

ISO 10439-1:2015-02 (E)

Petroleum, petrochemical and natural gas industries - Axial and centrifugal compressors and expander-compressors - Part 1: General requirements

Contents		Page
Foreword		vi
Introduction		vii
1	Scope	1
2	Normative references	1
3	Terms, abbreviated terms and definitions	2
3.1	Terms and definitions	2
3.2	Abbreviated terms	9
4	General	11
4.1	Dimensions and units	11
4.2	Statutory requirements	11
4.3	Unit responsibility	11
4.4	Basic design	11
4.4.1	General	11
4.4.2	Speed requirements	13
4.5	Materials	14
4.5.1	General	14
4.5.2	Castings	17
4.5.3	Forgings	18
4.5.4	Welding	19
4.6	Casings	19
4.6.1	Pressure-containing casings	19
4.6.2	Casing repairs and inspections	21
4.6.3	Material inspection of pressure-containing parts	22
4.6.4	Pressure casing connections	24
4.6.5	Casing support structures	26
4.6.6	External forces and moments	27
4.6.7	Guide vanes, stators, and stationary internals	27
4.7	Rotating elements	27
4.8	Dynamics	29
4.8.1	General	29
4.8.2	Lateral analysis	30
4.8.3	Unbalanced rotor response verification test	37
4.8.4	Additional testing	38
4.8.5	Level 1 stability analysis	39
4.8.6	Level II stability analysis	41
4.8.7	Torsional analysis	42
4.8.8	Vibration and balancing	44
4.9	Bearings and bearing housings	48
4.9.1	General	48
4.9.2	Hydrodynamic radial bearings	48
4.9.3	Hydrodynamic thrust bearings	48
4.9.4	Bearing housings	49
4.10	Shaft and seals	49
4.10.1	General	49
4.10.2	Clearance seals	50
4.10.3	Oil seals	51

4.10.4	Self-acting dry gas seal	51
4.11	Integral gearing	53
4.12	Nameplates and rotation arrows	53
5	Accessories	53
5.1	Drivers and gearing	53
5.2	Couplings and guards	54
5.3	Lubrication and sealing systems	54
5.4	Mounting plates	55
5.4.1	General	55
5.4.2	Baseplates	58
5.4.3	Soleplates and sub-soleplates	60
5.5	Controls and instrumentation	61
5.5.1	General	61
5.5.2	Control systems	61
5.5.3	Instrument and control panels	62
5.5.4	Instrumentation	62
5.5.5	Alarms, shutdowns, and control systems	62
5.5.6	Electrical systems	62
5.5.7	Vibration, position, and bearing temperature detectors	62
5.6	Piping and appurtenances	62
5.6.1	General	62
5.6.2	Instrument piping	63
5.6.3	Process piping	63
5.7	Special tools	63
6	Inspection, testing, and preparation for shipment	63
6.1	General	63
6.2	Inspection	64
6.2.1	General	64
6.2.2	Material inspection	65
6.3	Testing	66
6.3.1	General	66
6.3.2	Hydrostatic test	66
6.3.3	Overspeed test	66
6.3.4	Dry gas seals	66
6.3.5	Mechanical running test	66
6.3.6	Assembled machine gas leakage test	68
6.3.7	Optional tests	68
6.4	Preparation for shipment	69
7	Supplier's data	71
7.1	General	71
7.2	Proposals	72
7.2.1	General	72
7.2.2	Drawings	73
7.2.3	Technical data	73
7.2.4	Curves	74
7.2.5	Optional tests	75
7.3	Contract data	75
7.3.1	General	75
7.3.2	Curves and datasheets	75
7.3.3	Progress reports	76
7.3.4	Parts lists and recommended spares	76
7.3.5	Installation, operation, maintenance, and technical data manuals	76
	Annex A (normative) Procedure for the determination of residual unbalance	78
	Annex B (informative) Typical shaft end seals	88
	Annex C (normative) Requirements for lateral analysis reports	97

Annex D (normative) Requirements for torsional analysis reports	105
Annex E (normative) Magnetic bearings	109
Annex F (normative) Dry gas seal testing at manufacturer's shop	124
Annex G (informative) Guidelines for anti-surge systems	126
Annex H (informative) Typical bid tab template	127
Bibliography	128