



Centac Annual Inspection Procedure

The following procedure applies as minimum requirements for all Annual Inspection Procedures for large frame Centac centrifugal compressors.

Gearbox

- ✓ Split compressor at the cooler cover split line and remove air coolers and moisture separators for CTR.
- ✓ Measure and record pinion end floats.
- ✓ Measure bull gear float and lift.
- ✓ Check all gear teeth for damage and wear.
- ✓ Clean impellers and check for wear or damage.
- ✓ Check air seal pressure drop using a regulator and 10psig of static air pressure in each individual stage.
- ✓ Measure Impeller axial tip and radial tip clearances. Correct if required.
- ✓ Verify that all Impeller nuts are properly torqued.
- ✓ Clean diffusers and have repainted if necessary.
- ✓ Clean diffuser bore and have repainted if necessary.
- ✓ Verify that gearmesh oil spray nozzles are functioning properly.

Alignment

- ✓ Check main driver alignment and correct if required. Show all final readings on Service Report.
- ✓ Clean and inspect main drive coupling and re-grease if applicable.

If at any time in the preventative maintenance process you have questions or need additional assistance, give us a call. The benefit of our 250+ years of combined experience is available to you 24/7/365.

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Coolers

- ✓ Hydrotest coolers by circulating cooling water and checking for leaks at the condensate drains before the unit is disassembled.
- ✓ Check condensate drains for correct operation.
- ✓ Have coolers cleaned if required as part of a clean test and repair process.
- ✓ Check cooler shell interiors for corrosion brush gring and repaint if necessary.

Interstage Piping

- ✓ Check interstage piping for corrosion.

Lube System

- ✓ Check for leaks.
- ✓ Set oil pressure regulators to correct valves (if required).
- ✓ Check seal air switch for correct operation.
- ✓ Inspect main pump and auxiliary pump couplings.
- ✓ Clean oil cooler if required.
- ✓ Change oil if required.
- ✓ Change oil filters if required.

Control System

- ✓ Check all gauges for proper operation.
- ✓ Calibrate all pressure switches and temperature switches, if applicable.
- ✓ Check all alarm and trip set points.
- ✓ Check calibration on control valves and correct accordingly.
- ✓ Tune controls as needed.
- ✓ Drain any moisture front pneumatic control lines, and check for leaks.

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System Piping

- ✓ Inspect inlet filters and housing. Change if required.
- ✓ Remove and inspect discharge check valve.
- ✓ Inspect inlet and discharge expansion joints.

Test Run Compressor

- ✓ Check for leaks. Repair if required.
- ✓ Surge test machine, reset control settings if required.
- ✓ Tune controls as needed.
- ✓ Log 8 hours of operating data on service Report.

All findings will be reviewed with the customer and the service technician will comment on condition of machine and make recommendations accordingly.

A service report containing all operational data, control settings, clearances, alignment data, and an overall daily summary will be forwarded to the customer after the completion of the job.

NOTE: The average completion time for this procedure on a large frame Centac compressor is Twelve (12) 8-10 hour days (depending on size of unit and support). If the coolers are removed, additional time may be needed.

Additional work may also be required if the situation dictates.

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