optimized immotive multiphasic test signal;
 - generating a stator component optimized immotive multiphasic test signal;
 - generating a first component optimized immotive multiphasic test signal;
 - generating a second component optimized immotive multiphasic test signal;
 - generating a first effect indicative immotive multiphasic test signal;
 - generating a second effect indicative immotive multiphasic test signal;
 - generating a depth effect indicative immotive multiphasic test signal;
 - and
 - all permutations and combination of the above.
83. A method for multiphasic motive force electrical machine testing as described in claim 80 or 81 or any other claim and further comprising the step of varying an amplitude of said immotive multiphasic test signal.
84. A method for multiphasic motive force electrical machine testing as described in claim 83 or any other claim wherein the step of varying an amplitude of said

immotive multiphasic test signal comprises the step of varying relative amplitudes of said immotive multiphasic test signal.

85. A method for multiphasic motive force electrical machine testing as described in claim 23, 48, 64 or any other claim and further comprising the step of discerning the existence of a stator magnetization core fault from said response of said multiphasic motive force electrical machine to said immotive multiphasic test signal.

86. A method for multiphasic motive force electrical machine testing as described in claim 85 or any other claim wherein said step of discerning the existence of a stator magnetization core fault from said response of said multiphasic motive force electrical machine to said immotive multiphasic test signal comprises the step of discerning the existence of a frequency variation effect.

87. A method for multiphasic motive force electrical machine testing as described in claim 86 or any other claim wherein said step of discerning the existence of a frequency variation effect comprises the step of discerning the existence of a substantially frequency squared proportional effect.

88. A method for multiphasic motive force electrical machine testing as described in claim 85 or any other claim wherein said step of discerning the existence of a stator magnetization core fault from said response of said multiphasic motive force electrical machine to said immotive multiphasic test signal comprises the step of discerning the existence of a locational variation effect.

89. A method for multiphasic motive force electrical machine testing as described in claim 1, 23, or 64 or any other claim and further comprising the step of discerning the existence of a rotor conductivity anomaly from said response of said multiphasic motive force electrical machine to said immotive multiphasic test signal.

90. A method for multiphasic motive force electrical machine testing as described in claim 89 or any other claim wherein said step of discerning the existence of a rotor conductivity anomaly from said response of said multiphasic motive force electrical machine to said immotive multiphasic test signal comprises the step of discerning the existence of a frequency variation effect.

91. A method for multiphasic motive force electrical machine testing as described in claim 90 or any other claim wherein said step of discerning the existence of a frequency variation effect comprises the step of discerning the existence of an effect that decreases with increasing frequency test signals.

92. A method for multiphasic motive force electrical machine testing as described in claim 89 or any other claim wherein said step of discerning the existence of a rotor conductivity anomaly from said response of said multiphasic motive force electrical machine to said immotive multiphasic test signal comprises the step of discerning the existence of a locational variation effect.

93. A method for multiphasic motive force electrical machine testing as described in claim 1, 23, or 48 or any other claim and further comprising the step of discerning the existence of a rotational eccentricity fault for said multiphasic motive force electrical machine from said response to said immotive multiphasic test signal.

94. A method for multiphasic motive force electrical machine testing as described in claim 93 or any other claim wherein said step of discerning the existence of a rotational eccentricity fault for said multiphasic motive force electrical machine from said response to said immotive multiphasic test signal comprises the step of discerning the existence of a frequency variation effect.

95. A method for multiphasic motive force electrical machine testing as described in claim 94 or any other claim wherein said step of discerning the existence of a rotational eccentricity fault for said multiphasic motive force electrical machine from said response to said immotive multiphasic test signal further comprises the step of discerning the existence of a locational variation effect.

96. A method for multiphasic motive force electrical machine testing as described in claim 94, 95 or any other claim wherein said step of discerning the existence of a frequency variation effect comprises the step of discerning the existence of an effect that increases with increasing frequency test signals.

97. A method for multiphasic motive force electrical machine testing as described in claim 1, 23, 48, 64 or any other claim wherein said step of generating an immotive multiphasic test signal from said portable test device comprises the step of generating a fixed angular condition immotive multiphasic test signal.

98. A method for multiphasic motive force electrical machine testing as described in claim 97 or any other claim and further comprising the step of discerning the existence of a locational variation effect.

99. A method for multiphasic motive force electrical machine testing as described in claim 98 or any other claim wherein said step of discerning the existence of a locational variation effect comprises the step of varying a machine angle for said immotive multiphasic test signal.

100. A method for multiphasic motive force electrical machine testing as described in claim 99 or any other claim wherein said step of varying a machine angle for said immotive multiphasic test signal comprises the step of changing a machine test position through action of an immotive multiphasic test signal.

101. A method for multiphasic motive force electrical machine testing as described in claim 99 or any other claim wherein said step of varying a machine angle for said immotive multiphasic test signal comprises the step of changing a machine test position through action of an immotive multiphasic test signal between applications of immotive multiphasic test signals.
102. A method for multiphasic motive force electrical machine testing as described in claim 99 or any other claim wherein said step of varying a machine angle for said immotive multiphasic test signal comprises the step of changing a machine test position through action of an immotive multiphasic test signal during applications of immotive multiphasic test signals.
103. A method for multiphasic motive force electrical machine testing as described in claim 100 or any other claim wherein changing a machine test position through action of said immotive multiphasic test signal comprises the step of moving a component of said multiphasic motive force electrical machine.
104. A method for multiphasic motive force electrical machine testing as described in claim 103 or any other claim wherein said step of moving a component of said multiphasic motive force electrical machine comprises the step of multiply incrementing a movement of a component of said multiphasic motive force electrical machine.
105. A method for multiphasic motive force electrical machine testing as described in claim 100 or any other claim wherein said step of changing a machine test position through action of said immotive multiphasic test signal comprises the step of changing a magnetization location for said multiphasic motive force electrical machine.
106. A method for multiphasic motive force electrical machine testing as described in claim 105 or any other claim wherein said step of changing a magnetization

location for said multiphasic motive force electrical machine comprises the step of multiply incrementing a change of magnetization location for said multiphasic motive force electrical machine.

- 5 107. A method for multiphasic motive force electrical machine testing as described in claim 98 or any other claim wherein said step of discerning the existence of a locational variation effect comprises the step of changing relative amplitudes of said immotive multiphasic test signal.
- 10 108. A method for multiphasic motive force electrical machine testing as described in claim 99 or any other claim wherein said step of varying a machine angle for said immotive multiphasic test signal comprises the step of varying a machine angle for said immotive multiphasic test signal selected from a group consisting of:
- 15 - about five degree varying a machine angle for said immotive multiphasic test signal;
- about a rotor segment varying a machine angle for said immotive multiphasic test signal;
- about a stator segment varying a machine angle for said immotive multiphasic test signal;
- 20 - about one hundred eighty degree varying a machine angle for said immotive multiphasic test signal; and
- all permutations and combination of the above.
- 25 109. A method for multiphasic motive force electrical machine testing as described in claim 1, 23, 48, or 64 or any other claim wherein said step of generating an immotive multiphasic test signal from said portable test device comprises the step of multiple phase inverting from an electrical signal source.
- 30 110. A method for multiphasic motive force electrical machine testing as described in claim 1, 23, 48, or 64 or any other claim and further comprising the step of

applying said immotive multiphasic test signal to a stator of said multiphasic motive force electrical machine in situ in a working environment.

111. A method for multiphasic motive force electrical machine testing as described
5 in claim 1, 23, 48, or 64 or any other claim and further comprising applying said immotive multiphasic test signal to a rotor of said multiphasic motive force electrical machine in situ in a working environment.

112. A method for multiphasic motive force electrical machine testing as described
10 in claim 1, 23, 48, or 64 or any other claim wherein sensing at least one response of said rotational multiphasic motive force electrical machine to said immotive multiphasic test signal comprises the step of multiply sensing a plurality of responses, and further comprising the step of comparing results of said step of multiply sensing a plurality of responses to ascertain a condition of
15 said multiphasic motive force electrical machine.

113. A method for multiphasic motive force electrical machine testing as described
in claim 112 or any other claim wherein comparing results of said step of multiply sensing a plurality of responses to ascertain a condition of said
20 multiphasic motive force electrical machine comprises the step of analyzing variation in said responses selected from a group consisting of:

- analyzing a power effect variation;
- analyzing a voltage effect variation;
- analyzing a current effect variation; and
- 25 - all permutations and combination of the above.

114. A method for multiphasic motive force electrical machine testing as described
in claim 113 or any other claim wherein said step of sensing at least one response to said immotive multiphasic test signal comprises the step of
30 generating a voltage source immotive multiphasic test signal and wherein said step of sensing at least one response to said immotive multiphasic test signal

comprises the step of sensing a current response to said immotive multiphasic test signal.

- 5 115. A method for multiphasic motive force electrical machine testing as described in claim 113 or any other claim wherein said step of sensing at least one response to said immotive multiphasic test signal comprises the step of generating a current source immotive multiphasic test signal and wherein said step of sensing at least one response to said immotive multiphasic test signal comprises the step of sensing a voltage response to said immotive multiphasic test signal.
- 10 116. A method for multiphasic motive force electrical machine testing as described in claim 112 or any other claim wherein said step of comparing results of said step of multiply sensing a plurality of responses to ascertain a condition of said multiphasic motive force electrical machine comprises the step of separating out non-critical effects in analyzing said response.
- 15 117. A method for multiphasic motive force electrical machine testing as described in claim 112 or any other claim wherein said step of comparing results of said step of multiply sensing a plurality of responses to ascertain a condition of said multiphasic motive force electrical machine comprises the step of separating out expected resistance loss effects in analyzing said response.
- 20 118. A method for multiphasic motive force electrical machine testing as described in claim 112 or any other claim wherein said step of comparing results of said step of multiply sensing a plurality of responses to ascertain a condition of said multiphasic motive force electrical machine comprises the step of discerning the existence of a frequency variation effect.
- 25 119. A method for multiphasic motive force electrical machine testing as described in claim 118 or any other claim wherein said step of discerning the existence of
- 30

a frequency variation effect comprises the step of discerning the existence of a substantially frequency squared proportional effect.

120. A method for multiphasic motive force electrical machine testing as described
5 in claim 118 or any other claim wherein said step of discerning the existence of a frequency variation effect comprises the step of discerning the existence of a substantially frequency proportional effect.

121. A method for multiphasic motive force electrical machine testing as described
10 in claim 118 or any other claim wherein said step of discerning the existence of a frequency variation effect comprises the step of discerning the existence of a substantially frequency inverse effect.

122. A method for multiphasic motive force electrical machine testing as described
15 in claim 112 or any other claim wherein said step of comparing results of said step of multiply sensing a plurality of responses to ascertain a condition of said multiphasic motive force electrical machine comprises the step of comparing results of said step of multiply sensing a plurality of responses to ascertain a condition of said multiphasic motive force electrical machine is selected from a
20 group consisting of:

- comparing an interconnected phase signal response effect;
- comparing a frequency response effect;
- comparing an angular response effect;
- comparing a rotor angle response effect;
- 25 - comparing a stator magnetization plane response effect; and
- all permutations and combination of the above.

123. A method for multiphasic motive force electrical machine testing as
described in claim 1, 23, 48, 64 or any other claim wherein said step of sensing
30 at least one response to said immotive multiphasic test signal comprises the step

of sensing at least one response to said immotive multiphasic test signal selected from a group consisting of:

- sensing a power effect;
- sensing a voltage effect;
- 5 - sensing a current effect; and
- all permutations and combination of the above.

124. A method for multiphasic motive force electrical machine testing as described in claim 123 or any other claim and further comprising the step of comparing a
10 response effect to an input effect for said immotive multiphasic test signal

125. A multiphasic motive force electrical machine test device as described in claim 1, 41, or 71 or any other claim and further comprising a immotive multiphasic test signal variation controller.

126. A multiphasic motive force electrical machine test device as described in claim 125 or any other claim wherein said analyzer responsive to said magnetic core response sensor element and configured to assess the existence of a rotational eccentricity fault in a multiphasic motive force electrical machine comprises an
20 imotive multiphasic test signal frequency variation controller.

127. A multiphasic motive force electrical machine test device as described in claim 11, 55, or 71 wherein said a waveform signal generators comprise waveform signal generators selected from a group consisting of:

- 25 - an about $\frac{1}{4}$ Hz immotive multiphasic test waveform signal generator;
- an about 10Hz immotive multiphasic test waveform signal generator;
- an about 500Hz immotive multiphasic test waveform signal generator;
- an about 1000Hz immotive multiphasic test waveform signal generator;
- a sub-hertz immotive multiphasic test waveform signal generator;
- 30 - a high and low frequency immotive multiphasic test waveform signal generator;

- a superimposed high and low frequency immotive multiphasic test waveform signal generator;
 - a plurality of different frequency immotive multiphasic test waveform signals generator;
 - 5 - a superimposed immotive multiphasic test waveform signal and movement signal generator;
 - a variable depth immotive multiphasic test waveform signal generator;
 - a rotor component immotive multiphasic test waveform signal generator;
 - a stator component immotive multiphasic test waveform signal generator;
 - 10 - a first component optimized immotive multiphasic test waveform signal generator;
 - a second component optimized immotive multiphasic test waveform signal generator;
 - a first effect indicative immotive multiphasic test waveform signal generator;
 - 15 - a second effect indicative immotive multiphasic test waveform signal generator;
 - a depth effect indicative immotive multiphasic test waveform signal generator;
 - all permutations and combination of the above.
- 20
128. A multiphasic motive force electrical machine test device as described in claim 125 or 126 or any other claim wherein said analyzer responsive to said magnetic core response sensor element and configured to assess the existence of a rotational eccentricity fault in a multiphasic motive force electrical machine comprises a immotive multiphasic test signal amplitude variation controller.
- 25
129. A multiphasic motive force electrical machine test device as described in claim 128 or any other claim wherein said immotive multiphasic test signal amplitude variation controller comprises vary an immotive multiphasic test signal relative amplitude variation controller.
- 30

130. A multiphasic motive force electrical machine test device as described in claim 35, 55, or 71 or any other claim wherein said analyzer responsive to said magnetic core response sensor element and configured to assess the existence of a rotational eccentricity fault in a multiphasic motive force electrical machine comprises stator magnetization core fault analyzer responsive to said magnetic core response sensor element and configured to assess the existence of a magnetic core anomaly in a multiphasic motive force electrical machine.

131. A multiphasic motive force electrical machine test device as described in claim 130 or any other claim wherein said stator magnetization core fault analyzer responsive to said magnetic core response sensor element and configured to assess the existence of a rotational eccentricity fault in a multiphasic motive force electrical machine comprises a frequency variation effect analyzer.

132. A multiphasic motive force electrical machine test device as described in claim 131 or any other claim wherein said frequency variation effect analyzer comprises a substantially frequency squared proportional effect analyzer.

133. A multiphasic motive force electrical machine test device as described in claim 130 or any other claim wherein said stator magnetization core fault analyzer responsive to said magnetic core response sensor element and configured to assess the existence of a rotational eccentricity fault in a multiphasic motive force electrical machine comprises a locational variation effect analyzer.

134. A multiphasic motive force electrical machine test device as described in claim 11, 36, or 71 or any other claim wherein said analyzer responsive to said magnetic core response sensor element and configured to assess the existence of a rotational eccentricity fault in a multiphasic motive force electrical machine comprises a rotor conductivity anomaly analyzer responsive to said magnetic core response sensor element and configured to assess the existence

of a rotor conductivity anomaly in a multiphasic motive force electrical machine.

- 5 135. A multiphasic motive force electrical machine test device as described in claim 134 or any other claim wherein said rotor conductivity anomaly analyzer responsive to said magnetic core response sensor element and configured to assess the existence of a rotational eccentricity fault in a multiphasic motive force electrical machine comprises a frequency variation effect analyzer.
- 10 136. A multiphasic motive force electrical machine test device as described in claim 135 or any other claim wherein said frequency variation effect analyzer comprises a decrease with increasing frequency test signal effect analyzer.
- 15 137. A multiphasic motive force electrical machine test device as described in claim 134 or any other claim wherein said rotor conductivity anomaly analyzer responsive to said magnetic core response sensor element and configured to assess the existence of a rotational eccentricity fault in a multiphasic motive force electrical machine comprises a locational variation effect analyzer.
- 20 138. A multiphasic motive force electrical machine test device as described in claim 11, 36, or 55 or any other claim wherein said analyzer responsive to said magnetic core response sensor element and configured to assess the existence of a rotational eccentricity fault in a multiphasic motive force electrical machine comprises a rotational eccentricity fault analyzer responsive to said magnetic core response sensor element and configured to assess the existence of a rotational eccentricity fault in a multiphasic motive force electrical machine.
- 25 139. A multiphasic motive force electrical machine test device as described in claim 138 or any other claim wherein said rotational eccentricity fault analyzer responsive to said magnetic core response sensor element and configured to
- 30

assess the existence of a rotational eccentricity fault in a multiphasic motive force electrical machine comprises a frequency variation effect analyzer.

- 5 140. A multiphasic motive force electrical machine test device as described in claim 139 or any other claim wherein said rotational eccentricity fault analyzer responsive to said magnetic core response sensor element and configured to assess the existence of a rotational eccentricity fault in a multiphasic motive force electrical machine comprises a locational variation effect analyzer.
- 10 141. A multiphasic motive force electrical machine test device as described in claim 139 or 140 or any other claim wherein said frequency variation effect analyzer comprises an increase with increasing frequency test signal effect analyzer.
- 15 142. A multiphasic motive force electrical machine test device as described in claim 11, 35, 55, or 71 or any other claim wherein said plurality of interconnected test waveform signal generators established within said portable test device containment comprises a fixed angular condition immotive multiphasic test signal waveform signal generator.
- 20 143. A multiphasic motive force electrical machine test device as described in claim 142 or any other claim and further comprising a locational variation effect analyzer.
- 25 144. A multiphasic motive force electrical machine test device as described in claim 143 or any other claim wherein said locational variation effect analyzer comprises an immotive multiphasic machine angle test signal controller.
- 30 145. A multiphasic motive force electrical machine test device as described in claim 144 or any other claim wherein said immotive multiphasic machine angle test signal controller comprises an immotive multiphasic machine angle test signal change controller, and further comprising an immotive multiphasic test signal

reapplication controller, and wherein said analyzer comprises a multiphasic motive force electrical machine comparative test analyzer.

146. A multiphasic motive force electrical machine test device as described in claim 145 or any other claim wherein said immotive multiphasic machine angle test signal change controller comprises an interstitial angle change multiphasic machine angle test signal change controller.

147. A multiphasic motive force electrical machine test device as described in claim 145 or any other claim wherein said immotive multiphasic machine angle test signal change controller comprises a simultaneous angle change multiphasic machine angle test signal change controller.

148. A multiphasic motive force electrical machine test device as described in claim 145 or any other claim wherein said immotive multiphasic machine angle test signal controller comprises an immotive multiphasic machine angle test signal change controller, and further comprising an immotive multiphasic test signal reapplication controller, and wherein said analyzer comprises a multiphasic motive force electrical machine rotor movement controller

149. A multiphasic motive force electrical machine test device as described in claim 148 or any other claim wherein said multiphasic motive force electrical machine rotor movement controller comprises a sequential multiphasic motive force electrical machine component movement incrementor.

150. A multiphasic motive force electrical machine test device as described in claim 145 or any other claim wherein said immotive multiphasic machine angle test signal controller comprises an immotive multiphasic machine angle test signal change controller, and further comprising an immotive multiphasic test signal reapplication controller, and wherein said analyzer comprises an immotive multiphasic machine magnetization location change controller.

151. A multiphasic motive force electrical machine test device as described in claim 150 or any other claim wherein said immotive multiphasic machine magnetization location change controller comprises a sequential multiphasic motive force electrical machine magnetization location incrementor.

152. A multiphasic motive force electrical machine test device as described in claim 143 or any other claim wherein said immotive multiphasic test signal controller comprises an immotive multiphasic test signal relative amplitude variation controller.

153. A multiphasic motive force electrical machine test device as described in claim 144 or any other claim wherein said immotive multiphasic machine angle test signal controller comprises an immotive multiphasic machine angle test signal controller selected from a group consisting of:

- an about five degree incremental immotive multiphasic machine angle test signal controller;
- an about rotor segment incremental immotive multiphasic machine angle test signal controller;
- an about stator segment incremental immotive multiphasic machine angle test signal controller;
- an about one hundred eighty degree total incremental immotive multiphasic machine angle test signal controller;
- all permutations and combination of the above.

154. A multiphasic motive force electrical machine test device as described in claim 11, 36, 55, or 71 or any other claim wherein said plurality of interconnected waveform signal generators established within said portable test device containment comprises a multiple phase test signal inverter.

155. A multiphasic motive force electrical machine test device as described in claim 11, 36, 55, or 71 or any other claim wherein said test device is configured to apply said immotive multiphasic test signal to a stator of said multiphasic motive force electrical machine in situ in a working environment.

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156. A multiphasic motive force electrical machine test device as described in claim 11, 36, 55, or 71 or any other claim wherein said test device is configured to apply said immotive multiphasic test signal to a rotor of said multiphasic motive force electrical machine in situ in a working environment.

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157. A multiphasic motive force electrical machine test device as described in claim 11, 36, 55, or 71 or any other claim wherein said plurality of interconnected waveform signal generators established within said portable test device containment comprises a multiple parameter multiphasic motive force electrical machine response sensor element, and wherein said analyzer comprises a comparative test signal response analyzer.

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158. A multiphasic motive force electrical machine test device as described in claim 157 or any other claim wherein said comparative test signal response analyzer comprises a comparative test signal response analyzer is selected from a group consisting of:

20

- a power variation comparative test signal response analyzer;
- a voltage variation comparative test signal response analyzer;
- a current variation comparative test signal response analyzer; and
- all permutations and combination of the above.

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159. A multiphasic motive force electrical machine test device as described in claim 158 or any other claim wherein said plurality of interconnected waveform signal generators established within said portable test device containment comprises a voltage source immotive multiphasic test signal generator, and

30

wherein said sensor element comprises a current response immotive multiphasic test signal sensor element.

- 5 160. A multiphasic motive force electrical machine test device as described in claim 158 or any other claim wherein said plurality of interconnected waveform signal generators established within said portable test device containment comprises a voltage source immotive multiphasic test signal generator, and wherein said sensor element comprises a current source immotive multiphasic test signal generator, and wherein said sensor element comprises a voltage response immotive multiphasic test signal sensor element.
- 10 161. A multiphasic motive force electrical machine test device as described in claim 157 or any other claim wherein said comparative test signal response analyzer comprises a non-critical effect eliminator.
- 15 162. A multiphasic motive force electrical machine test device as described in claim 157 or any other claim wherein said comparative test signal response analyzer comprises a resistance loss effect eliminator.
- 20 163. A multiphasic motive force electrical machine test device as described in claim 157 or any other claim wherein said comparative test signal response analyzer comprises a frequency variation effect analyzer.
- 25 164. A multiphasic motive force electrical machine test device as described in claim 163 or any other claim wherein said frequency variation effect analyzer comprises a substantially frequency squared proportional effect analyzer.
- 30 165. A multiphasic motive force electrical machine test device as described in claim 163 or any other claim wherein said frequency variation effect analyzer comprises a substantially frequency proportional effect analyzer.

166. A multiphasic motive force electrical machine test device as described in claim 163 or any other claim wherein said frequency variation effect analyzer comprises a substantially frequency inverse effect analyzer.

5 167. A multiphasic motive force electrical machine test device as described in claim 157 or any other claim wherein said comparative test signal response analyzer comprises comparative test signal response analyzer selected from a group consisting of:

- 10 - an interconnected phase signal comparative test signal response analyzer;
- a frequency effect comparative test signal response analyzer;
- an angular effect comparative test signal response analyzer;
- a rotor angle effect comparative test signal response analyzer;
- 15 - a stator magnetization plane effect comparative test signal response analyzer; and
- all permutations and combination of the above.

168. A multiphasic motive force electrical machine test device as described in claim 11, 36, 55, or 71 or any other claim wherein said plurality of interconnected waveform signal generators established within said portable test device containment comprises a multiphasic motive force electrical machine response sensor element selected from a group consisting of:

- 20 - a power effect a multiphasic motive force electrical machine response sensor element;
- 25 - a voltage effect a multiphasic motive force electrical machine response sensor element;
- a current effect a multiphasic motive force electrical machine response sensor element; and
- all permutations and combination of the above.

169. A multiphasic motive force electrical machine test device as described in claim 168 or any other claim wherein said analyzer comprises an input-output comparative test signal response analyzer.

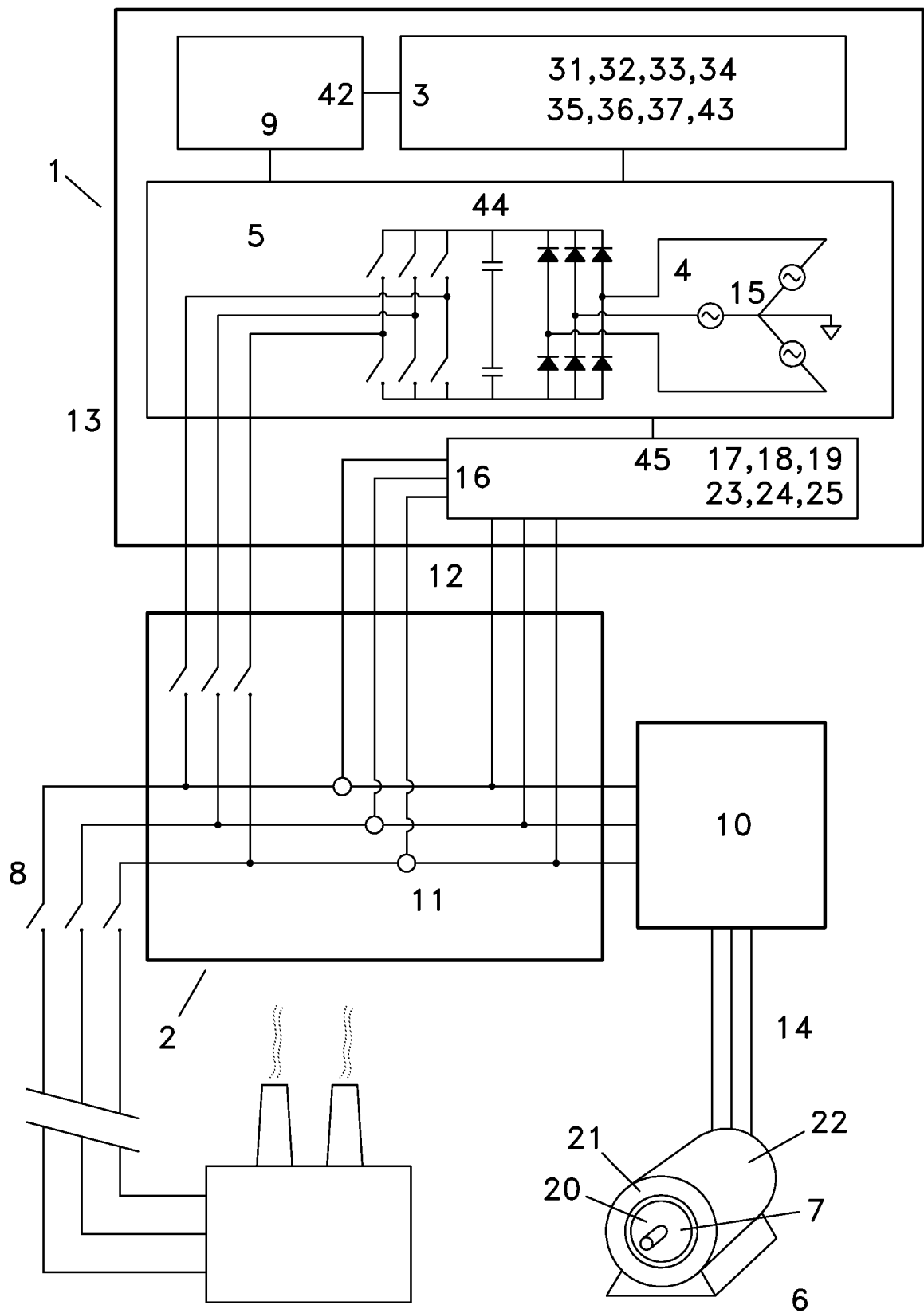


Fig. 1

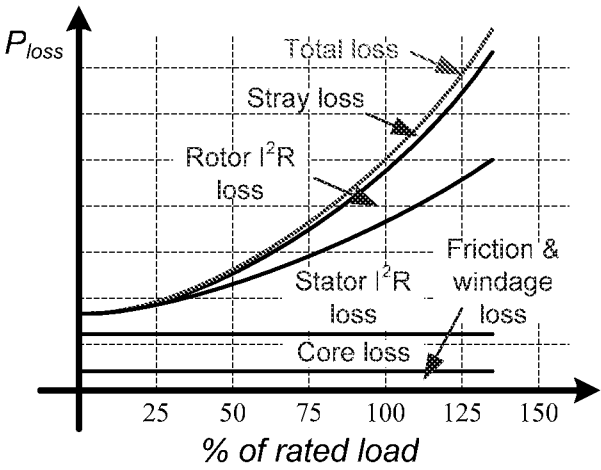


Fig. 2

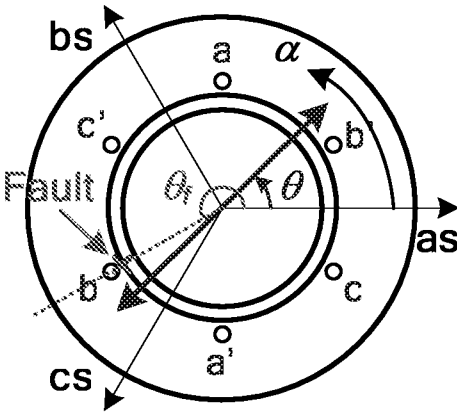


Fig. 3

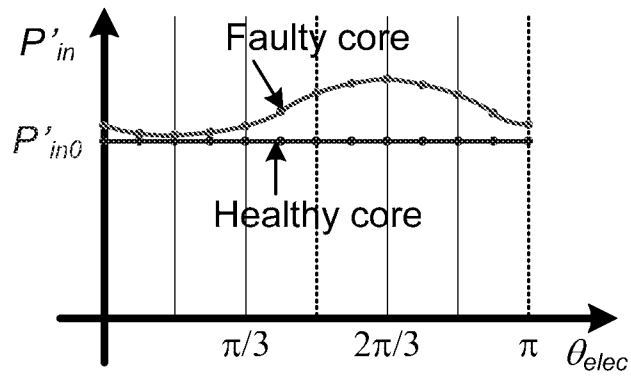


Fig. 4

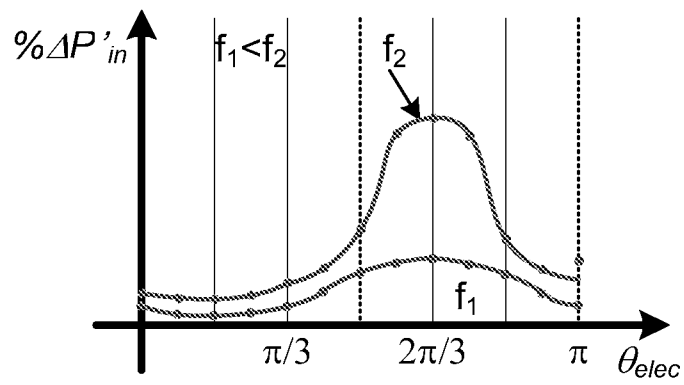


Fig. 5

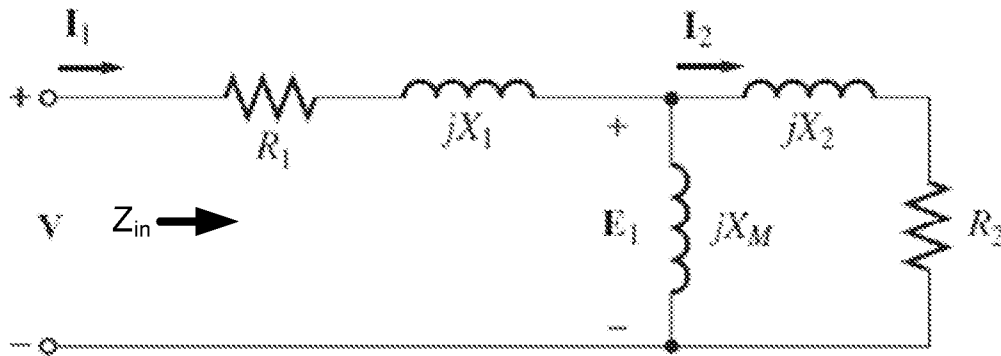


Fig. 6

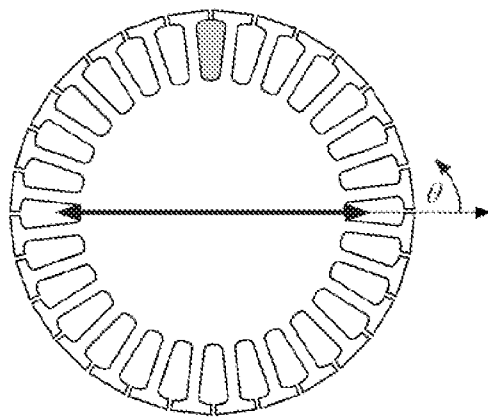


Fig. 7

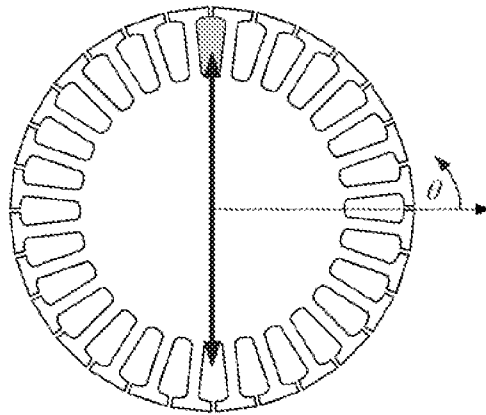


Fig. 8

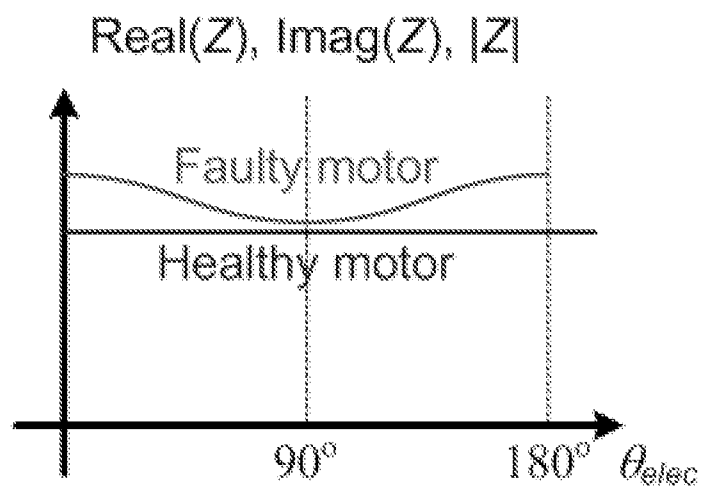


Fig. 9

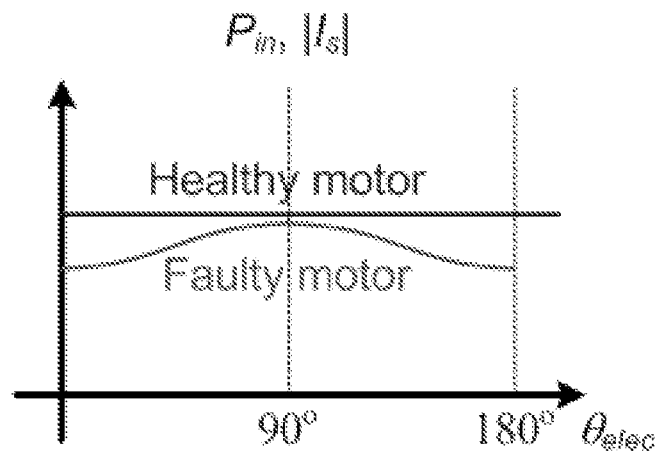


Fig. 10

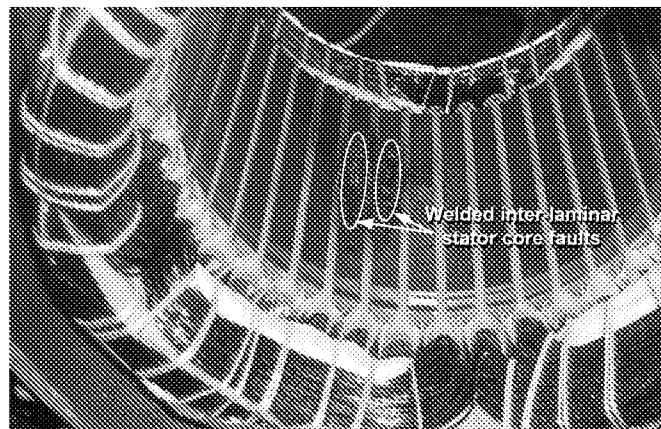


Fig. 11

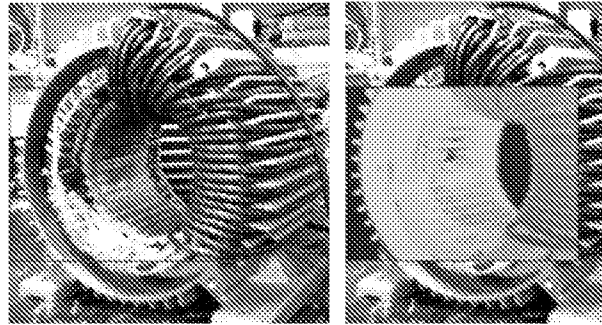


Fig. 12

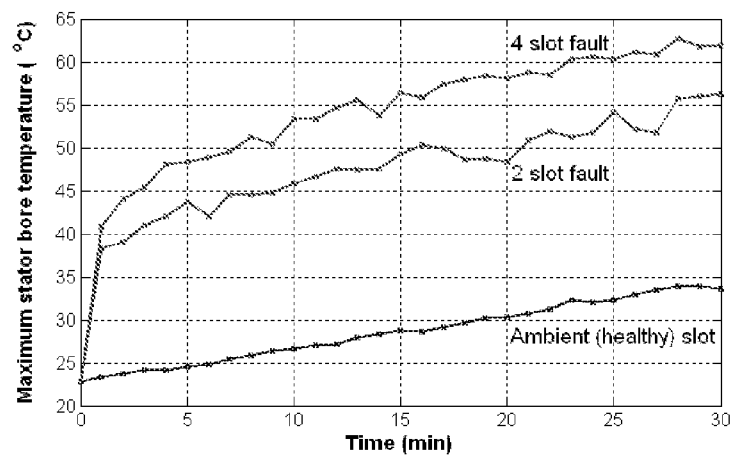


Fig. 13

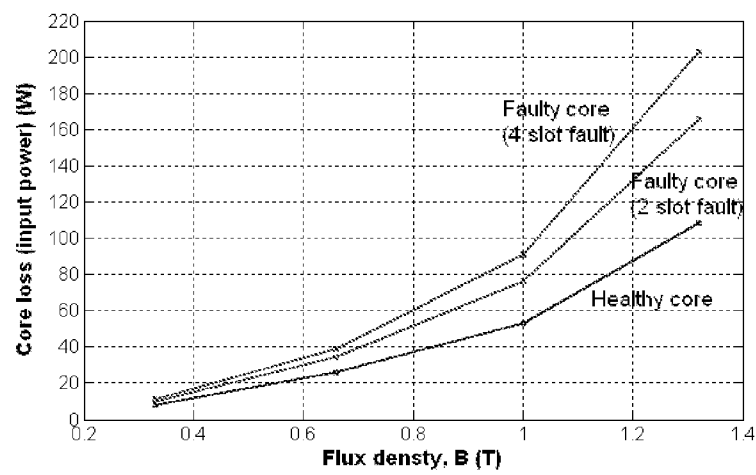


Fig. 14

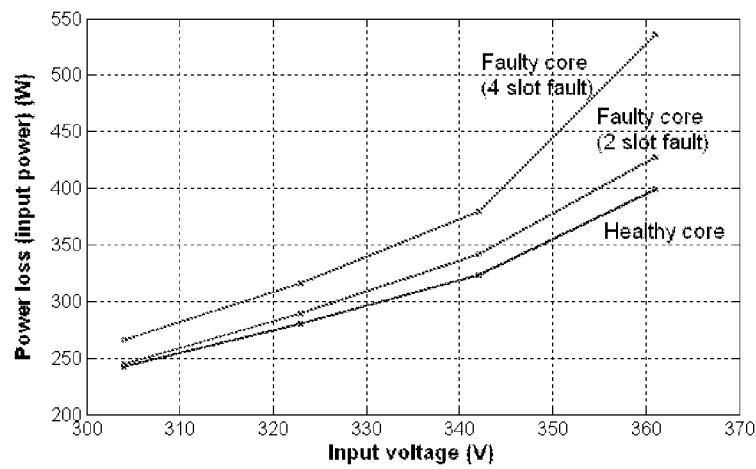


Fig. 15

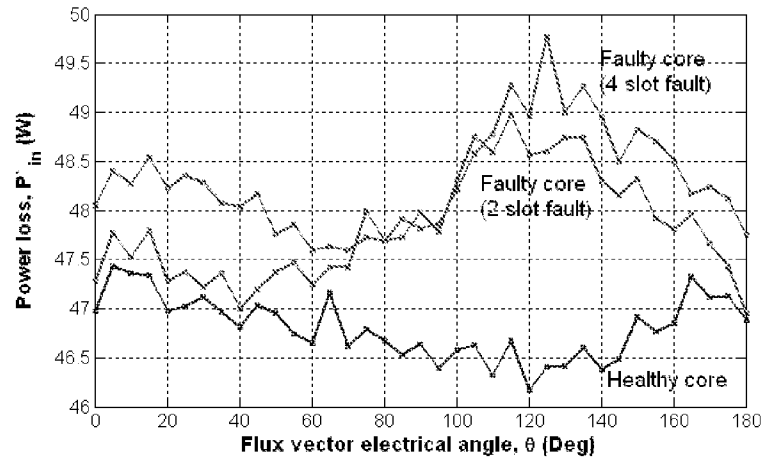


Fig. 16

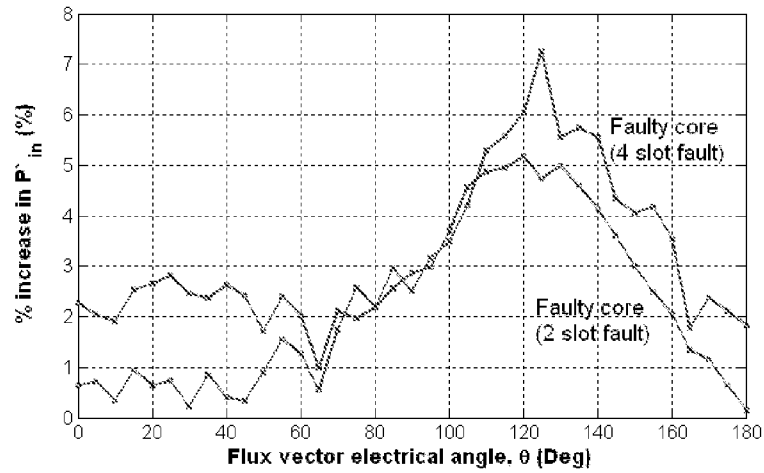


Fig. 17

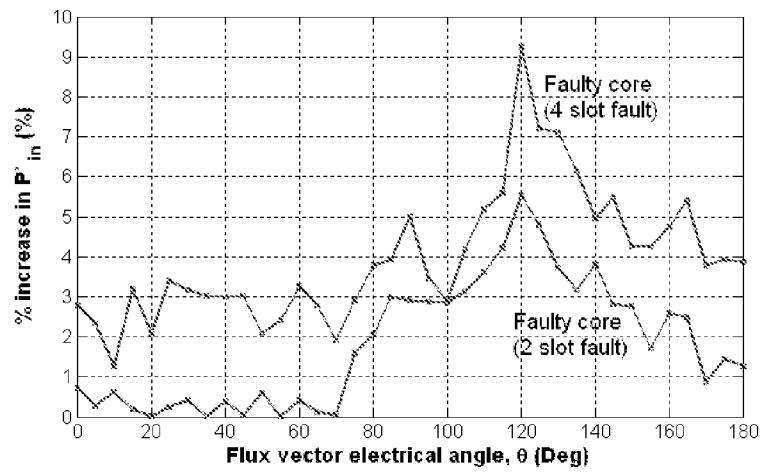


Fig. 18

INTERNATIONAL SEARCH REPORT

International application No.

PCT/US 08/78875

A. CLASSIFICATION OF SUBJECT MATTER

IPC(8) - G01R 31/02 (2008.04)

USPC - 324/511

According to International Patent Classification (IPC) or to both national classification and IPC

B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)

IPC(8) - G01R 31/02 (2008.04) (text search)

USPC - 324/511

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

IPC(8) - G01R 31/02 (2008.04) (text search)

USPC - 324/500, 510, 511, 512, 513, 771, 772 (text search)

Electronic data base consulted during the international search (name of data base and, where practicable, search terms used)

PubWEST(USPT,PGPB,EPAB,JPAB); Internet search via Google Web and Google Scholar search engines. Search Terms Used: polyphase multiphasic motor machine generator testing rotor stator machine test\$ engine performance analyzer

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
X ----- Y	US 6,529,135 B1 (Bowers et al.) 04 March 2003 (04.03.2003), entire document, especially col 3-8, Fig. 1-7.	1, 11-23, 35-39, 48, 55-64, and 71-79 ----- 40-43 and 127
Y	US 6,822,415 B1 (Komiya et al.) 23 November 2004 (23.11.2004), entire document especially col 3-16, Fig. 2, 29.	40-43 and 127
A	US 5,629,870 A (Farag et al.) 13 May 1997 (13.05.1997), entire document.	1, 11-23, 35-43, 48, 55-64, 71-79, 127
A	US 6,144,924 A (Dowling et al.) 07 November 2000 (07.11.2000), entire document.	1, 11-23, 35-43, 48, 55-64, 71-79, 127

☐ Further documents are listed in the continuation of Box C.

* Special categories of cited documents:

"A" document defining the general state of the art which is not considered to be of particular relevance

"E" earlier application or patent but published on or after the international filing date

"L" document which may throw doubts on priority claim(s) or which is cited to establish the publication date of another citation or other special reason (as specified)

"O" document referring to an oral disclosure, use, exhibition or other means

"P" document published prior to the international filing date but later than the priority date claimed

"T" later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention

"X" document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step when the document is taken alone

"Y" document of particular relevance; the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art

"&" document member of the same patent family

Date of the actual completion of the international search

20 November 2008 (20.11.2008)

Date of mailing of the international search report

05 DEC 2008

Name and mailing address of the ISA/US

Mail Stop PCT, Attn: ISA/US, Commissioner for Patents

P.O. Box 1450, Alexandria, Virginia 22313-1450

Facsimile No. 571-273-3201

Authorized officer:

Lee W. Young

PCT Helpdesk: 571-272-4300

PCT OSP: 571-272-7774

INTERNATIONAL SEARCH REPORT

International application No.

PCT/US 08/78875

Box No. II Observations where certain claims were found unsearchable (Continuation of item 2 of first sheet)

This international search report has not been established in respect of certain claims under Article 17(2)(a) for the following reasons:

1. ☐ Claims Nos.:
because they relate to subject matter not required to be searched by this Authority, namely:
2. ☐ Claims Nos.:
because they relate to parts of the international application that do not comply with the prescribed requirements to such an extent that no meaningful international search can be carried out, specifically:
3. ☒ Claims Nos.: 2-10, 24-34, 44-47, 49-54, 65-70, 80-126, 128-169
because they are dependent claims and are not drafted in accordance with the second and third sentences of Rule 6.4(a).

Box No. III Observations where unity of invention is lacking (Continuation of item 3 of first sheet)

This International Searching Authority found multiple inventions in this international application, as follows:

1. ☐ As all required additional search fees were timely paid by the applicant, this international search report covers all searchable claims.
2. ☐ As all searchable claims could be searched without effort justifying additional fees, this Authority did not invite payment of additional fees.
3. ☐ As only some of the required additional search fees were timely paid by the applicant, this international search report covers only those claims for which fees were paid, specifically claims Nos.:
4. ☐ No required additional search fees were timely paid by the applicant. Consequently, this international search report is restricted to the invention first mentioned in the claims; it is covered by claims Nos.:

Remark on Protest

- ☐ The additional search fees were accompanied by the applicant's protest and, where applicable, the payment of a protest fee.
- ☐ The additional search fees were accompanied by the applicant's protest but the applicable protest fee was not paid within the time limit specified in the invitation.
- ☐ No protest accompanied the payment of additional search fees.