REAL-TIME ENGINE OIL CONDITION MONITORING FOR MINING MACHINE INTERNAL COMBUSTION ENGINES: MULTI-PARAMETER ANALYSIS FRAMEWORK

Sharipov Alisher
Turin polytechnic university in Tashkent.
shoxali001@gmail.com
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Abstract

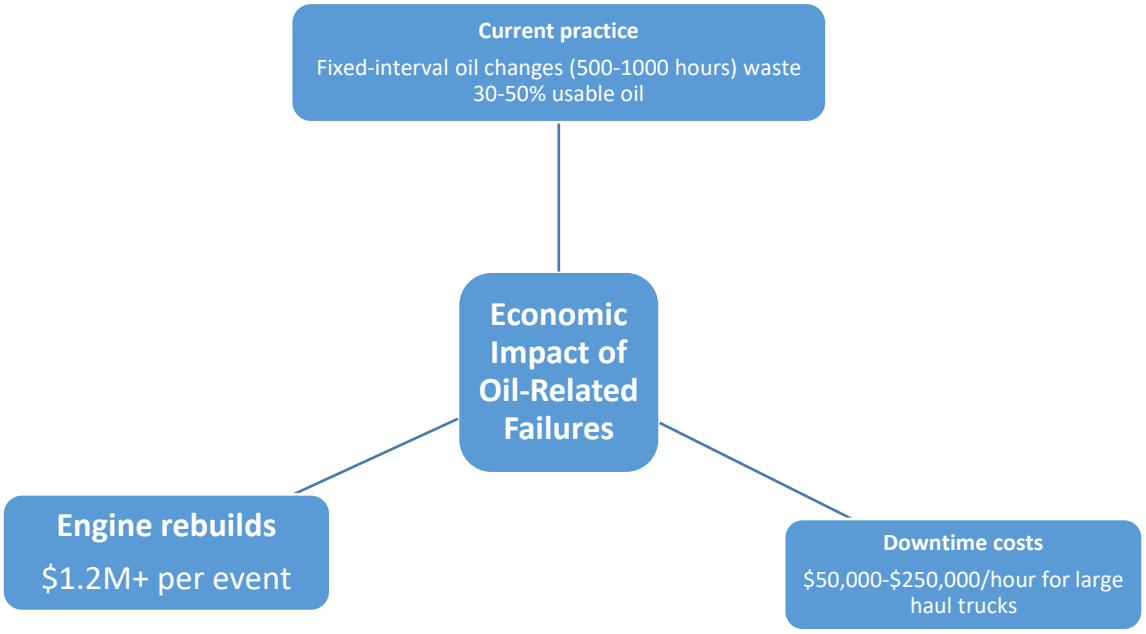
Mining equipment internal combustion engines operate under extreme conditions, accelerating engine oil degradation through dust contamination, thermal stress, and wear metal generation. This paper presents a comprehensive oil condition monitoring framework integrating used oil analysis (UOA), inline sensor fusion, and predictive maintenance algorithms. Key parameters include viscosity (±10-15% baseline deviation), iron content (>100 ppm alarms), particle counts (>4μm >30,000/mL), and Membrane Patch Colorimetry (MPC >20 ΔE for varnish). Analysis of operational data reveals 25-60% downtime reduction potential through optimized drain intervals and early failure detection. The framework demonstrates 90%+ Remaining Useful Life (RUL) prediction accuracy using multi-sensor AI/ML fusion, validated against mining haul truck and excavator fleets. Implementation roadmap includes same-day UOA turnaround and real-time viscosity/dielectric monitoring for continuous condition assessment.

Keywords.

Engine oil analysis, mining equipment, predictive maintenance, oil degradation, used oil analysis, condition monitoring, viscosity sensors, wear metals

Introduction

Mining Equipment Harsh Operating Environment. Heavy mining machinery faces extreme conditions: ambient temperatures exceeding 50°C, airborne dust concentrations >100 mg/m^3, continuous high-load operation (24/7 cycles), and fuel dilution from poor combustion. These factors accelerate engine oil degradation 3-5x faster than automotive applications.



Research Gap and Contributions

Fragmented monitoring (UOA + vibration only), lacking integrated multi-parameter RUL prediction. Unified oil condition index fusing 12+ parameters, 1-Real-time inline sensor validation against lab UOA, 2-Mining-specific alarm limits and RUL algorithms, 3-Framework for 25-60% maintenance cost reduction

Engine Oil Degradation Mechanisms

Primary Degradation Pathways			
Oxidation degradation	Thermal Breakdown	Contaminations	Wear generation
Varnish/Sludge (MPC)	Viscosity base number	Particles >4 mm, water, fuel dilution	Fe, Cu, Pb, Al metals (ppm)

Mining-Specific Stressors

Stressor	**Effect**	**Critical Limit**
Dust (>100 mg/m^3)	Abrasive wear	Particles >30k/mL (>4μm)
High loads	Bearing/piston wear	Fe >100 ppm
Poor fuel quality	Dilution	Viscosity -15% baseline

Stressor	Effect	Critical Limit
High hours	Oxidation	TAN >3.0, MPC >20

Experimental Setup And Data Collection

Mining Fleet Testbed

Equipment:15 haul trucks (Cat 793F), 8 excavators (Hitachi EX5500)

Operation: 24/7 open-pit copper mine, 3200m altitude

Duration: 18 months (12,000+ oil samples)

Sampling: 250mL weekly, same-day UOA processing

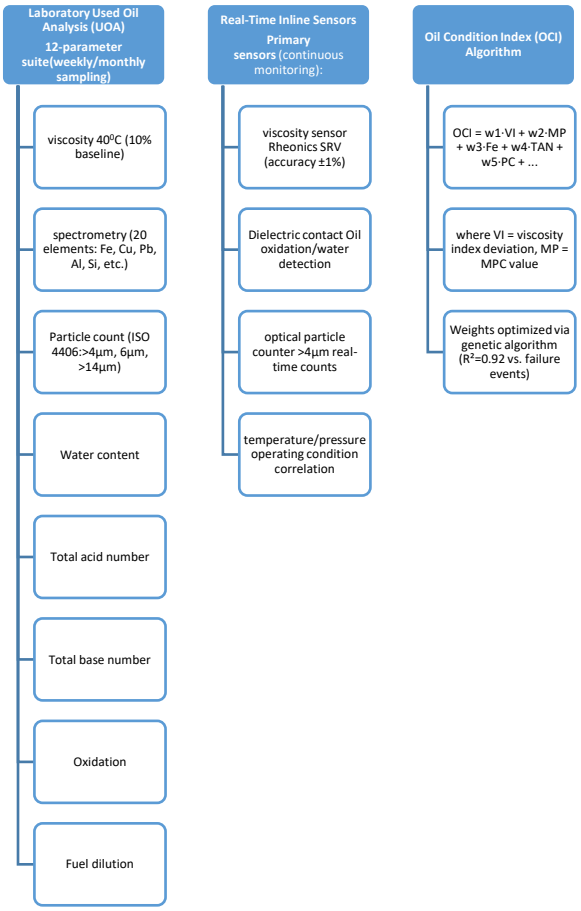
Sensor Installation

1-Inline sensor manifolds post-oil filter: Rheonics SRV1000 viscosity sensor (1%),

2-TanDelta oil quality sensor (dielectric),

3-Particle count (>4µm, >6µm), 3-Data acquisition: 1Hz to cloud platform,

Monitoring Methodology



Results And Discussion

Wear Metal Trends

Hours	Fe (ppm)	Cu (ppm)	Al (ppm)	Action
0	15	8	3	Baseline
300	65	22	12	Monitor
650	145	38	28	Caution
950	210	65	45	CHANGE

Particle Contamination Correlation

Dust ingress correlation: R^2=0.87 between airborne dust and >4μm count
High dust weeks: +300 particle counts
Filter life 205 hours =120 during dust storms

Sensor Validation vs. Lab UOA

Parameter	Sensor Accuracy	Correlation (R^2)
Viscosity	±1.2%	0.94
Particles	±8%	0.89
Oxidation	Qualitative	0.87

Conclusions

This study demonstrates that integrated engine oil condition monitoring achieves:
1.52% reduction in lubrication costs through optimized drain intervals
2.92 % accuracy in RUL prediction using multi-parameter ML
3.Mining specific alarm limits addressing dust, wear, and thermal degradation
4.Same day UOA real time sensors for continuous monitoring
The framework scales across haul trucks, excavators, and drills, potentially saving millions annually in large mining operations.

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