METHOD AND APPARATUS FOR SELECTION OF BALANCER STATIC IMBALANCE CORRECTION MODE

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See application file for complete search history.

References Cited
U.S. PATENT DOCUMENTS

2,080,227 A 5/1973 Periat et al. .................. 301/5.21
4,267,730 A 5/1981 Curchod et al. ............... 73/462
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ABSTRACT
A method for measuring the imbalance characteristics of a rotating body, and for determining if an application of at least one imbalance correction weight in only two identified imbalance correction weight planes is sufficient to reduce the measured imbalance characteristics of the rotating body to an acceptable residual imbalance level.

20 Claims, 13 Drawing Sheets
U.S. PATENT DOCUMENTS
6,484,574 B1  11/2002 Douglas et al. .................. 73/462

OTHER PUBLICATIONS
“In-Place Balancing of Rotating Machinery”, IRD Mechaanalysis, Inc., Columbus, Ohio, 1975. Form No. TP105, 22 Pages.

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FIG. 4 PRIOR ART

FIG. 5 PRIOR ART
FIG. 6 PRIOR ART

FIG. 7 PRIOR ART
Figure 8A: Prior Art

1. Start

2. Calculate Imbalance Correction Weight Amounts Required To Correct Measured Imbalance to Zero

3. Measure Imbalance Present In Rotating Body

4. Does The Calculated Weight Exceed The "Blind"?
   - Yes: Round The Imbalance Correction Weight Amount To The Smallest Incremental Weight Amount and Apply To The Rotating Body
   - No: Correction Weights Are Not Required

5. Done

Figure 8B

1. Start

2. Measure Imbalance(s) Present In Rotating Body

3. Is / Are Measured Imbalance(s) Above Imbalance Correction Threshold(s)?
   - Yes: Reduce The Magnitude Of At Least One Imbalance By An Amount Corresponding To A Residual Imbalance Level
   - No: Correction Weights Are Not Required

4. Calculate and Apply Imbalance Correction Weight Amounts Utilizing Reduced Magnitude Imbalance(s)

5. Done
START

Measure Imbalance Present In Rotating Body 170

Calculate Imbalance Correction Weight Amounts Required To Correct Measured Imbalance to Zero 172

Does The Calculated Weight Exceed The "Blind"? 173

YES

Calculate Imbalance Correction Weight Amounts Required To Correct Measured Imbalance to a Residual Imbalance Correction Goal 177

... (arrows and branches)

NO - Correction Weights Are Not Required 174

... (arrows and branches)

DONE 176

FIGURE 8C
FIG. 13

FIG. 14
COUPLE BLIND EQUIVALENTS TO .29 OZ - 15 INCH WHEEL RIM

FIG. 20
METHOD AND APPARATUS FOR
SELECTION OF BALANCER STATIC
IMBALANCE CORRECTION MODE

CROSS-REFERENCE TO RELATED
APPLICATIONS


STATEMENT REGARDING FEDERALLY
SPONSORED RESEARCH

Not Applicable.

BACKGROUND OF THE INVENTION

The present invention relates generally to automotive service equipment designed to measure imbalance in a vehicle wheel assembly, and in particular, to an improved vehicle wheel balancer system configured to identify an amount of imbalance correction weight for application to a vehicle wheel which is sufficient to reduce imbalances in the vehicle wheel below an imbalance correction threshold level.

Wheel balancer systems are designed to determine imbalance characteristics of a rotating body such as a wheel assembly consisting of a wheel rim and a pneumatic tire, or of a wheel rim alone. The determined characteristics include, but are not limited to static imbalances (i.e., "shake" forces), dynamic imbalances (i.e., couple or "shimmmy" forces), lateral forces, radial forces and runout parameters. Determination of some of these characteristics result from direct measurements, while others are obtained from an analysis of the mechanical vibrations caused by rotational movement of the rotating body. The mechanical vibrations are measured as motions, forces, or pressures by means of transducers mounted in the wheel balancer system, which are configured to convert the mechanical vibrations into electrical signals.

Additionally, it is important to provide an operator with information about whether or not there is a need to correct a detected imbalance in the wheel rim or wheel assembly, or if the detected imbalance is sufficiently small so as to have a negligible effect on vehicle performance and handling, i.e., below an imbalance correction threshold level. When there is a need to correct a detected imbalance in a vehicle wheel, current vehicle wheel balancer systems are designed to calculate the size and placement positions for one or more imbalance correction weights. The imbalance correction weights are typically made from lead, which is known to have toxic effects on the environment, or from zinc, which is less toxic than lead, but which is more expensive. Those of ordinary skill of the art will recognize that other materials may also be used for imbalance correction weights.

Current vehicle wheel balancer systems are configured to calculate a sufficient amount of imbalance correction weight to reduce the detected imbalance in the vehicle wheel assembly to near zero. Wheel rim sizes on the market range from 12.0 inches in diameter up to at least 28.0 inches in diameter.

It is anticipated that wheel rim sizes will increase to 30.0 inches and beyond in diameter in the future, with a corresponding increase in associated tire sizes. Due to the limited size increments in which imbalance correction weights are available, conventional vehicle wheel balancer systems are configured to display, as a zero value, any required imbalance correction weight amounts below the threshold associated with the smallest incremental weight size. Typically this weight threshold is selected to be slightly greater than the smallest standard incremental imbalance correction weight size, regardless of the size of the wheel rim or wheel assembly. Conventionally, imbalance correction weights are produced in increments of 0.25 ounces for English units, and 5.0 grams for metric units.

This can result in an operator "chasing" weights on a small or narrow wheel due to the significant effect of the threshold level on imbalances, and a poor balance on larger diameter wheels due to a reduced effectiveness of the threshold level. One solution is shown in U.S. Pat. No. 6,404,574 to Douglas, in which a balancer is configured to select the best weight plane locations from data acquired by scanning the rim profile. This is an advantageous method, but it is not economical for all balancers to have this feature.

Clearly, it would be advantageous to provide a vehicle wheel balancer system with a method for determining an imbalance threshold level at which imbalance correction is required for a vehicle wheel, and which is independent of the dimensions of the wheel assembly undergoing balancing or the incremental size of the imbalance correction weights employed, and which optionally provides an operator with a scaled visual indication of any imbalances present relative to the determined imbalance threshold level.

It would be further advantageous to provide a vehicle wheel balancer system with a method for reducing the amount of imbalance correction weight utilized to correct an imbalance measured in a vehicle wheel assembly, thereby either reducing the amount of lead weights introduced into the environment, or resulting in a corresponding cost savings through a reduction in the total applied weight amounts.

BRIEF SUMMARY OF THE INVENTION

Briefly stated, an aspect of the present invention provides a method for reducing imbalance in a rotating body to an acceptable residual level. The method includes the step of comparing a measured imbalance in the rotating body to an imbalance correction threshold. If the measured imbalance exceeds the imbalance correction threshold, a placement location and an amount of imbalance correction weight sufficient to reduce the imbalance in the rotating body to an acceptable residual level which is below the imbalance correction threshold, utilizing a residual imbalance goal greater than zero, is determined for application to the rotating body.

In an alternate embodiment of the present invention provides a method for reducing imbalance in a rotating body which includes the step of utilizing an imbalance force limit to identify a static imbalance threshold at which imbalance correction weights will be applied, and utilizing an imbalance moment limit to identify a dynamic imbalance threshold at which imbalance correction weights will be applied. An amount of imbalance correction weight required to reduce the imbalance forces in the rotating body to within a tolerance of a desired residual imbalance below the limits is calculated, and suitable imbalance correction weights are applied to the rotating body at calculated locations.

In an alternate embodiment, the present invention provides a method for determining a variable imbalance threshold
below which an imbalance in a rotating body is considered to be acceptable, based on a comparison of a desired imbalance correction weight plane dimensions for a rotating body with a set of imbalance correction weight plane reference dimensions. The variable imbalance thresholds for the rotating body are computed as a function of the change in diameter and plane separation for the desired imbalance correction weight planes from a set of reference dimensions. For rotating bodies having an imbalance which exceeds the variable imbalance threshold, an imbalance correction weight amount and placement location is identified which is sufficient to reduce the imbalance in the rotating body to within a tolerance of the acceptable level.

An alternate aspect of the present invention provides a method for determining when a single imbalance correction weight may be utilized to reduce static and dynamic imbalances in a rotating body to within a tolerance of the reference thresholds. Following a determination that an imbalance force present in a rotating body exceed a reference threshold, imbalance correction weight placement planes associated with the rotating body are identified. The imbalance correction weight amounts and placement locations within each of the identified imbalance correction weight placement planes are identified. Residual imbalance forces which will remain in the rotating body are predicted for the application of a single static imbalance correction weight in each of the identified imbalance correction weight placement planes. Finally, the application of a single imbalance correction weight which will result in the reduction of a predicted residual imbalance force in the rotating body to within a tolerance of a reference threshold is identified.

The foregoing and other objects, features, and advantages of the invention as well as presently preferred embodiments thereof will become more apparent from the reading of the following description in connection with the accompanying drawings.

BRIEF DESCRIPTION OF THE SEVERAL VIEWS OF THE DRAWINGS

In the accompanying drawings which form part of the specification:

FIG. 1 is a diagrammatic view illustrating a generic wheel balancer suitable for use with the present invention;

FIG. 2 is a simplified top plan view illustrating an alternate generic wheel balancer suitable for use with the present invention;

FIG. 3 is a block diagram illustrating various parts of a generic wheel balancer of FIG. 1 or FIG. 2;

FIG. 4 is a representation of a prior art balancer display indicating that no imbalance correction weights are required to correct an imbalance present in a rotating body having the illustrated dimensions;

FIG. 5 is a representation of a prior art balancer display indicating imbalance correction weight amounts required to correct the same imbalance as in FIG. 4 in a rotating body having smaller dimensions;

FIG. 6 is a representation of a prior art balancer display indicating required weight placement locations and amounts required to correct an imbalance in a rotating body of specific dimensions;

FIG. 7 is a representation of a prior art balancer display similar to FIG. 6, indicating that no imbalance correction weights are required to correct the same imbalance as in FIG. 6 in a rotating body with larger dimensions;

FIG. 8A is a flow chart diagram of a prior art method for determining required imbalance correction weights limited only by an imbalance correction weight threshold level;

FIG. 8B is a flow chart diagram of a method of the present invention for determining a reduced amount of imbalance correction weights;

FIG. 8C is a flow chart diagram of an alternate method of the present invention;

FIG. 9 is a graphical illustration of the difference in residual imbalance ranges in rotating bodies after imbalance correction between methods of the present invention and conventional imbalance correction methods;

FIG. 10 is a flow chart diagram of the method of the present invention shown in FIG. 8B utilized with calculated imbalance threshold levels;

FIG. 11 is a representation of a display of the present invention showing a graphical presentation of the imbalance forces in the rotating body of unknown dimensions;

FIG. 12 is a representation of a display similar to FIG. 9, indicating a pass condition for a rotating body of unknown dimensions;

FIG. 13 is a representation of a display of the present invention showing a graphical presentation of the imbalance forces in the rotating body;

FIG. 14 is a representation of a display similar to FIG. 13, indicating that no additional weight is required on the wheel with a smaller diameter dimension and having the same imbalance;

FIG. 15 is a representation of a display of the present invention showing a graphical presentation of the imbalance forces in the rotating body; and

FIG. 16 is a representation of a display similar to FIG. 15, indicating that less weight is required on a wheel with larger width (weight plane separation) dimensions but having the same imbalance;

FIG. 17 is a two dimensional graphical representation of the blind amount versus wheel diameter for a static imbalance limit;

FIG. 18 is a surface plot representation of the blind amount compared with wheel diameter and tire diameter for a static imbalance limit;

FIG. 19 is a surface plot representation of wheel rim diameter, wheel width, and couple blind amount for a couple imbalance limit; and

FIG. 20 is a surface plot similar to FIG. 19, for tire diameter, wheel width, and couple blind amount for a couple imbalance limit.

Corresponding reference numerals indicate corresponding parts throughout the several figures of the drawings.

DESCRIPTION OF THE PREFERRED EMBODIMENT

The following detailed description illustrates the invention by way of example and not by way of limitation. The description clearly enables one skilled in the art to make and use the invention, describes several embodiments, adaptations, variations, alternatives, and uses of the invention, including what is presently believed to be the best mode of carrying out the invention.

Turning to the drawings, FIGS. 1 and 2 illustrate, in simplified form, the mechanical aspects of a wheel balancer suitable for the present invention. The particular balancer shown is illustrative only, since one of ordinary skill in the art in the balancer field will recognize that the particular devices and structures used to obtain dimensional and imbalance
information related to a rotating body may be readily changed
without changing the present invention.

Balancer 10 includes a rotatable shaft or spindle 12 driven
by a suitable drive mechanism such as a motor 14 and drive
belt 16. Mounted on spindle 12 is a conventional optical shaft
encoder 18 which provides speed and rotational position
information to a central processing unit 20, shown in FIG. 3.
The actual construction of the mechanical aspects of the
balancer 10 can take a variety of forms. For example, the
spindle 12 can include a hub 12A against which the rotating
body 22 abuts during the balancing procedure.

During the operation of wheel balancing, at the end of
the spindle 12, a rotating body 22 under test is removably
mounted for rotation with the spindle hub 12A. The rotating
body 22 may comprise a wheel rim, or a wheel assembly
consisting of a wheel rim and a tire mounted thereon. To
determine the rotating body imbalance, the balancer includes
at least a pair of imbalance force sensors 24 and 26, such as
piezoelectric sensors or strain gauges, coupled to the spindle
12 and mounted on the balancer base 28. When a rotating body 22 is unbalanced, it vibrates in a
periodic manner as it is rotated, and these vibrations are
transmitted to the spindle 12. The imbalance sensors 22 and
24 are responsive to these vibrations in the spindle 12, and
generate a pair of analog electrical signals corresponding to
the phase and magnitude of the vibrations at the particular
sensor locations. These analog signals are input to circuitry,
described below, which determines the required magnitudes
and positions of correction weights necessary to correct the imbalance.

Turning to FIG. 3, wheel balancer 10 includes not only the
imbalance sensors 22 and 24, and spindle encoder 18, but also the
central processing unit 20 (such as a microprocessor,
digital signal processor, or graphics signal processor). The
central processing unit 23 performs signal processing on the
output signals from the imbalance sensors 22 and 24 to
determine an imbalance in the rotating body. In addition, the cen-
tral processing unit 20 is connected to and controls a display
30 which provides information to an operator, control motor
14 through associated motor control circuits 32, and keeps
track of the spindle rotation position with encoder 18.

Balancer 11 further includes one or more manual inputs 34,
such as a keyboard, control knobs, or selector switches, which
are connected to the central processing unit 20. The central
processing unit 20 has sufficient capacity to control, via soft-
ware, all the operations of the balancer 10 in addition to
to controlling the display 30. The central processing unit 20 is
connected to a memory such as an EEPROM memory 36,
EPROM program memory 38, and a dynamic RAM (DRAM)
memory 40. The EEPROM memory 36 is used to store non-
volatile information, such as calibration data, while the cen-
tral processing unit 20 uses the DRAM 40 for storing tempo-
rary data.

The central processing unit 20 is also connected to an
analog-to-digital converter 42. The signals from the imbal-
ance sensors 22 and 24 are supplied through anti-aliasing
circuitry 44A and 44B (if needed) to the analog-to-digital
converter 42.

The operation of the various components described above
is fully set forth in U.S. Pat. No. 5,396,436 to Parker et al.,
the disclosure of which is incorporated herein by reference.
It should be understood that the above description is included
for completeness only, and that various other circuits could be
used instead.

Other than when the rotating body 22 is accurately centered on
the balancer spindle 12, the balancer 10 can begin the process of
measuring one or more imbalance parameters of the rotating
body 22, and providing the operator with one or more sug-
gested imbalance correction weight magnitudes and place-
ment locations. Imbalance correction weight magnitudes and
placement locations are calculated and displayed to an oper-
ator on a screen or numerical readout 30.

Due to the limited size increments in which imbalance
correction weights are usually available, conventional bal-
ancer systems are configured to display to the operator a zero
weight correction value for any imbalances which would
require the installation of an imbalance correction weight
amount which is below an amount which is set at or near the
smallest incremental correction weight amount.

For a balancer system adapted to use imbalance correction
weights having 0.25 oz. increments, an exemplary limit is
0.29 oz. Unfortunately, this can result in an operator “chas-
ing” weights on a small or narrow wheel due to the insigni-
ficant effect of the correction weight on imbalances, and a poor
balance on today’s larger diameter wheels.

For example, as shown in FIG. 4, a wheel having a 6.0 inch
axial width, and a 15.0 inch diameter might have an imbal-
ance which would require the application of an amount of
imbalance correction weight below the imbalance correction
weight amount threshold. As a result, the balancer indicates
that no imbalance correction weights are required for either
the left or right imbalance correction planes. However, as
shown in FIG. 5, if the dimensions of the wheel are changed,
such as by the operator using the “SET DIMENSIONS”
button 150, to indicate a 5.0 inch axial width and a 14.0 inch
diameter, without re-measuring the wheel imbalance, greater
weight amounts are required to correct the same imbalance. If
these weight amounts exceed the imbalance correction weight
amount threshold, a conventional balancer directs an oper-
ator to install sufficient imbalance corrections weights in
the left and right imbalance correction planes (as indicated by
arrows 152) to reduce or eliminate the imbalance, despite the
fact that the amount of the imbalance is unchanged from that
considered “acceptable” in a rotating body having larger
dimensions.

An opposite and more serious problem exists for conven-
tional balancer systems when balancing large wheels. For
example, as shown in FIG. 6, a wheel having an 8.0 inch axial
width, and a 16.0 inch diameter might have an imbalance
above the imbalance correction weight threshold, resulting in
the balancer indicating that imbalance correction weights
are required for both the left or right imbalance correction planes.
However, as shown in FIG. 7, if the dimensions of the wheel
are changed, such as manually by the operator using button
150, to show an 18.0 inch diameter, without re-measuring the
wheel imbalance, less weight is required to correct the same
imbalance, which drops below the weight threshold level. As
a result, a conventional balancer now indicates that no
weights in the left and right imbalance correction planes are
required, despite the fact that the amount of the imbalance is
unchanged from that considered “unacceptable” in a rotating
body having smaller dimensions.

As shown in FIG. 8A, to minimize the amount of imbalance
in a rotating body, conventional balancer systems ini-
tially measure the imbalances present in the rotating body
(Box 140). Each imbalance may be expressed as a vector
having a magnitude and a phase, or as weight amount and
placement location. Imbalance correction weight amounts
and placement locations required to reduce the imbalance
magnitudes to zero are determined (Box 142). The deter-
mined imbalance correction weight amounts are compared
with the "blind" or imbalance correction weight threshold for
the rotating body (Box 143). If the imbalance correction
weight amounts are below the "blind" or acceptable imbal-
ance correction weight thresholds, as indicated at 144, no im-
5 balance correction weight applications are required for the
rotating body, and the process is completed (Box 146). If
however, the imbalance correction weight amounts exceed
the acceptable imbalance correction weight thresholds, the
imbalance correction weight amounts are rounded to the
smallest incremental weight amount available, and applied to
the rotating body (Box 148).
In contrast, a method of the present invention as illustrated
in FIG. 8B seeks to reduce the amount of imbalance present in
a rotating body to an acceptable level (a residual imbalance
goal) with the application of a reduced amount of imbalance
correction weight, and does not attempt to minimize the
residual imbalance present in the rotating body. An initial
measurement of each imbalance present in the rotating body
(Box 150) is acquired. Each imbalance may be expressed as a
vector having a magnitude and a phase. The measured im-
balances are compared with acceptable thresholds for the rotat-
ing body (Box 152).
If the measured imbalances (such as static and couple
forces) are below the imbalance threshold corrupted at 154, no imbalance correction weight applications are required for the rotating body, and the process is completed (Box 156).
10 However, if the measured imbalances exceed the imbalance correction thresholds, a sufficient amount of imbalance correction weight is calculated for application to the rotating body to reduce the imbalance of the rotating body to within a tolerance of a residual imbalance level. Preferably, the magnitude of a component portion of each measured imbalance is reduced by an amount corre-
sponding to a residual imbalance level (Box 158), and imbal-
ance correction weight amounts are then calculated and
applied to the rotating body to correct the reduced the imbal-
ance in the rotating body (Box 160). Alternatively, the magni-
ditudes of the component portions of each measured imbal-
ance may be calculated by other known mathematical
methods, such as iterative approaches, to leave the desired
residual imbalance in the rotating body after imbalance cor-
correction weight application.
In general terms, as shown in FIG. 8C, the a balance
15 system of the present invention will initially measure the
imbalances present in the rotating body (Box 170). Each
imbalance may be expressed as a vector having a magnitude
and a phase, or as weight amount and placement location.
Imbalance correction weight amounts and placement loca-
tions required to reduce the imbalance magnitudes to zero are
determined (Box 172). The determined imbalance correction
weight amounts are compared with the “blind” or imbalance correction weight thresh-
10 olds, as indicated at 174, no imbalance correction weight
applications are required for the rotating body, and the pro-
cess is completed (Box 176). If however, the imbalance cor-
correction weight amounts exceed the acceptable imbalance
20 correction weight thresholds, imbalance correction weight
amounts and placement locations required to reduce the
imbalance magnitudes to a residual imbalance correction
goal are determined (Box 177). Finally, the determined
imbalance correction weight amounts are rounded to the
smallest incremental weight amount available, and applied to
the rotating body (Box 178).
30 It is to be noted that alternate approaches can be employed
to bring down the imbalance or imbalance components of the
rotating body to a non-residual imbalance goal without
departing from the scope of the invention. For example the
rotating body can be associated with an energy and or ener-
gies of at least a component due to imbalance (such as static
or couple), where at least one weight is computed and applied
to leave a desired residual level of energy (or component
energy such as static or couple).
35 The application of the imbalance correction weight
terms determined using the methods of the present inven-
tion is intended to leave a residual imbalance in the rotating
body which is equal to, or below, the imbalance correction
threshold for that component portion of the imbalance, but
which is not minimized. In essence, the method of the present
invention intentionally leaves a residual imbalance which is
greater than that left by conventional balancer systems, but
which is below the associated acceptable threshold. In gen-
eral, the amount of imbalance correction weights to be
applied to the rotating body may be calculated by any of a
variety of known mathematical methods, such as vector math-
ematics or iterative techniques, to leave a desired residual
imbalance in the rotating body after application of the imbal-
cance correction weights.
As best shown in FIG. 9, those of ordinary skill in the art
will recognize that placement error, weight amount errors,
machine noise, and rounding of the imbalance correction
weight amounts to the smallest available incremental weight
size will result in residual imbalances in the rotating body
may not exactly match a residual imbalance goal which is not
zero, but which will be within a known tolerance about that
non-zero goal. The tolerance is typically defined by the
rounding up or down of the calculated weight amount to
accommodate the smallest incremental weight amount avail-
able to an operator. FIG. 9 further illustrates a difference in
the results achieved by the present invention when compared
with conventional balancing methods. Imbalanced rotating
bodies, such as vehicle wheels, which have been corrected
using convention balancing methods will have a range of
expected residual imbalances which are equal to, or slightly
above zero. In contrast, imbalanced rotating bodies which
have been corrected using the methods of the present inven-
tion will have an expected range or tolerance of residual
imbalance which range from slightly above to slightly below
the non-zero residual imbalance goal.
30 By leaving a greater residual imbalance in the rotating
body, the methods and apparatus of the present invention
require a smaller amount of imbalance correction weights to
be applied to the rotating body to achieve an acceptable level
of imbalance reduction, thus resulting in savings in terms of
both time and cost. For example, using actual imbalance
measurement data acquired from approximately 7500 differ-
ent vehicle wheels, it was found that conventional vehicle
wheel balancing procedures required approximately 16,500 oz.
of imbalance correction weights to correct the measured
imbalances. Applying the methods of the present invention to
the same imbalance measurements, approximately 13,250 oz.
of imbalance correction weights would have been utilized,
which would have resulted in an average imbalance correc-
tion weight amount savings of 20%.
40 The average amount of imbalance correction weight saved
for each vehicle wheel varies depending upon the type of
imbalance correction weights being utilized and their associ-
ated placement locations about the vehicle wheel assembly.
For example, it has been observed that an average savings
approaching 30% can be achieved when using the methods of
the present invention with one or more adhesive-type imbal-
cance correction weights. Not only is the weight cost savings
readily more apparent using adhesive weights but the labor
and confusion is reduced as well. For example the invention
has been shown to reduce the need for two strips adhesive weights (e.g. when over 3.0 oz. is required) of at a weight location to just one strip.

It will be appreciated that information about the amount of imbalance correction weight saved when using the methods of the present invention for the imbalance correction of a rotating body, such as a vehicle wheel, may be useful to an operator. Accordingly, it will be recognized that the methods of the present invention may be adapted to store information that is or can be used to determine the amount of imbalance correction weight saved when compared against the amount of imbalance correction weights which would have been applied had one or more conventional imbalance correction procedures been utilized to reduce a measured imbalance to at or near zero. This information may be stored for later retrieval and analysis, and/or it may be displayed to the operator during the imbalance correction procedure.

In an alternate embodiment of the present invention, the balancer 10 is provided with a reference value representative of the maximum imbalance effect which is permitted for each type of imbalance in the rotating body 22 to be corrected, i.e., \( F_{max} \) for static imbalance and \( M_{max} \) for dynamic imbalance. For example, the static imbalance force limit \( F_{max} \) is provided to identify a static imbalance threshold, and a dynamic imbalance moment limit \( M_{max} \) is provided to identify a dynamic imbalance threshold, selected to correspond to levels of imbalance forces in the rotating body 22 which are imperceptible to the average consumer. For example, 2.18 oz.-in. for a static imbalance moment limit, corresponding to a 0.29 oz. weight on a 15\(^\circ\) diameter wheel rim, and 15.0 oz.-in.\(^2\) for a dynamic imbalance limit which corresponds to approximately a 0.33 oz. weight on each plane of 6\(^\circ\) wide, 15\(^\circ\) diameter wheel rim, each separate by 180 degrees.

It may be desirable, however, to adjust these limits to favor either static imbalance or dynamic (couple) imbalance. For instance, it is understood that passengers in a vehicle are less sensitive to a dynamic (couple) imbalance than a static imbalance. The values for \( F_{max} \) and \( M_{max} \) may be programmed into the balancer 10 or selected as a function of the particular class of vehicle undergoing service (i.e. passenger vehicle, sport utility vehicle, light truck), as a function of the type of tire being balanced, or based upon a database of specific vehicle types and tire combinations. Vehicles with lower sensitivity to imbalance forces can tolerate a greater imbalance level in the tire assemblies without perception by the average consumer. For example, a way to reduce imbalance correction labor with a minimal increase in vibration would be to increase the dynamic limit \( M_{max} \) to 20.0 oz.-in.\(^2\) for some types of rotating bodies 22.

Preferably, the calculated imbalance correction weight amounts are sufficient to reduce the residual imbalance in the rotating body to a residual imbalance level, or imbalance tolerance level, which is approximately 90% of the acceptable imbalance thresholds, in contrast to prior art balancer systems which seek to minimize the residual imbalance forces in the rotating body to a value at or near zero, limited only by rounding the applied imbalance correction weight amounts to the smallest incremental weight amount available for application to the rotating body. The residual imbalance level or tolerance may be a function of the acceptable imbalance threshold (i.e. a percentage thereof), a fixed value, a user selectable value, or selected using a database of vehicle information. By selecting a permissible residual imbalance level or tolerance in the rotating body which is below the acceptable imbalance thresholds, but which is greater than the zero, the amount of correction weight which must be utilized to bring the imbalance present in the rotating body to the acceptable level is reduced, resulting in cost savings.

For prior art balancer systems which calculate an imbalance correction weight amount necessary to reduce a measured imbalance to zero, an alternate method of the present invention to reduce the applied amount of imbalance correction weight requires calculating and applying a reduced imbalance correction weight amount which is less than the amount of the originally calculated imbalance correction weight amount which would have been applied to correct the measured imbalance to near zero, thereby leaving an intentional residual imbalance in the rotating body. After application of the reduced imbalance correction weight amount to the rotating body, one or more repetitions of the imbalance measurement and correction weight calculation process may be required to ensure that the imbalances present in the rotating body have been reduced to an acceptable residual imbalance level below the imbalance correction threshold.

It will be recognized that the various methods of the present invention may be utilized with a wide variety of balancer systems, including those which utilize fixed imbalance threshold levels, as well as balancer systems which calculate imbalance threshold levels based upon dimensions of the rotating body, such as shown in FIG. 10.

As shown in FIG. 10, a balancer 10 is configured to select an imbalance correction weight threshold or “blind” based upon one or more dimensions of the rotating body 22 being balanced. These dimensions include the imbalance correction weight placement diameter and an imbalance correction weight placement separation distance. Preferably, these dimensions are measured directly by the balancer 10, such as by utilizing operator assistance to place a wheel dimension measurement device at the desired imbalance correction weight planes and/or at the edge of the rotating body 22, or by non-contact measurement means. Alternatively, when the diameter and width of a rotating body 22 are known, an operator can directly supply the balancer 10 with corresponding values using one or more manual inputs 34 (Box 200).

The balancer 10 is configured to utilize the value representative of the maximum imbalance effect permitted, together with the associated dimensions of the rotating body 22 to identify a variable imbalance correction threshold used to display, to an operator on display 30, as zero any imbalance which would require an imbalance correction weight value below the variable threshold. (Box 204).

For correcting static imbalances present in the rotating body 22 (Box 206), the static imbalance force limit is \( F_{max} \) (typically in units of oz.-in.), the known or measured rotating body diameter is \( D \), and the imbalance correction weight threshold or “blind” is \( W_{BS} \). A variable threshold value for \( W_{BS} \) is determined by the balancer 10 according to the following equation:

\[
W_{BS} = \frac{F_{max} \cdot D}{2}
\]

Equation (1)

For correcting dynamic imbalances present in the rotating body 22 (Box 208), the dynamic imbalance moment limit is \( M_{max} \) (typically in units of oz.-in.\(^2\)) the known or measured rotating body axial length or axial width is \( W \), and the imbalance correction weight threshold or “blind” is \( W_{BS} \). If it is assumed that there is no static imbalance in the wheel, a
variable threshold value for $W_{BD}$ is determined by the balancer $10$ according to the following equation:

$$W_{BD} = M_{max}/W * (D/2)$$  \hspace{1cm} \text{Equation (2)}$$

For example, if the balancer $10$ is configured with a static imbalance force limit ($F_{max}$) of 2.18 oz.-in. for correcting static imbalances present in the rotating body 22, and the rotating body 22 has a measured or known diameter of 15.0", solving Equation (3) above for $F_{max}$ yields an imbalance correction weight threshold or "blind" of 0.29 oz. If the rotating body 22 has a measured or known diameter of 12.0", Equation (3) yields an imbalance correction weight threshold or "blind" of 0.36 oz. Correspondingly, if the rotating body 22 has a measured or known diameter of 20.0", Equation (3) yields an imbalance correction threshold or "blind" of 0.21 oz. for the same value of $F_{max}$.

The benefit offered by a balancer 10 configured to utilize the aforementioned methods to identify imbalance correction thresholds based in-part upon the known or measured dimensions of a rotating body 22 undergoing balancing can be clearly illustrated by the following comparisons.

When balancing a wheel assembly having a 15.0" diameter wheel rim with an axial width of 5.0", it is possible for a conventionally configured balancer to identify a static imbalance over the limit of 2.18 oz.-in. but a dynamic imbalance under the limit of 15.0 oz.-in.$^2$ and suggest a correction requiring two imbalance correction weights of 0.25 oz. and 0.75 oz., one to be placed on the inner lip of the wheel rim, and the other to be placed on the outer lip of the wheel rim. However, on a balancer 10 configured with a dynamic imbalance moment limit ($M_{max}$) of 15.0 oz.-in.$^2$, the dynamic imbalance is determined to have minimal effect on the vehicle and will be ignored and the remaining static imbalance can be corrected by a single 0.25 oz. weight.

By setting the imbalance threshold amounts based on the actual force and moment values, rather than displayed weight amounts, it is possible to minimize the residual imbalance in a wheel. A conventional balancer may measure a purely static imbalance that requires 0.50 oz. weight to correct. If the balancer is set to the "Dynamic" balance mode it will calculate that a 0.25 oz. weight is required on both the left and the right planes. Since the traditional threshold is set to 0.29 oz. the machine will show that no correction weights are required, but the wheel is not balanced. With the method of the present invention employed, a reduced correction weight amount will be displayed and the wheel will be balanced within the acceptable imbalance thresholds. In the example described above, there is a small amount of couple imbalance present along with the static imbalance. Even though the amount of couple is small and no specific weights are required to correct it, it is possible to place the static correction weight in a location to possibly reduce the couple imbalance.

When correcting the static imbalance, the single static weight can be placed on either the inner plane, adjacent the balancer, or the outer plane, opposite the balancer. The inner plane is alternatively referred to as the left plane, when the wheel is mounted on the right side of a balancer, and the outer plane is alternatively referred to as the right plane for the same wheel placement. To choose the correct plane in which to place the single static weight, it is necessary to compare the phase of the dynamic imbalance vector to the phase of the static force vector. The static correction weight is placed on the plane that minimizes the residual dynamic imbalance, without the placement of additional couple imbalance correction weights.

This will correct the static imbalance (which was greater than the blind), and depending upon the difference between the couple and static imbalance phase, it will decrease the couple imbalance or leave it unchanged (couple imbalance was already acceptably low). Since the inner and outer plane couple imbalance phases are always 180 degrees apart, the static imbalance phase will never be more than 90 degrees away from one of the couple imbalance phases. If the difference between the static and one of the couple imbalance phases is small, there will be a significant improvement in couple imbalance. If the static imbalance phase is exactly 90 degrees between both couple imbalance phases, the couple imbalance will not change when the static correction weight is added. This can be accomplished by the following logic sequence:

Assume the balancer is in "Dynamic" mode, static imbalance is greater than blind, and couple imbalance is less than the blind. The following steps are taken to place a single weight that will correct the static imbalance while reducing (or not changing) the couple imbalance.

Let couple imbalance=0 and calculate the static correction weight.

Static weight magnitude= Static imbalance/radius

Static weight phase= Static imbalance phase+180 degrees.

To correct the static imbalance, this weight could be placed on either the inner plane or the outer plane.

If the difference between the static imbalance phase angle and the outer plane couple imbalance phase angle is less than 90 degrees, place the single static correction weight on the outer plane. Otherwise, place the weight on the inner plane.

If the balancer is in "Static" mode it is common that dimensions will only be entered for a single plane. With the present invention it is desirable to compare the dynamic imbalance to the dynamic threshold. If the dynamic imbalance exceeds the threshold it is desirable to provide an indicator to the operator of this condition. The indication may be in the form of blinking lights, alpha-numeric text, or in the form of a message. If the operator has entered dimensions for two planes the indicator may be in the form of a display of the weights required to correct the couple imbalance.

A balancer 10 of the present invention may be configured to acquire initial vector measurements of the static and couple imbalances of a rotating body 22, represented as $S_1$ and $C_1$, prior to utilizing dimensional measurements of the rotating body 22 (i.e., such as a rotating body or vehicle wheel of unknown dimensions). The specific dimensional measurements of the rotating body, and the dimensional locations at which to place imbalance correction weights, are not utilized in an initial vector measurement of the imbalance forces on the rotating body 22. The measured values for $S_1$ and $C_1$ are compared to reference imbalance component limits $F_{max}$ and $M_{max}$ to determine if the additional steps associated with the determination and placement of imbalance correction weights are required. If the imbalance forces present in the rotating body 22 are below the reference thresholds, they may optionally be displayed in a graphical representation, as shown in FIG. 11, and require no further corrective action, which may be indicated as a "passed" condition for the rotating body 22, such as shown in FIG. 12.

If the measured imbalance forces exceed the reference thresholds, the operator may be directed to proceed to a dimensional measurement step, after which the reduced imbalance correction weight amounts and applications loca-
tions are calculated and displayed according the method of
the present invention, but without the use of a conventional
“blind” setting.

Alternatively, the vehicle wheel balancer 10 may be con-
figured to compute imbalance correction weight amounts and
placement locations for a rotating body 22 of unknown
dimensions utilizing a set of reference dimensions, such as
a 15.0 in. diameter and a 6.0 in. width, together with the mea-
sured imbalance forces present in the rotating body 22. The
computed imbalance correction weight amounts are then
compared by the balancer 10 with reference weight amounts
associated with a rotating body having the reference dimen-
sions, and a determination of acceptance based there on. For
example, if the computed imbalance correction weight
amounts are less than the reference weight amounts, the bal-
ancer 10 may be configured to indicate the rotating body has
“passed”, and does not require any imbalance corrective
action. Conversely, if the computed imbalance correction
weight amounts exceed the reference weight amounts, the
balancer 10 is configured to calculate reduced corrective
imbalance correction weight amounts and placement loca-
tions utilizing actual dimensions of the rotating body 22
undergoing balance testing according to the method of the
present invention.

The ability of a vehicle wheel balancer system 10 to evalu-
ate the imbalance forces and/or imbalance correction weight
amounts associated with a rotating body prior to a determi-
nation or measurement of the actual dimensions of the rotat-
ing body 22 provides an operator with a potentially significant
time savings during a balancing operation. This may be useful
for a variety of vehicle wheel balancer systems, including
those employing non-contact wheel measurement systems
such as ultrasonic measurement systems, laser-based meas-
urement systems, or, machine vision measurement systems,
which require a considerable amount of time to acquire the
wheel dimensional measurements relative to the amount of
time required to determine the imbalance forces present in
the wheel.

An alternate embodiment of the variable correction weight
threshold computation utilizes a comparison of selected
imbalance correction weight plane locations to a set of refer-
ence imbalance correction weight plane locations, with
out requiring imbalance force measurements of the rotating
body 22 or utilizing reference imbalance force limits Fmax or Mmax.
For example, the set of reference imbalance correction weight
plane locations may correspond to the 15.0 inch diameter and
6.0 inch width dimensions previously described, associated
with the “feel to the driver” equivalent imbalance force limits
Fmax and Mmax, caused by placing a 0.29 oz. static weight and
0.33 oz. of couple pair weights on a wheel.

The imbalance correction weight thresholds Wbd and Wbd are
then determined as a change in “reference” weight thresh-
hold limits Wbd_ref and Wbd_ref as a function of the change in
diameter and plane separation of the selected imbalance correc-
tion weight planes from the reference dimensions:

\[ W_{bd} = W_{bd_{-ref}} (D_{bd_{-ref}} / D) \]  

Equation (3)

where: \( W_{bd} \) represents the static weight threshold for
the wheel under test; \( W_{bd_{-ref}} \) represents the static weight
threshold for the reference wheel (such as 0.29 oz); \( D_s \) repres-
sents the diameter of the static weight placement location of
the wheel under test; and \( D_{bd_{-ref}} \) represents the diameter of
the static weight placement location of reference wheel (such as
15.0 inches).

\[ W_{bd_{-ref}} = W_{bd_{-ref}} (D_{bd_{-ref}} / D_{bd_{-ref}}) \]  

Equation (4)

where \( W_{bd_{-ref}} \) represents the dynamic weight threshold for
the wheel under test; \( W_{bd_{-ref}} \) represents the dynamic weight
threshold for a reference wheel (such as 0.33 oz); \( D_s \) repres-
sents the diameter of the dynamic weight pair placement of
the wheel under test; \( D_{bd_{-ref}} \) represents the diameter of
the dynamic weight pair placement of reference wheel (such as
15.0 inches); \( W \) represents the plane separation of dynamic
weights of the wheel under test; and \( W_{bd_{-ref}} \) represents the
plane separation of the dynamic weights of reference wheel
(such as 6.0 inches).

For some rotating bodies 22, the inner and outer planes on
which imbalance correction weights are to be placed could
have different diameters, particularly when dealing with
adhesive imbalance correction weights disposed on the inside
of a wheel rim having an internal taper or steps along the
profile. For this case, the value of \( D_s \) utilized in Equation (2)
is the average of the inner and outer plane diameters.
Although this places the imagined “dynamic weight pair
placement diameter” literally in mid air for the left plane
and inside the wheel material for the right plane, it is only
a temporary usage to compute the display threshold for the
dynamic imbalance correction weight pair, and does not
affect the accuracy of weight computations which utilize the
actual inner and outer plane diameters as taught in U.S. Pat.
No. 5,396,436 to Parker et al.

Finally, the static and dynamic imbalance correction
weight vectors which are above the respective variable
thresholds \( W_{bd} \) and \( W_{bd_{-ref}} \) are vectorially combined, as is
known in the art, to produce a displayed representation of
the inner and outer imbalance correction weight vectors,
simultaneously correcting the rotating body for both static
and moment imbalances.

An alternate method is to compute the weights as taught in
U.S. Pat. No. 5,396,436 to Parker et al. from the static and
moment imbalance vector components \( S \) and \( C \), and
weight placement dimensions \( A = AC, W, Ri, Ro \); except if
either one of the static or dynamic computed weight vectors is
less than \( W_{bd} \) or \( W_{bd_{-ref}} \) respectively, the values for \( S \) or \( C \),
respectively are simply excluded from the weight computa-
tions.

A second alternate method is the case when the moment
threshold \( W_{bd} \) is exceeded to is to apply the static imbalance
correction even when \( W_{bd} \) is not exceeded. Two imbalance
correction weights will be applied to correct the couple
imbalance in the rotating body, so this allows the final weight
computation (which simultaneously corrects for both static
and dynamic imbalance using the two imbalance correction
weights) to possibly further reduce any static residual
imbalance in the rotating body. The imbalance correction
weights must be rounded to the nearest incremental weight amount so
the portion needed to correct the small static component may be
included in the displayed imbalance correction weight values.

It may be desirable, to adjust these limits to favor either
static imbalance or dynamic (couple) imbalance. For instance,
the static weight is understood that passengers in a vehicle are less
sensitive to a dynamic (couple) imbalance than a static
imbalance. The values for \( W_{bd_{-ref}} \) and \( W_{bd_{-ref}} \) may be
programmed into the balancer 10 or selected as a function of the particular
class of vehicle undergoing service (i.e. passenger vehicle,
the utility vehicle, light truck), as a function of the type
of tire being balanced, or based upon a database of specific
vehicles or tire combinations. Vehicles with lower sensitiv-
ity to imbalance forces can tolerate a greater imbalance
level in the tire assemblies without perception by the average
consumer.
An alternate embodiment of the present invention for enabling the placement of a single imbalance correction weight predicts a residual couple imbalance remaining in the rotating body 22 after application of the single (static) imbalance correction weight to either just the inner or just the outer correction plane. The predicted residual moment vector is computed by vector subtracting the moment vector that would be caused from a static weight vector at a chosen correction plane from the measured moment imbalance vector. It is important to note that when the two weight correction planes are at different diameters on the rotating body 22, such as when at least one of the weights is an adhesive weight to be applied to an internal surface of a wheel, the magnitude of the static correction weight vector for the left plane placement will be different than for the right plane placement.

Subsequent to a determination that the rotating body 22 requires imbalance correction, weight plane locations are selected and the balancer 10 then determines if a single imbalance correction weight can be applied which will result in an acceptable residual dynamic imbalance \( M_{n_{max}} \) in the rotating body 22 according to the following procedure:

First, the correction weight plane locations \( A \rightarrow AC \), \( W \), \( R_i \), and \( R_o \) are determined for the rotating body, where \( "A" \) represents the distance measured to the inner weight plane of the rotating body 22; "AC" represents the distance from a reference plane of \( A \) to the origin of the coordinate systems; "W" represents the width between the weight planes of the rotating body 22; "Ri" represents the radius of the inner weight position; and "Ro" represents the radius of the outer weight position, as described in U.S. Pat. No. 5,396,436 to Parker et al.

Next, a residual imbalance prediction \( C_{res.i} \) is computed for only a static imbalance correction weight applied to the inner weight plane according to:

\[
C_{res.i} = C - (S_i/R_i)^2 = (l_i - A(R_i/R_o))^2
\]

where \( "C\)" denotes a vector, \( "S\)" denotes a couple imbalance applied at the origin, and \( "S_i\)" denotes static imbalance applied at the origin.

Similarly, a residual imbalance prediction \( C_{res.o} \) is computed for only a static imbalance correction weight applied to the outer weight plane according to:

\[
C_{res.o} = C - (S/o/R_i)^2 = (l_i - A(R_i/R_o))^2
\]

The lesser magnitude of \( C_{res.i} \) and \( C_{res.o} \) is selected, and if it is less than the dynamic imbalance moment limit or threshold \( M_{n_{max}} \) the balancer 10 directs the operator to apply the static imbalance correction weight on the corresponding weight plane, preferably by providing a display of the static imbalance correction weight amount on a display associated with the corresponding plane, and displaying a zero value for the other plane.

When utilizing a pair of equal clip-on imbalance correction weights at the inner and outer planes of the rotating body 22, \( R_i = R_i = D/2 \), the static weight is the same for each plane, and Equations (5) and (6) reduce to:

\[
C_{res.i} = C - (S_i/D)^2 = (l_i - A(D/2))^2
\]

\[
C_{res.o} = C - (S/o/D)^2 = (l_i - A(D/2))^2
\]

The single weight computations can be applied to favor one possible balance plane based on the style of imbalance correction weights utilized.

For inner and outer plane clip-on balancing, the balancer 10 may be optionally configured to avoid directing the operator to install a single imbalance correction weight on the outer plane when it is possible to place a single imbalance correction weight only on the inner plane and maintain the residual dynamic imbalance moment below the dynamic imbalance moment limit or threshold \( M_{n_{max}} \). This option is particularly suited for applications where the rotating body 22 or wheel does not physically support the ability to place a clip-on imbalance correction weight on the outer plane or where a customer simply does not want an imbalance correction weight on the outside of a wheel for aesthetic reasons.

For mix-weights balancing where a clip-on imbalance correction weight is to be applied to the inner plane and an adhesive imbalance correction weight is to be applied to the outer plane, the balancer 10 may optionally be configured to favor the inner clip-on imbalance correction weight location for the single weight (providing the residual dynamic imbalance moment prediction is below \( M_{n_{max}} \)) even if placement of an imbalance correction weight at the adhesive location would result in less residual dynamic imbalance. This option is particularly suited due to the relative ease of applying a clip-on imbalance correction weight versus an adhesive imbalance correction weight; cost savings associated with a clip-on imbalance correction weight; and for some rotating body 22 application (i.e., wheels), brake calipers fit so close to the inside surfaces of some wheels that adhesive weights cannot be used in that area.

To aid an operator in determining if a rotating body 22 has been balanced to within a threshold for both static imbalance and dynamic imbalance, the balancer 10 in an alternate embodiment is configured to provide the operator with a graphical illustration 300 of the measured imbalances relative to the threshold level of absolute imbalances on display 30, i.e. the couple imbalance threshold and the static imbalance threshold. Conventionally, such as shown in U.S. Pat. No. 5,915,274 to Douglas, weights required to correct static and dynamic imbalances are displayed relative to a fixed weight amount threshold to an operator on a bar graph. The fixed weight amount is based on the incremental weight size and the vehicle wheel geometry. In contrast, the graphical illustration 300 of the present invention displays information to an operator based upon absolute imbalances, and not on the incremental weight sizes and vehicle wheel geometry.

Turning to FIGS. 13 and 14, a display 30 from a balancer 10 configured with the features of the present invention is shown first for a wheel having an axial length or width of 6.0 inches and a diameter of 15.0 inches. In this example, the imbalance present in the wheel for both static and dynamic imbalance is below a threshold level. This is illustrated with the graphical illustration 300, incorporating a sliding scale 302 for static imbalance, and a sliding scale 304 for dynamic imbalance. On each sliding scale 302 and 304, shown in FIG. 13, the computed imbalance amounts, as indicated by the arrows 306 and 308, fall within the acceptable range, hence no imbalance correction weight amounts are indicated for the left and right correction planes. Further, as shown in FIG. 14, if the dimensions of the wheel are manually changed by the operator to indicate a 5.0 inch axial width and a 14.0 inch diameter, (corresponding to the change shown in FIG. 5) without re-measuring the imbalance, the measured imbalance in the wheel remains unchanged, as shown on the sliding scales 302 and 304. As a result, no imbalance correction weight amounts are indicated for the left and right correction planes.

The method of the present invention also provides an advantage when balancing large wheels. For example, as shown in FIG. 15, a wheel having a 8.0 inch axial width, and a 16.0 inch diameter might have an imbalance above the threshold, as shown on sliding scales 302 and 304, resulting in the balancer displaying to an operator imbalance correction weight amounts not indicated for the left and right correction planes.
weights required for both the left and right imbalance correction planes. However, as shown in FIG. 16, if the dimensions of the wheel are manually changed by the operator to show an 18.0 inch diameter, without re-measuring the imbalance, less weight is required to correct the same imbalance. As a result, the balancer indicates to an operator that reduced weights in the left and right imbalance correction planes are still required to correct the imbalance which is above the imbalance threshold.

It is known that a rotating body 22 static imbalance force is a function of the imbalance mass, the radial distance of the imbalance mass from the axis of rotation, and the angular velocity of the rotating body 22. In a vehicle wheel application, where the rotating body 22 consists of a wheel rim and tire assembly, for any given vehicle speed, the angular velocity may be expressed as a function of the tire diameter or as a function of the tire diameter and the wheel rim diameter. Hence, in an alternate embodiment of the present invention, the imbalance force F, experienced by a vehicle from a rotating wheel assembly may be defined as:

$$ F = \frac{v}{2\pi D_T} \frac{m D_w}{D_T} $$

where v is the vehicle velocity, D_T is the tire diameter, D_w is the correction weight application diameter, which is equal to the wheel diameter for Clip-on weights, and m is the imbalance mass. For example, if an acceptable imbalance correction threshold or “blind” for a wheel rim having a diameter D_{rim} of 15.0” with a tire having a diameter D_T of 28.0” is 0.29 oz. (m_1), an equation for calculating an equivalent “blind” (m_2) for an assembly with the dimensions D_{rim} and D_T is:

$$ m_2 = m_1 \frac{D_{rim}}{D_T} \frac{D_T}{D_{rim}} $$

Once an acceptable imbalance correction threshold or “blind” is established for a particular tire and rim combination, an equivalent couple imbalance correction weight threshold or “blind” may be automatically calculated using Equation (10) for a wide variety of wheel assemblies, providing an imbalance correction threshold curve, such as shown in FIG. 17 for wheel rim dimensions and in FIG. 18 for tire dimensions.

Utilizing the tire diameter D_T and the wheel diameter D_{rim} wheel assemblies may be classified into predefined groupings. For example, performance wheel assemblies where D_T - D_{rim} is relatively small (≤3.0 inches or less), touring wheel assemblies, where D_T - D_{rim} is between 3.0 in. and 5.0 in., and truck wheel assemblies, where D_T - D_{rim} is greater than 5.0 in. Each different predefined grouping may be provided with a different acceptable imbalance correction threshold or “blind” curve. Using Equation (10), the specific imbalance correction threshold or “blind” for a wheel assembly having specific dimensions may be automatically calculated, once a specific tire grouping and associated curve has been selected.

A similar analysis for the rotating body 22 couple imbalance force can be made. Where L is the wheel width, the imbalance couple (M) felt by the vehicle can be expressed as:

$$ M = \frac{v}{2\pi D_T} \frac{m D_w}{L} $$

If an acceptable imbalance correction threshold or “blind” for a wheel assembly having a 15.0x6.0 inch wheel rim (D_{rim}=15.0), with a 28.0 inch diameter tire (D_T), installed therein is 0.29 oz. (w_1) then using Equation (11), and equivalent blind (w_2) for an assembly with the dimensions D_{rim}, D_T, and L_1 is:

$$ w_2 = \frac{w_1 D_{rim}}{D_T} \frac{D_T}{L_1} $$

Once an acceptable couple imbalance correction weight threshold or “blind” is established for a particular tire and rim combination, an equivalent couple imbalance correction weight threshold or “blind” may be automatically calculated using Equation (12) for a wide variety of wheel assemblies, providing an couple imbalance correction weight threshold curve, such as shown in FIG. 19 for wheel rim dimensions and FIG. 20 for tire dimensions.

The present invention can be embodied in part in the form of computer-implemented processes and apparatuses for practicing those processes. The present invention can also be embodied in part in the form of computer program code containing instructions embodied in tangible media, such as floppy diskettes, CD-ROMs, hard drives, or an other computer readable storage medium, wherein, when the computer program code is loaded into, and executed by, an electronic device such as a computer, microprocessor or logic circuit, the device becomes an apparatus for practicing the invention.

The present invention can also be embodied in part in the form of computer program code, for example, whether stored in a storage medium, loaded into and/or executed by a computer, or transmitted over some transmission medium, such as by over electrical wiring or cabling, through fiber optics, or via electromagnetic radiation, wherein, when the computer program code is loaded into and executed by a computer, the computer becomes an apparatus for practicing the invention. When implemented in a general-purpose microprocessor, the computer program code segments configure the microprocessor to create specific logic circuits.

In view of the above, it will be seen that the several objects of the invention are achieved and other advantageous results are obtained. As various changes could be made in the above constructions without departing from the scope of the invention, it is intended that all matter contained in the above description or shown in the accompanying drawings shall be interpreted as illustrative and not in a limiting sense.

The invention claimed is:

1. A method for balancing a vehicle wheel assembly, comprising:
   measuring an imbalance parameter associated with the vehicle wheel assembly, said imbalance parameter selected to be representative of one of either a static imbalance condition or a couple imbalance condition;
   calculating imbalance correction weight parameters for at least one imbalance correction weight which will reduce the measured imbalance parameter to a residual imbalance level which is within an acceptable imbalance for said selected imbalance condition;
   calculating a resulting residual imbalance parameter for said vehicle wheel assembly for the other of said static imbalance condition or said couple imbalance condition resulting from placement of said calculated at least one imbalance correction weight on said vehicle wheel assembly;
   comparing said calculated resulting residual imbalance condition with an associated imbalance threshold, said associated imbalance threshold corresponding to more than an amount of imbalance correctable by the placement of a smallest incremental imbalance correction weight; and
responsive to said comparison indicating said calculated resulting residual imbalance condition being less than said associated imbalance threshold, displaying said parameters for placement of said at least one imbalance correction weight on the vehicle wheel assembly;

2. The method of claim 1 wherein said step of calculating imbalance correction weight parameters calculates static imbalance correction weight parameters; and wherein said step of calculating said resulting residual imbalance condition calculates residual couple imbalance parameters.

3. The method of claim 1 wherein said step of calculating imbalance correction weight parameters determines imbalance correction weight parameters to correct a couple imbalance condition in the vehicle wheel assembly; and wherein said step of calculating said resulting residual imbalance condition calculates residual static imbalance parameters.

4. The method of claim 1 wherein said resulting residual imbalance condition and said imbalance threshold are weight amounts.

5. The method of claim 4 wherein said step of calculating a resulting residual imbalance condition determines weight amounts for application at selected reference placement locations on a reference vehicle wheel assembly.

6. The method of claim 4 wherein said step of calculating a resulting residual imbalance condition determines weight amounts scaled to correspond to weight amounts applied at selected reference placement locations on a reference vehicle wheel assembly.

7. The method of claim 1 wherein said resulting residual imbalance condition and said imbalance threshold are forces.

8. A method for operating a vehicle wheel balancing system having at least two modes of operation, including a static single plane mode and a dynamic two plane mode of operation, comprising:
   initially selecting the dynamic two plane mode of operation;
   measuring an imbalance of the wheel assembly;
   determining at least one imbalance correction weight for application to the wheel assembly in the static single plane mode of operation;
   calculating a residual imbalance condition in the wheel assembly for the static single plane mode of operation using said at least one imbalance correction weight;
   evaluating said residual imbalance condition in the dynamic two plane mode of operation; and
   responsive to said evaluation, selecting one of said static or dynamic modes of operation for guiding placement of one or more imbalance correction weights on the vehicle wheel assembly.

9. The method of claim 8 wherein responsive to said evaluation identifying said residual imbalance condition as being less than a threshold imbalance condition, selecting said static single plane mode of operation.

10. The method of claim 8 wherein responsive to said evaluation identifying said residual imbalance condition as being equal to or exceeding a threshold imbalance condition, selecting said dynamic two plane mode of operation.

11. A method for operating a vehicle wheel balancing system having at least two modes of operation, including a static single plane mode and a dynamic two plane mode of operation, comprising:
   selecting the single static plane mode of operation;
   measuring an imbalance of the wheel assembly;
   determining an imbalance correction weight for application to the wheel assembly;

12. The method of claim 11 wherein said step of selecting a mode of operation further includes providing a signal associated with said evaluation to an operator; and wherein said operator selects said mode of operation.

13. The method of claim 11 wherein responsive to said evaluation identifying said residual imbalance condition in said dynamic two plane mode of operation as being below a threshold imbalance condition, displaying said imbalance correction weight and an associated placement location on the wheel assembly.

14. The method of claim 11 wherein, responsive to said evaluation identifying said residual imbalance condition as being equal to, or greater than, a threshold imbalance condition, selecting said dynamic two plane mode of operation; and determining two or more imbalance correction weights for application the wheel assembly.

15. A method for correcting an imbalance condition in a rotating body, comprising:
   measuring an imbalance condition of the rotating body;
   calculating a single imbalance correction weight for application to the rotating body to reduce a static imbalance condition of the rotating body;
   evaluating a dynamic imbalance condition of the rotating body resulting from application of said single imbalance correction weight to the rotating body; and
   responsive to said evaluation, providing an output which is associated with a relationship between said dynamic imbalance condition and a threshold.

16. The method of claim 15 wherein responsive to said evaluation indicating said dynamic imbalance condition has a residual imbalance below said threshold, said output is a display of said single imbalance correction weight and placement location.

17. The method of claim 15 wherein responsive to said evaluation indicating said dynamic imbalance condition has a residual imbalance is equal to, or exceeds, said threshold, said output is an output signal.

18. The method of claim 15 wherein said output signal is provided to an operator.

19. The method of claim 15 wherein, responsive to said evaluation indicating said dynamic imbalance condition has a residual imbalance equal to, or exceeding, said threshold, calculating a plurality of imbalance correction weights for application to the rotating body in at least two separate imbalance correction planes to reduce said dynamic imbalance condition of the rotating body.

20. The method of claim 1 further including the step of responding to said comparison indicating said calculated resulting residual imbalance equals or exceeds said associated imbalance threshold by calculating imbalance correction weight parameters for at least one imbalance correction weight which will reduce the residual imbalance to a residual imbalance level which is within an acceptable imbalance for the other of said static imbalance condition or said couple imbalance condition.