

	LIDCO, Pars SEE Zone, Assaluyeh, Integrated Methanol and Ammonia Plant 3000 MTPD MeOH / 900 MTPD NH3 PROJECT							
	FAT Procedure (incl. full unit mechanical run test procedure)							
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FAT Procedure (incl. full unit mechanical run test procedure) (K-020)

code-2
M. Vakili

As we informed vendor with PCIM system before, comments attached from client shall be reviewed/replied by vendor.

03	31-01-2024	Issued for Approval	TT	SK	JJ
02	03-01-2024	Issued for Approval	TT	SK	JJ
01	15-09-2023	Issued for Approval	SK	KP	JJ
REV.	DATE	DESCRIPTION	DRAWN	CHECKED	APPROVED

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FAT Procedure (incl. full unit mechanical run test procedure)

Document No. 17735-14

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2	X	X	X			27						52						77					
3	X	X	X			28						53						78					
4	X	X	X			29						54						79					
5	X	X	X			30						55						80					
6	X	X	X			31						56						81					
7	X	X	X			32						57						82					
8	X	X	X			33						58						83					
9	X	X	X			34						59						84					
10	X	X	X			35						60						85					
11	X	X	X			36						61						86					
12	X	X	X			37						62						87					
13		X	X			38						63						88					
14		X	X			39						64						89					
15		X	X			40						65						90					
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25						50						75						7					



**LIDCO, Pars SEE Zone, Assaluyeh,
Integrated Methanol and Ammonia
Plant 3000 MTPD MeOH / 900 MTPD NH3 PROJECT**






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1. Purpose

Checking the performance and functioning of the package against the approved documents and specifications.

Separate test reports for each test will be generated; however, this FAT procedure covers only the procedure to be performed on all skids.

2. Reference documents

2.1. Vendor documents




Please find below the reference vendor documents that will be used during this FAT.

N-278-VD-6019-PR-PID-0002-01	18841-03	P&ID
N-278-VD-6019-PR-GAD-0003-01	18841-04	General Arrangement Drawing
N-278-VD-6019-IN-DIA-0005-01	18841-05	Wiring Diagram (LCP and JB)
N-278-VD-6019-IN-DWG-0007-01	18841-07	Panel lay-out (LCP and JB)
N-278-VD-6019-GN-ITP-0008-01	18841-08	Inspection & Test Plan (ITP)
N-278-VD-6019-GN-PRO-0022-01	18841-21	Control Philosophy
N-278-VD-6019-GN-SF-0029-01	18841-27	Cause and Effect chart

2.2. Manufacturing data book

The manufacturing data book will also be available for review during the FAT. The MDB will be checked according to the approved MDB index and ITP.

The client or client TPI will sign the relevant pages as well as all relevant point of the ITP.

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3. Scope

One (1) Instrument air booster compressor (K-020), Vertical piston compressor with motor driver (320-KM-020), outlet capacity 35 Nm³/hr, 30 bar(g) and inlet, 9,5 bar(g). 1 duty (1x100%). The compressor is water cooled at 4,5 bar(g) inlet pressure.

The test will include:

- Main motor (KM-020)
- Intercooler and aftercooler
- 4x pulsation damper
- Oil system
- Water system
- Local panel

The compressor is equipped with:

- One (1) LPS (Local Push Button Station)
- One (1) JB (Junction Box)




4. HSE

Standard safety precautions have to be taken since we are working with pressurised air.

- Proper PPE has to be worn when working / testing the package
- All visitors for the FAT will be instructed before the FAT, about Airpack safety precautions, by Airpack Safety movie.
- All visitors will be asked to sign a disclaimer to be able to enter the hazardous area during the test.
- The test area is cordoned off to make sure non-authorized personnel does not enter this area.

5. FAT Kick off meeting

Before starting the FAT there will be a short kick off meeting, where Airpack will explain the safety rules and regulations as well as what activities and planning will be performed during the FAT.

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Kick-Off Meeting (KOM) Agenda.

- i. Introduction/Sign in (along with the name, role/designation)
- ii. HSE Induction
- iii. FAT organization, roles and responsibilities of the personnel involved.
- iv. Briefing on duration and sequence of tests planned, timing etc.

Also proper PPE will be distributed as required.

6. Roles and responsibilities

The project manager is responsible for the complete FAT. The project manager will arrange the persons who are required for each part of the FAT.

A qualified AIRPACK Technician who is familiar with the operational parameters of the Package will perform all FAT tasks

6.1. Problem resolution

If there are any problems during the FAT, then not possible they will be recorded in the FAT commissioning of the package.

Please find attachment 1: Punch list format

Plz add following items for instrument
 - Degree of Ingress Protection (IP) Certificate
 - Performance Tests
 For Valves are required the following Items too
 - Hydrostatic/NDE Test
 - Blowdown/Set Pressure Test

7. Test Instruments

The following test instruments will be used during the FAT, all instruments will have a valid calibration certificate which will be supplied as part of the FAT test results for checking and signing.

- Paint thickness meter
- Sound level meter
- Ambient pressure / temperature meter
- Multi meter (voltage check)

should be added "and material certificate"

8. Utilities



LIDCO, Pars SEE Zone, Assaluyeh,
Integrated Methanol and Ammonia
Plant 3000 MTPD MeOH / 900 MTPD NH3 PROJECT






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The utilities that are available during FAT are:

- Power: 400V, 50Hz, 3ph and 230V, 50Hz, 1ph
- Cooling water supply: 4,5 bar(g), ~36 °C

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9. Test procedure

Test may not be done in below order; it is subject to availability of personnel and equipment.

9.1. Mechanical checks

The Following will be tested / checked and recorded as part of the FAT. All checks are mentioned in attachment 2: Equipment checklist

Quality

- 1 Verify all equipment are installed in accordance with approved P&ID and GAD.
- 2 Visual inspection of the complete package for quality.
- 3 Verify piping, tubing location, orientation in accordance with approved GA Drawing.

P&ID review

- 1 Verify all components are installed as per the GA Drawing.
- 2 Check that all components are tagged according to the P&ID.
- 3 Check that the location is of the components is as per the GAD.

Dimensions

- 1 Dimensional check of the complete package for compliance to approved GA Drawing.
- 2 Verification and dimensional check of Tie-in Point, lifting points
- 3 Verification and dimensional check of foundation holes.

Painting




- 1 Check the overall paint for damages and overall quality.
- 2 Randomly check the thickness as per the approved paint procedure.
- 3 Check the paint color as per the paint procedure.

LPS and JB

- 1 Check for any loose connection in the control panel
- 2 Verify all control panel BOM, GA, wiring, I/O etc., matches approved drawings.
- 3 Check the installation and type of cable glands
- 4 Check the installation of the cable trays
- 5 Check the cable type

Instruments

- 1 Check for any loose connection of cables or wires in the instruments
- 2 Check the installation of the instruments as per approved drawings
- 3 Check if all instruments are tagged
- 4 Check the quantity of the instruments

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9.2. Performance test (four hours)

Test set-up for the package is as follows:

- The power from the package will come from internal power supply
- 400V / 50Hz / 3ph and 230V / 50Hz / 1ph
- Power is ON

as stated before ,
all electrical eq.
shall be 400 V

The following measurements will be performed during performance test.

- Sound level at 1 metre distance from skid (max. 85 dB(A))
- The performance test will be done with ambient air. **The related calculation for the outlet pressure can be found in attachment 6.**
- Refer to Attachment 1 for an example of the performance test results sheet, which will be filled in during FAT.
- The piping will be sprayed and checked for leakage.

All in house instruments required / used during the test will have recent calibration certificated, which will be attached to the FAT test report.

The FAT recordings can be found in attachment 3: Performance test results

9.3. Noise level measurement

Noise test will be done during the performance test. Measuring points will be defined by a distance of 1 metre from the package and measured round the package. Final measuring point will be the same as start measure point. This is for checking correct functioning of the noise level meter.

Noise level shall not exceed 85 dB(A) for complete package at 1 metre distance (with package test blow off muffler closed).

The measurement will be recorded in attachment 4: Noise test results.

9.4 Vibration measurement

Vibration measurement will be done with job vibration transmitter unless they cannot be used. In that case a handheld analyser will be used.

Is this applicable to all measuring point? (e.g. cylinders, frame, motor, etc.)?

The vibration is measured on the points as stated in attachment 4: Vibration test results, the values are recorded there as well.

The vibration level should not exceed 10 mm/s at the compressor and the motor.



Punch List Air Compressor Package

Project: 17735-GEN

Revision	03
Dry Test	
Inhouse Test	
FAT	
F. Inspection	
Shipment	
Commissioning	

Item	Description	Point raised by	Action by	Completion before	Closed [date] [name]
001					
002					
003					
004					
005					
006					
007					
008					
009					
010					
011					
012					
013					
014					
015					
016					
017					
018					
019					
020					
021					
022					
023					
024					
025					
026					

FAT TEST PROCEDURE

Equipment	K-020
Customer	Lavan Industry Development Company (LIDCO)
Serial number	T-2023-00799
Project name	Integrated Methanol and Ammonia Plant
Airpack reference number	17735-COM
Date	8-1-2024
Revision	03
Document number	17735-14 Attachment 2
Handled by	SK
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INSPECTION	DOCUMENT	COMPLETED	REMARKS
Quality			
1. Installation of main equipment	GAD / PID		
2. Visual inspection of overall quality	GAD / PID		
3. piping, tubing location / orientation	GAD / PID		
P&ID review			
1. Component check	P&ID		
2. Tagging of all components	P&ID		
3. Component location	P&ID		
Dimensions			
1. Overall skid dimensions	GAD		
2. Tie-in point dimensions	GAD		
3. Foundation bolt holes	GAD		
Painting			
1. Overall Paint quality	Paint procedure		
2. Paint DFT measurement	Paint procedure		
3. Paint color	Paint procedure		
Control Panel			
1. Loose connections	Wiring diagram / Panel lay-out		
2. BOM	Wiring diagram / Panel lay-out		
3. Cable glands	Wiring diagram / Panel lay-out		
4. Cable trays	Wiring diagram / Panel lay-out		
5. Cable type	Wiring diagram / Panel lay-out		
Instruments			
1. Loose connections	Wiring diagram		
2. Installation	P&ID		
3. Tagging	P&ID		
4. quantity	P&ID		

Airpack Test Engineer	Client Inspector

Notes:

FAT TEST PROCEDURE

Equipment	K-020
Customer	Lavan Industry Development Company (LIDCO)
Serial number	T-2023-00799
Project name	Integrated Methanol and Ammonia Plant
Airpack reference number	17735-COM
Date	8-1-2024
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Performance Test Results																					
											OPERATING										
											VALUES										
											UNIT										
											00:00	00:30	01:00	01:30	02:00	02:30	03:00	03:30	04:00		
320-PT-8201	START										bar(g)	9,5									
320-TT-8201											°C	46									
320-TT-8202											°C	157									
320-PT-8202											bar(g)	23,3									
320-TT-8203											°C	60									
320-TT-8204											°C	116									
320-TT-8205											°C	60									
320-PG-8203											bar(g)	30									
320-PT-8203											bar(g)	30									
320-PG-8204											bar(g)	4,5									
320-TG-8205											°C	max 46									
320-PT-8204											bar(g)	1,5									
Running test starting time:																					
Humidity:												R.H.%									
Ambient temperature:												°C									
Ambient pressure:												hPa									

Airpack Test Engineer	Client Inspector

Notes:

Integrated Methanol and Ammonia Plant

Document n° : 17735-14 attachment 4

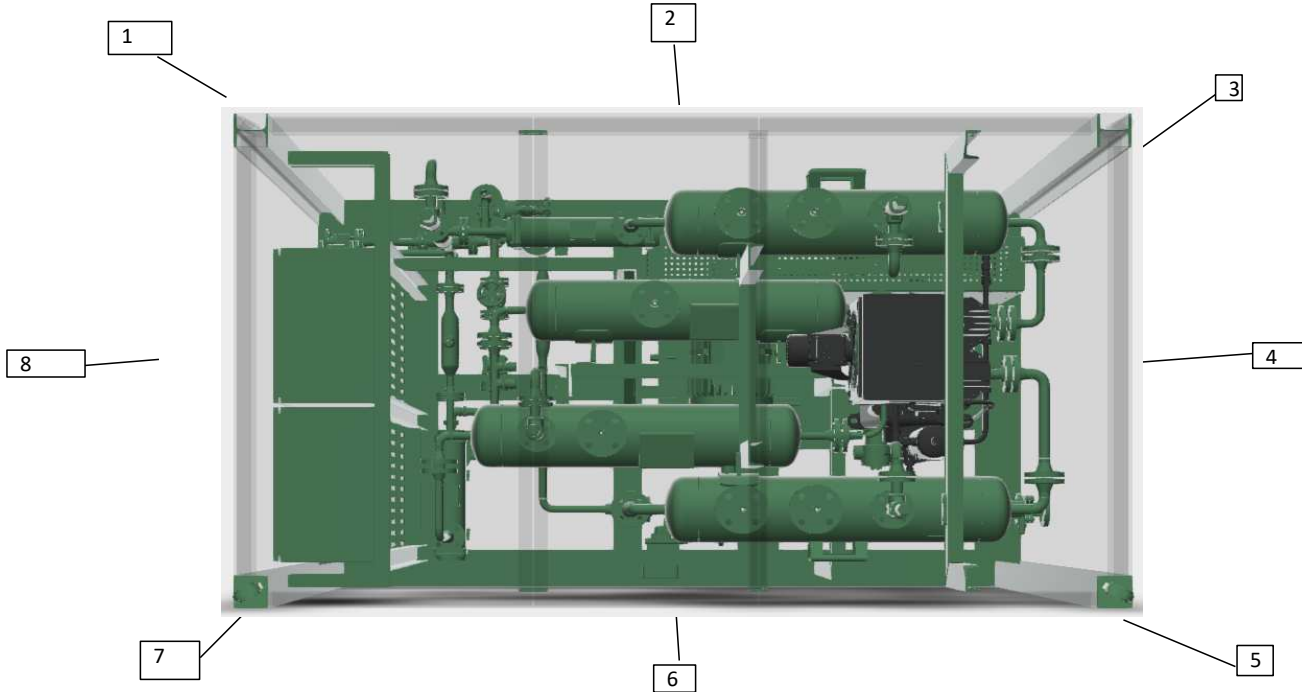
Revision : 03

NOISE LEVEL

Unit : K-020
 Service : Air booster compressor
 Supplier : Airpack
 Serial No. : T-2023-00799

Client: Lavan Industry Development Company (LIDCO)
 Contractor: Nargan Company
 Project: Integrated Methanol and Ammonia Plant

Supplier to Complete Expected Noise Level Data



Noise test has been performed during performance test:

Procedure:
 Measure point will be defined by a distance of 1 metre from the package and 1,5 metre above the ground level to measured round the package. Final measure points will be the same as start measure points. This is for checking correct functioning of the noise level meter. Noise shall not exceed 85 dB(A) for complete package. Noise meter calibration certificate is available during test

Points	Unit	Noise Estimated	Noise measured	Average of anti logs	Noise level (Logarithmic Avg)	Noise level (Arithmetic Avg)	Test Result: Tested By : Date: NOTE:
P1	dB(A)	83		1	0	0	
P2	dB(A)	84					
P3	dB(A)	85					
P4	dB(A)	85					
P5	dB(A)	85					
P6	dB(A)	84					
P7	dB(A)	83					
P8	dB(A)	83					
Surrounding Noise measured (dB(A)) : 85							
Noise level (After correction(if required) as per 5.3 of ISO 2151):							
Correction Factor							
Level increase due to	Value to be subtracted from measured						
Test Condition : Noise level test as per ISO 2151							

Project	:	17735-1				
Equipment	:	K-02C				
Date	:	8-1-202				
Test Engineer(s)	:					
Vibration Test Report						
Measurement points no.as sketch	Measurement quantity: r.m.s. overall values (2 Hz. A 1000 Hz)					
	Speed	Power	H	V	L	Notes
			horizont	vertical	axial	
			al	mm/s.	mm/s.	
rev/min.	kW.	(M)	(M)	(M)		
Compressor tag no:						
Compressor frame measere point 1						
Compressor frame measere point 2						
Compressor frame measere point 3						
Compressor frame measere point 4						
Motor measure point 1						
Motor measure point 2						
Compressor tag no:						
1						
2						
3					X	
4					X	
5				X	X	
A						
B						
C						
D						

What are these marks?

1-Please clarify. We have 2 cylinders, and 4 dampers. It means if vendor wants to measure on compressor, cylinders and dampers, at least we have 7 points. This shall be clarified.
2-Measuring points shall be clear. Please add a schematic.

Please add a schematic same as previous revision showing the measuring point.

Equipment K-020
Customer Lavan Industry Development Company (LIDCO)
Serial number T-2023-00799
Project name Integrated Methanol and Ammonia Plant
Airpack reference number 17735-COM
Date 30-1-2024
Revision 03
Document number 17735-14 Attachment 6
Handled by TT
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Please clarify. will actual volume in test condition be measured/calculated and compared with actual flow at site condition?

Operation with ambient air at the inlet		
Suction conditions	1	bar absoluut
Discharge pressure	6	bar absoluut
Working speed	410	rpm
Vollume flow. Approx.	3,2	Nm ³ /h
Power requirement approx	1	kW
Gas temperature 1st stage approx	112	°C
Suction temperature 2nd stage approx	40	°C
Gas temperature 2nd stage approx	123	°C
max operating time	24	hr

Notes:
The machine operates at a 10 times smaller inlet pressure and at a pressure ratio of approx. 6 instead of approx. 3.

Please remove this. (test duration is specified in age 9)