

	TECHNICAL SPECIFICATION		No. I-ET-3010.00-5134-321-P4X-001							
	CLIENT:							SHEET: 1 OF 21		
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	AREA:									
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	REV. 0	REV. A	REV. B	REV. C	REV. D	REV. E	REV. F	REV. G	REV. H	
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	TECHNICAL SPECIFICATION	No. I-ET-3010.00-5134-321-P4X-001	REV. 0
			SHEET 2 OF 21
	TITLE: INSTRUMENT/SERVICE AIR CENTRIFUGAL COMPRESSOR UNITS		INTERNAL

SUMMARY

1. OBJECTIVE	3
2. DEFINITIONS AND ABBREVIATIONS.....	3
3. NORMATIVE REFERENCES.....	3
4. DESIGN AND GENERAL REQUIREMENTS.....	6
5. PACKAGE SPECIFICATION	7
6. NAMEPLATES	13
7. TAG NUMBERING.....	14
8. SPARE PARTS AND SPECIAL TOOLS.....	14
9. INSPECTION, TESTING AND COMMISSIONING	14
10. PACKAGER/MANUFACTURER'S RESPONSIBILITY	15
11. PREPARATION FOR SHIPMENT	15
12. DOCUMENTATION REQUIREMENTS	16
ANNEX A	21

	TECHNICAL SPECIFICATION	No. I-ET-3010.00-5134-321-P4X-001	REV. 0
			SHEET 3 OF 21
	TITLE: INSTRUMENT/SERVICE AIR CENTRIFUGAL COMPRESSOR UNITS		INTERNAL ESUP

1. OBJECTIVE

- 1.1 This specification covers the minimum requirements for design, engineering, materials, fabrication, inspection, testing, pre-commissioning and commissioning of INSTRUMENT/SERVICE CENTRIFUGAL AIR COMPRESSOR UNITS.
- 1.2 The PACKAGE is composed by the units defined in INSTRUMENT/SERVICE AIR COMPRESSION UNIT DATASHEET and this technical specification.

2. DEFINITIONS AND ABBREVIATIONS

2.1 DEFINITIONS

All terms and definitions are established in the latest revision of I-ET-3010.00-1200-940-P4X-002 – General Technical Terms.

2.2 ABBREVIATIONS:

CLASS	- Classification Society
DAM	- Data Acquisition Module
FAT	- Factory Acceptance Test
HMI	- Human Machine Interface
MMS	- Machinery Monitoring System
MPS	- Machinery Protection System
NDT	- Non-Destructive Tests
UCP	- Unit Control Panel

3. NORMATIVE REFERENCES

All INSTRUMENT/SERVICE CENTRIFUGAL AIR COMPRESSOR UNITS shall comply with the requirements of this technical specification, data sheets, documents, codes and standards as stated below.

3.1 CLASSIFICATION

PACKAGER/MANUFACTURER shall perform the work in accordance with the requirements of Classification Society. PACKAGER/MANUFACTURER is responsible for submitting to the Classification Society all documentation in compliance with stated Rules.

3.2 APPLICABLE CODES, STANDARDS AND GOVERNMENTAL REGULATIONS

The following codes and standards shall be fully complied with:


AISC


AISC 335-89 Specification for Structural Steel Buildings Allowable Stress Design and Plastic Design

API

API-RP-2A Planning, Designing, And Constructing Fixed Offshore Platforms - Working Stress Design

API 672 Packaged, Integrally Geared Centrifugal Air Compressors for Petroleum, Chemical, and Gas Industry Services

	TECHNICAL SPECIFICATION	No. I-ET-3010.00-5134-321-P4X-001	REV. 0
			SHEET 4 OF 21
	TITLE: INSTRUMENT/SERVICE AIR CENTRIFUGAL COMPRESSOR UNITS		INTERNAL
		ESUP	
<p>API 677 General-Purpose Gear Units for Petroleum, Chemical and Gas Industry Services</p> <p>ASME</p> <p>ASME BPVC Sec VIII Div 1 Rules for Construction of Pressure Vessels ASME BPVC Sec IX Welding and Brazing Qualifications ASME B31.3 Process Piping ASME B16.5 Pipe Flanges and Flanged Fittings</p> <p>AWS</p> <p>AWS D1.1 Structural Welding Code – Steel</p> <p>IEC</p> <p>IEC 60034 Rotating Electrical Machines IEC 61892 Mobile and Fixed Offshore Units – Electrical Installations – All parts IEC 60092-502 Electrical Installation in Ships – Tankers – Special Features</p> <p>IOGP</p> <p>IOGP S-612 Supplementary Specification to API Standard 672 – Packaged, Integrally Geared Centrifugal Air Compressors IOGP S-612L Information Requirements for Packaged, Integrally Geared Centrifugal Air Compressors (API) IOGP S-612Q Quality Requirements for Packaged, Integrally Geared Centrifugal Air Compressors (API) IOGP S-612D Procurement Data Sheet for Packaged, Integrally Geared Centrifugal Air Compressors (API)</p> <p>ISO</p> <p>ISO 8573 Compressed Air: Part 1 Contaminants and Purity Classes ISO 14691 Petroleum, petrochemical and natural gas industries - Flexible couplings for mechanical power transmission - General-purpose applications</p> <p>TEMA</p> <p>TEMA Standards of the Tubular Exchanger Manufacturers Association</p> <p>3.3 BRAZILIAN REGULATIONS</p> <p>NR 10 Segurança em Instalações e Serviços em Eletricidade (Safety in Electrical Facilities and Services) NR-12 Segurança no Trabalho em Máquinas e Equipamentos (Safety on Labour in Machines and Equipment). NR 13 Caldeiras, Vasos de Pressão, Tubulações e Tanques Metálicos de Armazenamento (Boilers, Pressure Vessels, Piping and Metallic Storage Tanks) NR 26 Sinalização de Segurança (Safety Signaling) NR 37 Segurança e Saúde em Plataformas de Petróleo (Safety and Health in Petroleum Platforms)</p> <p>3.3.1. Brazilian Government regulations are mandatory and shall prevail over the requirements of this specification and other references herein.</p> <p>3.3.2. PACKAGER/MANUFACTURER shall comply with any other government regulations stated in the Contract and not listed above.</p> <p>3.4 APPLICABLE DOCUMENTS</p> <p>The following design documents shall be fully complied with:</p> <p>3.4.1. TYPICAL DOCUMENTS</p>			

	TECHNICAL SPECIFICATION	No. I-ET-3010.00-5134-321-P4X-001	REV. 0
			SHEET 5 OF 21
	TITLE: INSTRUMENT/SERVICE AIR CENTRIFUGAL COMPRESSOR UNITS		INTERNAL
		ESUP	

General

I-ET-3000.00-0000-940-P4X-002	Symbols for Production Units Design
I-ET-3000.00-1200-940-P4X-001	Tagging Procedure for Production Units Design
I-ET-3010.00-1200-940-P4X-002	General Technical Terms
I-ET-3010.00-1350-940-P4X-001	Systems Operation Philosophy
I-ET-3010.00-5400-947-P4X-002	Safety Signalling

Mechanical

I-ET-3010.00-1200-200-P4X-115	Requirements for Piping Fabrication Assembly and Commissioning
I-ET-3010.00-1200-251-P4X-001	Requirements for Bolting Material
I-ET-3010.00-1200-300-P4X-001	Noise and Vibration Control Requirements
I-ET-3010.00-1200-431-P4X-001	Thermal Insulation for Maritime Installations
I-ET-3010.00-1200-451-P4X-001	Requirements for Shell and Tube Heat Exchanger Design and Fabrication
I-ET-3010.00-1200-955-P4X-001	Welding
I-ET-3010.00-1200-956-P4X-002	General Painting
I-ET-3010.00-1200-956-P4X-001	Qualification Tests for Paint Systems
I-ET-3010.00-1200-540-P4X-001	Requirements for Pressure Vessels Design and Fabrication
DR-ENGP-I-1.15	Color Coding

Electrical

I-DE-3010.00-5140-700-P4X-003	Grounding Installation Typical Details
I-DE-3010.00-5140-797-P4X-001	Electrical System Automation Architecture Diagram
I-DE-3010.00-5140-797-P4X-002	Electrical System Automation Typical Actuation Diagrams
I-ET-3010.00-5140-700-P4X-001	Specification for Electrical Design for Offshore Units
I-ET-3010.00-5140-700-P4X-002	Specification for Electrical Material for Offshore Units
I-ET-3010.00-5140-700-P4X-003	Electrical Requirements for Packages for Offshore Units
I-ET-3010.00-5140-700-P4X-005	Requirements for Human Engineering Design for Electrical Systems of Offshore Units
I-ET-3010.00-5140-700-P4X-007	Specification for Generic Electrical Equipment for Offshore Units
I-ET-3010.00-5140-700-P4X-009	General Requirements for Electrical Material and Equipment for Offshore Units
I-ET-3010.00-5140-712-P4X-001	Low-Voltage Induction Motors for Offshore Units
I-ET-3010.00-5140-712-P4X-002	Medium-Voltage Induction Motors for Offshore Units
I-ET-3010.00-5140-741-P4X-004	Specification for Low-Voltage Generic Electrical Panels for Offshore Units
I-ET-3010.00-5140-797-P4X-001	Electrical System Automation Architecture
I-LI-3010.00-5140-700-P4X-001	Electrical Equipment Data-Sheet Models
I-LI-3010.00-5140-797-P4X-001	Electrical System Automation Interface Signals List

Instrumentation and Automation

I-ET-3010.00-1200-800-P4X-002	Automation, Control and Instrumentation on Package Units
I-ET-3010.00-5500-854-P4X-001	Machinery Monitoring System (MMS)
I-ET-3010.00-5520-888-P4X-001	Automation Panels

Naval


I-ET-3010.00-1350-960-P4X-001	Design Requirements – Naval Architecture
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3.4.2. SPECIFIC PROJECT DOCUMENTS

This section specifies documents that are referenced along the text and are part of a specific project. For that reason, the document's identification number is not yet defined and may vary according to project. The document title may also vary slightly from one project to another. Project's DOCUMENT LIST shall be consulted in order to verify the correct document number and title.

General

GENERAL ARRANGEMENT

	TECHNICAL SPECIFICATION	No. I-ET-3010.00-5134-321-P4X-001	REV. 0
			SHEET 6 OF 21
	TITLE: INSTRUMENT/SERVICE AIR CENTRIFUGAL COMPRESSOR UNITS		INTERNAL ESUP

AREA CLASSIFICATION – GENERAL
METOCEAN DATA

Mechanical

PIPING SPECIFICATION FOR TOPSIDE
HULL/ACCOMMODATION MECHANICAL HANDLING PROCEDURES
TOPSIDES STRUCTURAL REQUIREMENTS
MATERIAL SELECTION PHILOSOPHY FOR DETAILED DESIGN

Process

INSTRUMENT/SERVICE AIR COMPRESSION UNIT (Datasheet)
INSTRUMENT/SERVICE AIR SYSTEM (P&ID)
GENERAL SPECIFICATION FOR AVAILABLE UTILITIES

Instrumentation and Automation

AUTOMATION INTERFACE OF PACKAGE UNITS

Naval

MOTION ANALYSIS

3.5 CONFLICTING REQUIREMENTS

Any conflict between the requirements of this specification and related codes and standards, specification, etc. shall be presented in writing for OWNER's resolution prior to manufacturing.

4. DESIGN AND GENERAL REQUIREMENTS

4.1 DESIGN LIFE

- 4.1.1. Equipment shall be designed for a 30-year life in a corrosive offshore environment without the need for replacement of any major component due to wear, corrosion, fatigue, or material failure.
- 4.1.2. All equipment and components shall be manufactured up to two years before the delivery date at most.

4.2 DESIGN CONDITIONS


PACKAGER/MANUFACTURER shall design the equipment for the full range of operational conditions as specified in the INSTRUMENT/SERVICE AIR COMPRESSION UNIT DATASHEET and INSTRUMENT / SERVICE AIR SYSTEM P&ID.

4.3 EQUIPMENT LOCATION

The INSTRUMENT/SERVICE CENTRIFUGAL AIR COMPRESSOR UNIT will be installed on the location defined in GENERAL ARRANGEMENT drawing of the UNIT.

4.4 SAFETY REQUIREMENTS

- 4.4.1. Personnel safety protection shall be provided according to Regulatory Standards (NR).
- 4.4.2. Warning signs in Brazilian Portuguese language shall be provided where risk of personnel injury exist.
- 4.4.3. Rotating equipment outer parts, such as pulleys, couplings, belts and flywheels, shall have rigid protection and shall be capable of being easily removed.

	TECHNICAL SPECIFICATION	No. I-ET-3010.00-5134-321-P4X-001	REV. 0
			SHEET 7 OF 21
	TITLE: INSTRUMENT/SERVICE AIR CENTRIFUGAL COMPRESSOR UNITS		INTERNAL
		ESUP	

- 4.4.4. Safety signalling shall be in full compliance with I-ET-3010.00-5400-947-P4X-002 Safety Signalling specification.
- 4.4.5. For area classification, refer to the drawing AREA CLASSIFICATION – GENERAL.
- 4.4.6. Double block & bleed arrangements are required for isolation of equipment in piping classes of 300# and above.

4.5 NOISE AND VIBRATIONS

Noise and vibration control concerning human exposure shall be performed according to I-ET-3010.00-1200-300-P4X-001 – Noise and Vibration Control Requirements.

4.6 ENVIRONMENTAL CONDITIONS

The equipment supplied shall be suitable for the environment and range of ambient conditions defined in the document METOCEAN DATA and also the range of ambient conditions at the construction yard.


4.7 MOTIONS AND ACCELERATION

- 4.7.1. PACKAGE shall be able to withstand and operate in accordance with I-ET-3010.00-1350-960-P4X-001 - DESIGN REQUIREMENTS – NAVAL ARCHITECTURE.
- 4.7.2. For design data on motion requirements, refer to MOTION ANALYSIS report.
- 4.7.3. The equipment shall withstand inertial forces during transportation from construction site to operation site (onshore or offshore).
- 4.7.4. For the Hull loading conditions details and the maximum designed operational trim and heel inclinations refer to I-ET-3010.00-1350-960-P4X-001 - DESIGN REQUIREMENTS - NAVAL ARCHITECTURE.

5. PACKAGE SPECIFICATION

5.1 GENERAL

- 5.1.1. Routine maintenance and removal of components and subassemblies requiring periodic replacement or overhaul shall be achieved without dismantling adjacent equipment.
- 5.1.2. INSTRUMENT/SERVICE CENTRIFUGAL AIR COMPRESSOR UNITS process is described in the INSTRUMENT/SERVICE AIR COMPRESSION UNIT DATASHEET and INSTRUMENT / SERVICE AIR SYSTEM P&ID.
- 5.1.3. The utility requirements and consumption of the equipment shall be clearly defined by PACKAGER in the technical proposal and detailed design. The consumption of utilities shall comply with the requirements of GENERAL SPECIFICATION FOR AVAILABLE UTILITIES.
- 5.1.4. The PACKAGE, including all auxiliary equipment, shall be assembled, aligned and pre-checked in PACKAGER’s shop, allowing shipment to the shipyard with minimal fieldwork.
- 5.1.5. The PACKAGE shall be manufactured, inspected, and verified to comply with all specifications mentioned in NORMATIVE REFERENCES section and the Classification Society regulations.
- 5.1.6. For foreign made equipment, the standard manufacturing parts (couplings, mechanical type seals, bearings) shall be purchased from MANUFACTURERS with representative branches located in Brazil, with service parts and maintenance workshops.

	TECHNICAL SPECIFICATION	No. I-ET-3010.00-5134-321-P4X-001	REV. 0
			SHEET 8 OF 21
	TITLE: INSTRUMENT/SERVICE AIR CENTRIFUGAL COMPRESSOR UNITS		INTERNAL
		ESUP	

5.1.7. Thermal insulation for personnel protection shall be according to I-ET-3010.00-1200-431-P4X-001 - Thermal Insulation for Maritime Installations.

5.1.8. For all intents and purposes, international system units (SI units) shall be used.

5.2 AIR COMPRESSOR

5.2.1. INSTRUMENT/SERVICE CENTRIFUGAL AIR COMPRESSOR UNIT type shall be integrally-gearred centrifugal compressor and comply with the requirements of IOGP S-612 (including supporting procurement data sheet, information requirement specification and quality requirements specification) and API 672.

5.2.2. The INSTRUMENT/SERVICE CENTRIFUGAL AIR COMPRESSOR UNIT shall be provided with a load control system using inlet guide vanes. Minimum turndown ratio shall be 25%.

5.2.3. INSTRUMENT/SERVICE CENTRIFUGAL AIR COMPRESSOR UNIT shall be supplied on a baseplate with all required components, such as coupling, coupling guard, intercoolers, moisture separators, drain system, aftercooler, lubrication oil system, unit control panel, driver (electric motor), inlet air filter, piping, discharge blowoff valve, discharge blowoff silencer, discharge check valve and accessories required in API 672, in a noise reducing enclosure.

5.2.4. Shaft sleeves shall be provided under all shaft sealing areas. Major parts of rotating elements shall be dynamically balanced, individually. Each rotor shall be dynamically balanced in an assembled condition.

5.2.5. Rotors shall be designed with the first lateral critical speed at least 20 percent above the maximum operating speed.

5.2.6. Couplings of compressor drive train (compressor, motor and gearbox) shall be non-lubricated and designed to reduce torque peaks. Guards shall be manufactured from a non-sparking material.

5.2.7. Cooling System

5.2.7.1. Air compressors shall be fresh water cooled.

5.2.7.2. Machine mounted coolers are not acceptable.

5.2.8. The air intake filter shall be designed for 110% of the rated air flow.

5.2.9. Threaded connections shall not be used on equipment casing.

5.2.10. Dual oil coolers shall be provided, one in operation and another in standby.


5.2.11. Automatic drain traps with manual bypass shall be provided. Drain trap system shall also contain drain collectors with high level alarm.

5.2.12. Main lube oil pump shall be shaft driven and auxiliary lube oil pump shall be electric motor driven.

5.2.13. An oil bypass line around the oil cooler with a temperature-control valve shall be included to regulate the oil-supply temperature.

5.3 PIPING

5.3.1. All piping shall be designed, fabricated, and inspected in accordance with ASME B31.3 and PIPING SPECIFICATION FOR TOPSIDE. Threaded connections shall not be used.

	TECHNICAL SPECIFICATION	No. I-ET-3010.00-5134-321-P4X-001	REV. 0
			SHEET 9 OF 21
	TITLE: INSTRUMENT/SERVICE AIR CENTRIFUGAL COMPRESSOR UNITS		INTERNAL ESUP

- 5.3.2. All connections shall be located at baseplate edge and provided with flanged connections, according to ASME B16.5 and PIPING SPECIFICATION FOR TOPSIDE. Locations, size and rating of all connections shall be clearly defined by PACKAGER/MANUFACTURER.
- 5.3.3. All auxiliary piping shall terminate with block valves at the edge of the baseplate and shall be designed to allow easy disconnection of pipework. Drains and vents shall be flanged with valves.
- 5.3.4. After completion of fabrication, all fabricated pipe spools shall be internally and externally cleaned to remove all loose scale, weld spatter, sand, and other foreign materials.
- 5.3.5. PACKAGER shall check and approve all piping with respect to stresses, vibration and layout. Piping support shall be provided at baseplate edge.
- 5.3.6. Spectacle blinds shall be supplied and assembled for maintenance and testing.
- 5.3.7. Blow-off valve outlets shall be routed outside the PACKAGE hood.

5.4 MATERIAL SELECTION AND CERTIFICATION


- 5.4.1. The SELLER is responsible for the materials selection considering the philosophy detailed at MATERIAL SELECTION PHILOSOPHY FOR DETAILED DESIGN, and the operational condition and process data stated at INSTRUMENT/SERVICE AIR COMPRESSION UNIT data sheet.
- 5.4.2. In all cases, SELLER shall submit the detailed material selection report, including all piping, equipment and their components, for BUYER approval prior to manufacturing activities.
- 5.4.3. SELLER shall be responsible for obtaining all necessary certification of the equipment, work and materials.
- 5.4.4. SELLER through the independent certifying authority shall supply all certificates related to the materials, inspections, tests and qualification activities detailed in the approved Quality Plan.
- 5.4.5. Dissimilar materials shall be isolated to avoid galvanic corrosion.

5.5 PRESSURE VESSELS (DESIGN AND FABRICATION)


- 5.5.1. Pressure vessels shall comply with I-ET-3010.00-1200-540-P4X-001 - Requirements for Pressure Vessels Design and Fabrication.
- 5.5.2. For shell and tube heat exchangers, in addition to the previous mentioned technical specification, the equipment shall comply with I-ET-3010.00-1200-451-P4X-001 - Requirements for Shell and Tube Heat Exchanger Design and Fabrication.
- 5.5.3. INSTRUMENT/SERVICE AIR COMPRESSION UNIT INTERCOOLER and INSTRUMENT/SERVICE AIR COMPRESSION UNIT AFTERCOOLER shall follow TEMA standard and shall be considered as pressure vessels.

5.6 INSTRUMENTATION AND CONTROL

- 5.6.1. General
 - 5.6.1.1. INSTRUMENT/SERVICE CENTRIFUGAL AIR COMPRESSOR UNIT is classified according to the specification for AUTOMATION INTERFACE OF PACKAGE UNITS.

	TECHNICAL SPECIFICATION	No. I-ET-3010.00-5134-321-P4X-001	REV. 0
			SHEET 10 OF 21
	TITLE: INSTRUMENT/SERVICE AIR CENTRIFUGAL COMPRESSOR UNITS		INTERNAL
		ESUP	


- 5.6.1.2. The PACKAGE automation, control and instrumentation shall fully comply with I-ET-3010.00-1200-800-P4X-002 – Automation, Control and Instrumentation on Package Units, I-ET-3010.00-1350-940-P4X-001 – Systems Operation Philosophy and AUTOMATION INTERFACE OF PACKAGE UNITS.
- 5.6.1.3. All sensors shall be suitable for prevailing temperatures. When applicable, field amplifiers, transducers, etc., shall be installed as per PACKAGER/MANUFACTURER practices, according to the area classification and to protect them against mechanical damage.
- 5.6.1.4. For control panel specification, refer to the requirements in I-ET-3010.00-5520-888-P4X-001 - Automation Panels.
- 5.6.1.5. PACKAGE unit equipment will be provided with PACKAGER/MANUFACTURER's control system and safeguarding incorporated. PACKAGER/MANUFACTURER shall assume total responsibility for the instrumentation, design, engineering, operational philosophy, and the PLC based control and safeguarding systems. These are part of PACKAGER/MANUFACTURER's scope, unless specified otherwise.
- 5.6.1.6. The INSTRUMENT/SERVICE CENTRIFUGAL AIR COMPRESSOR UNITS shall be provided with all necessary instruments, instrumented valves, equipment and accessories (such as, but not limited to, thermowells, tubing, connections, cables, etc) to operate safely, adequately and without interruption in a tropical marine environment.
- 5.6.2. Automation, Control and Instrumentation System Cabling
- 5.6.2.1. All wiring within the limits of the enclosure shall be clearly marked on the wire and at the terminal.
- 5.6.2.2. All cabling between the driver and the local gauge board shall be furnished. All cables and cable routes shall contain at least 20% of the extra capacity.
- 5.6.3. Alarms and Shutdown
- The minimum alarm and shutdown functions shall be as required on the INSTRUMENT / SERVICE AIR SYSTEM P&ID and matrix of cause and effect.
- 5.6.4. Monitoring Requirements
- 5.6.4.1. The equipment that shall be monitored and the monitoring requirements shall be according to I-ET-3010.00-5500-854-P4X-001 – Machinery Monitoring System (MMS).
- 5.6.4.2. Monitoring sensors for motors shall be in accordance with I-ET-3010.00-5140-712-P4X-002 – Medium-Voltage Induction Motors for Offshore Units.
- 5.6.4.3. All equipment sensors shall be compatible with MPS/DAM, as described in I-ET-3010.00-5500-854-P4X-001 - Machinery Monitoring System (MMS).
- 5.6.4.4. Equipment shall be supplied with all sensors necessary for monitoring installed, configured, and connected to junction box.
- 5.6.4.5. A high frequency accelerometer shall be supplied, installed and calibrated in accordance with API Std 670 on the machined surface of the gear casing.
- 5.6.4.6. A temperature transmitter shall be provided on each inlet of cooling water in the PACKAGE. Temperature values shall be shown on the panel, with alarm indication in case the maximum temperature defined in GENERAL SPECIFICATION FOR AVAILABLE UTILITIES is reached.

	TECHNICAL SPECIFICATION	No. I-ET-3010.00-5134-321-P4X-001	REV. 0
			SHEET 11 OF 21
	TITLE: INSTRUMENT/SERVICE AIR CENTRIFUGAL COMPRESSOR UNITS		INTERNAL ESUP

5.6.4.7. The vibration signals (including displacement and accelerometers) of the whole train shall have an unfiltered output at the UCP (one per channel) for recording and maintenance purposes.

5.7 ELECTRICAL REQUIREMENTS

- 5.7.1. Electrical equipment shall be manufactured and tested in compliance with Classification Society and IEC requirements, unless otherwise stated.
- 5.7.2. Compressor drivers shall be squirrel cage induction electric motor. All drivers shall be supplied and mounted by PACKAGER.
- 5.7.3. All electrical equipment and design shall fully comply with documents I-ET-3010.00-5140-700-P4X-002 - Specification for Electrical Material for Offshore Units, I-ET-3010.00-5140-700-P4X-007 - Specification for Generic Electrical Equipment for Offshore Units, I-ET-3010.00-5140-700-P4X-009 – General Requirements for Electrical Material and Equipment for Offshore Units, I-ET-3010.00-5140-741-P4X-004 - Specification for Low-Voltage Generic Electrical Panels for Offshore Units and I-ET-3010.00-5140-700-P4X-003 - Electrical Requirements for Packages for Offshore Units.
- 5.7.4. Electrical installations and PACKAGE electrical interfaces shall comply with requirements of I-ET-3010.00-5140-700-P4X-001 - Specification for Electrical Design for Offshore Units, I-ET-3010.00-5140-700-P4X-003 - Electrical Requirements for Packages for Offshore Units, I-ET-3010.00-5140-700-P4X-005 - Requirements for Human Engineering Design for Electrical Systems of Offshore Units and I-LI-3010.00-5140-797-P4X-001 - Electrical System Automation Interface Signals List, I-DE-3010.00-5140-797-P4X-001 - Electrical System Automation Architecture Diagram, I-ET-3010.00-5140-797-P4X-001 -Electrical System Automation Architecture and I-DE-3010.00-5140-797-P4X-002 - Electrical System Automation Typical Actuation Diagrams.
- 5.7.5. Low-voltage auxiliary motors shall comply with requirements of I-ET-3010.00-5140-712-P4X-001 - Low-Voltage Induction Motors for Offshore Units. Medium-voltage motors shall comply with requirements of I-ET-3010.00-5140-712-P4X-002 - Medium-Voltage Induction Motors for Offshore Units.
- 5.7.6. Electrical panel shall comply with requirements of I-ET-3010.00-5140-741-P4X-004 - Specification for Low-Voltage Generic Electrical Panels for Offshore Units, being acceptable fixed (not withdrawable) functional units.
- 5.7.7. It shall be issued datasheets for electrical equipment, according to templates of I-LI-3010.00-5140-700-P4X-001 - Electrical Equipment Data-Sheet Models.
- 5.7.8. All materials and equipment proper to be used in hazardous areas, shall have conformity certificates complying with INMETRO Portaria n° 115, March 21st, 2022 and shall be approved by Classification Society. Electrical equipment installed in external safe areas, that shall be kept operating during emergency shutdown ESD-3P and ESD-3T shall be certified for installation in hazardous areas Zone 2 (EPL Gc) Group IIA temperature T3, unless they are automatically disconnected if there is gas in the equipment area, according to IEC 61892-1.
- 5.7.9. All equipment and materials shall be suitable for service on marine and petrochemical environments, and able to withstand the severe tropical, damp and saline atmospheric local conditions.
- 5.7.10. PACKAGER/MANUFACTURER shall inform all the PACKAGE loads for purpose of external design.
- 5.7.11. If the requirements are not applied to the proposed system, PACKAGER/MANUFACTURER shall indicate the deviations and explain them.

	TECHNICAL SPECIFICATION	No. I-ET-3010.00-5134-321-P4X-001	REV. 0
			SHEET 12 OF 21
	TITLE: INSTRUMENT/SERVICE AIR CENTRIFUGAL COMPRESSOR UNITS		INTERNAL ESUP

5.7.12. Grounding installations inside the PACKAGE shall comply with requirements of I-ET-3010.00-5140-700-P4X-001 – Specification for Electrical Design for Offshore Units and I-DE-3010.00-5140-700-P4X-003 – Grounding Installations Typical Details.

5.8 MAINTENANCE HANDLING

5.8.1. PACKAGER/MANUFACTURER and SUPPLIER shall follow the requirements for maintenance handling on HULL/ACCOMMODATION MECHANICAL HANDLING PROCEDURES.

5.8.2. PACKAGER/MANUFACTURER shall supply spreader bars and specific handling devices for maintenance with the applicable certificates.

5.8.3. Lifting facilities shall permit the equipment to be lifted by crane as a single point lift for transportation and installation. The design and manufacture of the lifting lugs shall be certified. The arrangement of equipment, piping and superstructure shall be such that the center of gravity coincides approximately with the geometrical center of the baseplate.

5.9 BASEPLATE / SUPPORT STRUCTURE

5.9.1. The baseplate shall be designed to accommodate the entire equipment within the scope of supply, with the possible exceptions mentioned on item 5.10 - LAYOUT. The baseplate shall not distort during lifting, operation and shipment and shall withstand the imposed loads due to the vessel motion.

5.9.2. SUPPLIER shall design and detail all structural components, including calculation report and detailing drawings. SUPPLIER shall fabricate and assemble the support structures in accordance with TOPSIDES STRUCTURAL REQUIREMENTS.

5.9.3. Lifting pad eyes shall be designed in accordance with project TOPSIDES STRUCTURAL REQUIREMENTS or Classification Society or Marine Warranty Surveyor Rules, where the most restrictive requirements shall prevail. Any slings, spreaders bars etc, provided by PACKAGER/MANUFACTURER and shall be furnished with applicable certificates.

5.9.4. The baseplate shall resist all sling forces, including both horizontal and vertical components of the applied sling angle (sling angles shall be within between 50 and 90 degrees with the horizontal plane).


5.9.5. The baseplate shall be of the MANUFACTURER's standard design, complete with a drip pan with valved drain connections. One 1½" NPT minimum drain connection shall be provided at the short side of the baseplate where liquid accumulates. Draining points shall be installed on the lowest point of the drip pan according to the operational trim of the UNIT .

5.9.6. The baseplate shall be welded to the supporting structures. The floor shall be made of stiffened plate material with a raised on-slip tread. Welds underneath baseplate beams shall be ground flush. Baseplate shall have 2 diagonally opposed earthing bars.

5.9.7. Welding shall be carried out with procedures and operators qualified in accordance with the ASME BPVC section IX. Welding shall not be performed before qualified welding procedures have been approved. Intermittent fillet welds are not permitted.

5.10 LAYOUT

5.10.1. Package layout and arrangement shall be designed to provide sufficient access for ease of operability and maintenance, and to maximize safety. It is the responsibility of PACKAGER to ensure that the layout of all equipment and components are conducive to efficient and safe operation.

	TECHNICAL SPECIFICATION	No.	I-ET-3010.00-5134-321-P4X-001	REV.	0
				SHEET	13 OF 21
	TITLE: INSTRUMENT/SERVICE AIR CENTRIFUGAL COMPRESSOR UNITS			INTERNAL	
			ESUP		

5.10.2. Packages shall be designed and fabricated such that all equipment and components are located entirely within the baseplate perimeter, including all equipment, piping, valves, electrical, UCP (including HMI), power panels for low-voltage auxiliaries, instrumentation and controls. The projection of such items beyond the perimeter of the baseplate shall be strictly prohibited, unless approved in writing by OWNER.

5.10.3. INSTRUMENT/SERVICE CENTRIFUGAL AIR COMPRESSION UNITS shall be fully operable in their installation location, defined on section 4.3 - EQUIPMENT LOCATION.

5.11 PAINTING

5.11.1. Painting and coating shall be in accordance with I-ET-3010.00-1200-956-P4X-002 – General Painting and DR-ENGP-I-1.15 – Color Coding.

5.11.2. All components shall be delivered fully painted/coated, except on the machined surfaces for alignment shims, which shall be protected with a coating against corrosion.

5.11.3. The performed pre-treatment and complete coating shall be in accordance with the paint manufacturer's data sheets.

6. NAMEPLATES


6.1 The INSTRUMENT/SERVICE CENTRIFUGAL AIR COMPRESSOR UNIT equipment shall have nameplates in Brazilian Portuguese language, made of stainless steel AISI 316L, with 3 mm minimum thickness and fixed by stainless steel (AISI 316L) bolts or fasteners on visible and accessible location. Nameplates shall include at least the following information:

- Petróleo Brasileiro S.A. – PETROBRAS;
- Purchase order number;
- PACKAGER/MANUFACTURER's name;
- Year of build;
- Serial number;
- Main data for design, operation and testing (Power, Discharge Pressure, Discharge Temperature, Rotation, Flow rate in normal reference);
- Maximum Allowable Working Pressure of the casing;
- Module and UNIT identification;
- Driver power rating and speed;
- Maximum continuous speed;
- Equipment TAG;
- Empty Weight;
- Design Code;
- Service.

6.2 For pressure vessels (filters, heat exchangers, moisture separators, among others, as per ASME BPVC Sec VIII definition) the nameplates shall be according to I-ET-3010.00-1200-540-P4X-001 – Requirements for Pressure Vessels Design and Fabrication.

6.3 Valves, instruments and orifices shall have a nameplate with tag number and serial number.

6.4 Auxiliary equipment shall have nameplates in accordance with respective technical specifications defined on section NORMATIVE REFERENCES.

	TECHNICAL SPECIFICATION	No. I-ET-3010.00-5134-321-P4X-001	REV. 0
			SHEET 14 OF 21
	TITLE: INSTRUMENT/SERVICE AIR CENTRIFUGAL COMPRESSOR UNITS		INTERNAL
			ESUP

7. TAG NUMBERING

- 7.1 For tag rules, refer to I-ET-3000.00-1200-940-P4X-001 – TAGGING PROCEDURE FOR PRODUCTION UNITS DESIGN.
- 7.2 Tagging of all instruments, electrical, mechanical and piping items, including valves, shall be carried out by PACKAGER/MANUFACTURER and confirmed by OWNER.
- 7.3 All tag plates shall be made from AISI 316 stainless steel material.


8. SPARE PARTS AND SPECIAL TOOLS

- 8.1 Spare parts recommended by the Classification Society, if applicable, and those required for NR-13 tests shall be provided.
- 8.2 All spare parts and special tools shall be detailed in the packing list and shall be consistent with the list of spare parts or special tools issued for the engineering documentation. These items shall have an item number in the packing list, which shall match the item number fixed on the packing.

9. INSPECTION, TESTING AND COMMISSIONING

9.1 INSPECTION AND TESTING

- 9.1.1. PACKAGER/MANUFACTURER shall perform all required inspection and testing in accordance with the design and test codes mentioned on section NORMATIVE REFERENCES.
- 9.1.2. PACKAGER shall submit the Inspection and Test Plan (ITP) based on the SUPPLIER technical data sheet with witnessed inspections and tests identified.
- 9.1.3. PACKAGER shall ensure that all the witnessed inspection requirements by the Classification Society are fully accommodated, and the due notice requirements are satisfied.
- 9.1.4. Acceptance of shop tests shall not constitute a waiver of requirements to meet the field tests under specified operating conditions, nor shall inspection relieve MANUFACTURER of his responsibilities in any way whatsoever.
- 9.1.5. For all inspections predicted on ITP, a respective inspection report shall be issued and included in Databook.
- 9.1.6. INSTRUMENT/SERVICE CENTRIFUGAL AIR COMPRESSOR performance test and hydrostatic test of vessels classified in NR-13 within the PACKAGE shall be witnessed by OWNER. PACKAGER shall invite CLASS surveyor for the performance test.
- 9.1.7. The following tests shall be included in PACKAGER/MANUFACTURER's scope:
- Hydrotest of all vessels and pipes.
 - Electrical continuity checks on all wiring and earthing.
 - Functional checks on all instruments and valves.
 - Electrical insulation tests.
 - All tests required for electrical equipment in specific electrical technical specifications of section TYPICAL DOCUMENTS.

	TECHNICAL SPECIFICATION	No. I-ET-3010.00-5134-321-P4X-001	REV. 0
			SHEET 15 OF 21
	TITLE: INSTRUMENT/SERVICE AIR CENTRIFUGAL COMPRESSOR UNITS		INTERNAL ESUP

9.2 FACTORY ACCEPTANCE TEST (FAT)

- 9.2.1. MANUFACTURER shall make preliminary test to ensure that all parts of the equipment are operating satisfactory prior to the arrival of the OWNER's representative.
- 9.2.2. PACKAGE shall be tested according to the parameters defined on the INSTRUMENT/SERVICE AIR COMPRESSION UNIT DATASHEET. All units shall be tested in this condition.
- 9.2.3. Compressors shall be tested at the capacity required in INSTRUMENT/SERVICE AIR COMPRESSION UNIT DATASHEET, minimum capacity and at least one intermediate capacity between required and minimum.
- 9.2.4. Acceptance of the FAT will not be considered as the final acceptance test of the PACKAGE.
- 9.2.5. PACKAGER/MANUFACTURER shall measure and record vibration and bearing temperature during FAT. Vibration and bearing temperature measurements shall be included on FAT report.
- 9.2.6. Monitoring systems and sensors of the PACKAGE shall be tested on the FAT.

9.3 COMMISSIONING

PACKAGE shall undergo a Reliability Acceptance Test Criteria (SAT) on site, in accordance with the requirements of Annex A.


10. PACKAGER/MANUFACTURER'S RESPONSIBILITY

- 10.1 Equipment certification and approval as required by the CLASS rules is PACKAGER/MANUFACTURER's responsibility. PACKAGER/MANUFACTURER shall communicate directly with Classification Society and provide all documentation necessary to obtain approvals. OWNER shall be copied on all correspondence between PACKAGER/MANUFACTURER and Classification Society. PACKAGER/MANUFACTURER shall obtain approval for all parts of their work as required by Classification Society before shipment of the equipment to the shipyard.
- 10.2 PACKAGER shall assume full unit responsibility for the complete PACKAGE, including the driver and all auxiliaries.
- 10.3 Compliance by PACKAGER/MANUFACTURER with the provisions of this specification does not relieve the PACKAGER/MANUFACTURER of his responsibility to furnish equipment and accessories of a proper mechanical design suited to meet the specified service conditions.

11. PREPARATION FOR SHIPMENT

11.1 MARKING

- 11.1.1. All items supplied to this specification shall be adequately marked for identification against a certificate or relevant test documentation. Marking shall be such that it will not damage or impair the component.
- 11.1.2. Items that cannot be identified shall be rejected. Rejected items may be re-certified by carrying out all relevant testing, with prior approval of OWNER.
- 11.1.3. PACKAGER shall issue during engineering stage the packing list, which shall contain the item number of each part supplied loose in the PACKAGE.

	TECHNICAL SPECIFICATION	No. I-ET-3010.00-5134-321-P4X-001	REV. 0
			SHEET 16 OF 21
	TITLE: INSTRUMENT/SERVICE AIR CENTRIFUGAL COMPRESSOR UNITS		INTERNAL
			ESUP

11.2 SHIPMENT PACKING

- 11.2.1. Shipment packing preparation of the equipment shall be suitable for 24 months outdoor storage from time of shipment.
- 11.2.2. All open ends of pipes shall be treated and closed off by plastic caps and taped. Small bore threaded connections shall be taped over.
- 11.2.3. Packing shall be in accordance with the requirements of the country to which the equipment is being shipped.
- 11.2.4. All internally unpainted carbon steel pressure vessels and piping shall be protected with corrosion inhibitor prior to shipment. If necessary, PACKAGER/MANUFACTURER shall provide instructions to remove the corrosion inhibitor prior to the commissioning.
- 11.2.5. Equipment and accessories shall be protected from corrosion.
- 11.2.6. Vulnerable instruments shall be removed and separately packed for shipment.
- 11.2.7. Transportation bracing/support should be used where necessary and shall be clearly identified as temporary.
- 11.2.8. All crates and boxes shall contain sufficient moisture absorbing agent to avoid condensation.
- 11.2.9. PACKAGER/MANUFACTURER shall specify any limitations applicable to the transportation and installation phase.
- 11.2.10. The equipment shall be properly cleaned internally and free of all loose foreign materials.

12. DOCUMENTATION REQUIREMENTS


- 12.1 PACKAGER/MANUFACTURER shall supply a certificate of compliance with the rules of Classification Society.
- 12.2 Before any document is issued by PACKAGER/MANUFACTURER, document list shall be issued and approved by OWNER.

Note: This is required in order to guarantee that document number in accordance with N-1710 is correct. If PACKAGER/MANUFACTURER assigns wrong document numbers, document number changing procedure is time consuming, therefore detrimental to the project.

- 12.3 If any other documents are issued at the same time as the document list or even before issuance of document list, these documents will be rejected.
- 12.4 Document list shall be submitted with the source file, otherwise it will be rejected;
- 12.5 Title of all documents to be issued by PACKAGER/MANUFACTURER shall have the following format:
 - First part – tag number;
 - Second part – equipment description;
 - Third part – document description


EXAMPLE: C-UC-5134501A/B - Instrument and Service Centrifugal Air Compressors – General Arrangement Drawing

- 12.6 If PACKAGER/MANUFACTURER issues documents which contain information valid for the whole package, title shall be summarized to the compression unit tag and document purpose.

	TECHNICAL SPECIFICATION	No. I-ET-3010.00-5134-321-P4X-001	REV. 0
			SHEET 17 OF 21
	TITLE: INSTRUMENT/SERVICE AIR CENTRIFUGAL COMPRESSOR UNITS		INTERNAL
		ESUP	

EXAMPLE: UC-5134501A/B – Inspection and Test Plan.


- 12.7 PACKAGER/MANUFACTURER shall provide source files of all required documents, whenever required by OWNER.
- 12.8 The equipment shall be supplied with documentation in English language. Some documents shall be submitted in Portuguese language, in accordance with definition in this technical specification.
- 12.9 The following documents shall be issued within the first two weeks from the beginning of the detailed design stage and approved before manufacturing or procurement starts:
- Piping and Instrument diagram, which shall follow I-ET-3000.00-0000-940-P4X-002 - Symbols for Production Units Design.
 - General arrangement drawing.
 - Weight and center of gravity datasheet.
 - Utility consumption list and heat dissipation.
 - Inspection and test plan (ITP), including auxiliary equipment.
- 12.10 The following documents shall be issued and approved before FAT. If these documents are not approved prior to the FAT, OWNER will not attend the FAT and will not consider it as executed:
- Main equipment datasheet.
 - Performance curve.
 - Hydrostatic test report.
 - Painting and insulation specification.
 - Torsional and lateral analysis report.
 - Noise datasheet.
 - FAT procedure.
- 12.11 The following documents shall be issued and approved before delivery of the PACKAGE. If these documents are not approved prior to the delivery of the PACKAGE, OWNER will not attend to the receiving inspection, and will not consider the receiving of the PACKAGE:
- Nameplate drawing.
 - Noise report.
 - FAT report.
 - Handling drawing for installation.
 - Painting report.
 - Installation manual.
 - Packing list.

	TECHNICAL SPECIFICATION	No. I-ET-3010.00-5134-321-P4X-001	REV. 0
			SHEET 18 OF 21
	TITLE: INSTRUMENT/SERVICE AIR CENTRIFUGAL COMPRESSOR UNITS		INTERNAL
			ESUP

- Electrical motors data-sheets, dimensional drawings and all other documents required in specific technical specifications.
- Certificates of all electrical equipment required to operate in hazardous area.


12.12 All documents on annex "Contract Documents and Engineering Design Data" of API 672 shall be submitted to OWNER for analysis and approval, besides the additional documents below. These documents, besides those mentioned previously in this section, shall be issued and approved before issuance of the Databook, otherwise, OWNER will not accept the Databook:

- Coupling drawing.
- Details drawings of pressure vessels.
- Nameplate drawings.
- List of spare parts for commissioning and start up.
- List of recommended spare parts for two years of operation.
- List and datasheets of instruments and instrumented valves.
- List of set points, alarms and shutdown.
- Cable list.
- Logic diagrams.
- Cause and effect charts.
- Loop diagram.
- Electromechanical panel drawing.
- Memory maps.
- Automation architecture.
- Calculation notes of control valves, PSVs, thermowells and flowmeters.
- I/O List.
- HMI screen layout.
- Calibration certificates of instruments, control valves and PSVs.
- Databook index.
- Fabrication procedures of pressure vessels classified in NR-13.
- NDT procedures of pressure vessels classified in NR-13.
- Calculation reports of pressure vessels.
- Welding, heat treatment and NDT reports, specially for pressure vessels.
- Material certificates of all pressurized components, specially for pressure vessels.


	TECHNICAL SPECIFICATION	No. I-ET-3010.00-5134-321-P4X-001	REV. 0
			SHEET 19 OF 21
	TITLE: INSTRUMENT/SERVICE AIR CENTRIFUGAL COMPRESSOR UNITS		INTERNAL
		ESUP	

- Hydrotest procedures and reports of piping and pressure vessels. For pressure vessels classified in NR-13, hydrotest reports shall contain the Qualified Professional signature, as per NR-13 requirement.

- 12.13 All documents to be issued for auxiliary and main motors during Detailed Design shall be according to I-ET-3010.00-5140-712-P4X-001 - Low-Voltage Induction Motors for Offshore Units and I-ET-3010.00-5140-712-P4X-002 - Medium-Voltage Induction Motors for Offshore Units.
- 12.14 Required documents to be issued for power panels shall comply with I-ET-3010.00-5140-741-P4X-004 – Specification for Low-Voltage Generic Panels for Offshore Units.
- 12.15 Datasheets and outline drawings shall be submitted not only for the main equipment, i.e., the compressors, but also for the auxiliary equipment. PACKAGER/MANUFACTURER may include data in the outline drawing of each auxiliary equipment rather than issuing a separate datasheet for the auxiliary equipment, under approval of OWNER.
- 12.16 PACKAGER/MANUFACTURER shall include manual of auxiliary equipment in the Databook.
- 12.17 All inspections, NDTs and tests predicted by PACKAGER in the Inspection and Test Plan shall have a report, which shall be included in the Databook.
- 12.18 Progress reports shall be issued periodically, in accordance with total duration of the fabrication time (e.g., every two weeks or every month).
- 12.19 PACKAGER/MANUFACTURER operation and maintenance manual shall contain the specification of lubricant fluids, besides periodicity to replace it. A lubricant schedule may be issued separately.
- 12.20 PACKAGER shall provide a schedule stating the expected time between major overhauls. This schedule can be included in the maintenance manual or issued as a separate document.
- 12.21 Installation manual shall contain all recommendations for preservation during storage on erection stage and long-term storage. If PACKAGER/MANUFACTURER fails to provide this information on the installation manual, any damages due to the lack of preservation will be PACKAGER/MANUFACTURER's responsibility.
- 12.22 Installation manual shall also contain all consumables to be used for erection, commissioning and start up, preferably in a summarized list.
- 12.23 PACKAGER/MANUFACTURER shall provide original documents in PDF format for all required documents. Extracted figures from catalogue or manual, especially for the outline drawings of components such as couplings, mechanical seals and auxiliary equipment, will not be accepted.
- 12.24 General arrangement drawings shall contain the connection list, i.e., a list with all connection tie in points of the baseplate, which shall have the following minimum information: Connection identification number (which shall be indicated in the drawing), connection description, connection specification (design code), rating, flange face type, connection nominal diameter and fluid.
- 12.25 Operation manual shall contain, among other information, the control system description of the PACKAGE.
- 12.26 Each material certificate and NDT report provided shall be preceded by a PACKAGER/MANUFACTURER sheet, informing to which part of the equipment the document refers.
- 12.27 PACKAGER/MANUFACTURER is required to indicate on the general arrangement drawing the distance required for removal of all internal parts, which shall be disassembled periodically for maintenance, in accordance with recommendations on the maintenance manual.

	TECHNICAL SPECIFICATION	No. I-ET-3010.00-5134-321-P4X-001	REV. 0
			SHEET 20 OF 21
	TITLE: INSTRUMENT/SERVICE AIR CENTRIFUGAL COMPRESSOR UNITS		INTERNAL
			ESUP

- 12.27.1. SUPPLIER shall include this information on the respective handling arrangement drawing or handling study, along with the required handling equipment used to remove and transport the internal part. SUPPLIER is also required to check if there is any clash between the space required to remove the internal part and any obstacle nearby the PACKAGE using the 3D model.
- 12.28 PACKAGER/MANUFACTURER shall provide complete documentation of the monitoring sensors installed in the equipment.

	TECHNICAL SPECIFICATION	No. I-ET-3010.00-5134-321-P4X-001	REV. 0
			SHEET 21 OF 21
	TITLE: INSTRUMENT/SERVICE AIR CENTRIFUGAL COMPRESSOR UNITS		INTERNAL
			ESUP

ANNEX A

