

Subject:

MYCOM comments & Exceptions to API Standard 619 5th (fifth) Edition, December 2010.

Meeting agreement 15.02.2021: It has been assumed that MYCOM scope is compressor skid which has been specified as MYCOM field work, otherwise shall be clarified with Kasravand. Kasravand Reply: As per latest agreement compressor Block and oil pumps will be supplied from MYCOM

Prepared by Mayekawa	
MYCOM Comments or Exceptions	
	The American Petroleum institute Standard 619 now rec... Meeting agreement 15.02.2021: Noted
	Flooded Rotary Screw compressor is not only an accepta... Meeting agreement 15.02.2021: Compressor shall be based on API 619 with this agreed deviation.
	"compressor, but also requires special consideration in applying requirements addressed here-in. As manufactures have diverging views on engineering, manufacturing, and assembling techniques, it sh... As such, MYCOM addresses these differences for
2.	MYCOM compressors are based on JIS (Japanese Industrial Standards) design codes.
5.1.17	Clarification : MYCOM fieldwork is contracted separately.
5.1.24	Compressor casing bolt thread is per NPT. Meeting agreement 15.02.2021: Noted
5.2.8	Cast steel is optional LTCS shall be used for casing Kasravand Reply: Noted
5.2.13	MYCOM standard alignment arrangement allows jackscrews (or similar) on... Meeting agreement 15.02.2021: Noted
5.2.21	Neither jackscrews nor dowelling pins are provided on the compressor.
5.3.1	Some threaded connection may be smaller than DIN1/2(3/4NPS).
5.3.10	Compressor casing thread openings will be NPT type.
5.3.11	Thread tape and thread sealant will be used. Meeting agreement 15.02.2021: Noted
5.3.16	Some connections are not designed for through bolting due to space restrictions.
5.3.19	Some bolts holes will not straddle the centerline.
5.5.1.2	Optional : Forged steel rotors material acc. JIS SFCM 930S (equivalent to ASTM A 668 Class M)
5.5.1.5	Shaft is per JIS. Meeting agreement 15.02.2021: Noted
5.5.1.6	Shaft keyway is per JIS. Meeting agreement 15.02.2021: Seal system shall be clarified (type and detail shall be specified) Kasravand reply: Proper Double seal selected by MYCOM will be provided.
5.6.1.8	Double mechanical seal back-to-back will be used.
5.6.4.2	Independent seal fluid system is not provided and not necessary for general service.
5.7.3.3	Rotor balance is per G2.5, G-1.0 is optional. Meeting agreement 15.02.2021: Noted
5.7.3.5	Rotor balance check procedure is per MYCOM Standard.
5.7.3.6	Shop tests are performed at 3000rpm
5.8.2.1.b)	Bearing installation fitness / clearances are as per MYCOM standard. (JIS)
5.8.2.2	Normal internal clearances of ball bearings are per JIS.

Strong advice and similar to many projects in Iran and worldwide, MYCOM has selected Higher Grade Iron which is suitable for stage and material selected by MYCOM is suitable for life time of the project similar to ARAK PC which is under operation since 1989. Despite MYCOM Technical advice, Forge C.S. rotor will be used as well upon request

5.8.3.1.1	Liner is not used	Meeting agreement 15.02.2021: Noted
5.9	Clarification: bearing housing is lube oil flooded by mea The lube oil is circulated through the oil system together	Meeting agreement 15.02.2021: Noted
5.9.5	This is per MYCOM standard	
5.11.1.15	Compressor bolt material is per JIS.	
5.11.4	There are no welds on the casing.	
6.2.5	Shop tests are done with shop couplings. Moment simulator is not used.	
6.5	Clarification :No spiral wound gaskets are provided on the compressor block. All casing gaskets are flat non-asbestos type.	
6.10.2	Tools are not tagged nor stamped. A diagram or list is provided to identify e tool.	Meeting agreement 15.02.2021: Noted
7.2.1.1	Data is kept available for at least 10 years.	Meeting agreement 15.02.2021: Noted
7.2.2	Compressor material inspection will be per JIS.	
7.2.2.2	Casing UT and RT are not possible due to the casing construction.	
7.2.2.3	Ultrasonic inspection is applied for rotor material and test method is according to JIS standard.	
7.2.2.4	As an option, magnetic particle inspection is possible. Inspection method is in accordance with JIS standards.	
7.2.2.5	Liquid penetrant inspection is performed on all casings & rotors. Inspection method is in accordance with JIS standards.	
7.3.2.1	Hydrostatic test is performed at room temperature.	
7.3.3.1	Mechanical running test of bare compressors is performed in the MYCOM factory in Japan with equipment available in the test stand. Tests will be done following MYCOM standard test methods which are based on JIS and local government Oil condition is per MYCOM shop test standard condition. Shop coupling is used. Shop vibration instrument is used.	
7.3	Meeting agreement 15.02.2021: Noted n test is performed on mentioned (7.3.3.1) MYCOM test bench. Compressor speed is 3000 rpm.	Meeting agreement 15.02.2021: Please specify method for vibration analysis. FFT analysis shall be provided during test. Kasravand reply: overall vibration value as per MYCOM standards will be reported in test report and not possible to perform spectrum analysis as stated. Vibration Value in under MYCOM guarantee.
7.3.3.2.2/3/4	Compressor speed is 3000 rpm and is not varied.	
7.3.3.3.2	Spectrum analysis is not performed and not available during shop tests.	
7.3.3.3.4	Lube-oil, seal-oil and other temperatures are not varied during the tests.	
7.3.3.4.3	Casing Pressure Test performed after Running Test is not done.	
7.3.4.2	Performance test is per MYCOM Standard Procedure. Casing vibration is manually recorded using shop Vibration Instruments.	Meeting agreement 15.02.2021: Noted
7.3.4.4	Deceleration test is not performed.	
7.3.4.7	Helium test can be done optionally.	
7.3.4.8	Sound level test is performed for all screw compressors according to MYCOM Standard test method, which is based on JIS B83446 and JIS 8731.	
7.3.4.11	Full pressure/full load/full speed tests are not performed.	
7.4.1	Storage after shipment is purchaser's responsibility.	Meeting agreement 15.02.2021: Is in Kasravand responsibility Kasravand reply: until delivery of goods as per contract confirmed