

DEP SPECIFICATION

**PACKAGED INTEGRALLY GEARED CENTRIFUGAL
PLANT AND INSTRUMENT AIR COMPRESSORS
(AMENDMENTS/SUPPLEMENTS TO API 672)**

DEP 31.29.40.33-Gen.

February 2012

DESIGN AND ENGINEERING PRACTICE



© 2012 Shell Group of companies
All rights reserved. No part of this publication may be reproduced, stored in a retrieval system, published or transmitted, in any form or by any means, without the prior written permission of the copyright owner or Shell Global Solutions International BV.

PREFACE

DEP (Design and Engineering Practice) publications reflect the views, at the time of publication, of Shell Global Solutions International B.V. (Shell GSI) and, in some cases, of other Shell Companies.

These views are based on the experience acquired during involvement with the design, construction, operation and maintenance of processing units and facilities. Where deemed appropriate DEPs are based on, or reference international, regional, national and industry standards.

The objective is to set the standard for good design and engineering practice to be applied by Shell companies in oil and gas production, oil refining, gas handling, gasification, chemical processing, or any other such facility, and thereby to help achieve maximum technical and economic benefit from standardization.

The information set forth in these publications is provided to Shell companies for their consideration and decision to implement. This is of particular importance where DEPs may not cover every requirement or diversity of condition at each locality. The system of DEPs is expected to be sufficiently flexible to allow individual Operating Units to adapt the information set forth in DEPs to their own environment and requirements.

When Contractors or Manufacturers/Suppliers use DEPs, they shall be solely responsible for such use, including the quality of their work and the attainment of the required design and engineering standards. In particular, for those requirements not specifically covered, the Principal will typically expect them to follow those design and engineering practices that will achieve at least the same level of integrity as reflected in the DEPs. If in doubt, the Contractor or Manufacturer/Supplier shall, without detracting from his own responsibility, consult the Principal.

The right to obtain and to use DEPs is restricted, and is typically granted by Shell GSI (and in some cases by other Shell Companies) under a Service Agreement or a License Agreement. This right is granted primarily to Shell companies and other companies receiving technical advice and services from Shell GSI or another Shell Company. Consequently, three categories of users of DEPs can be distinguished:

- 1) Operating Units having a Service Agreement with Shell GSI or another Shell Company. The use of DEPs by these Operating Units is subject in all respects to the terms and conditions of the relevant Service Agreement.
- 2) Other parties who are authorised to use DEPs subject to appropriate contractual arrangements (whether as part of a Service Agreement or otherwise).
- 3) Contractors/subcontractors and Manufacturers/Suppliers under a contract with users referred to under 1) or 2) which requires that tenders for projects, materials supplied or - generally - work performed on behalf of the said users comply with the relevant standards.

Subject to any particular terms and conditions as may be set forth in specific agreements with users, Shell GSI disclaims any liability of whatsoever nature for any damage (including injury or death) suffered by any company or person whomsoever as a result of or in connection with the use, application or implementation of any DEP, combination of DEPs or any part thereof, even if it is wholly or partly caused by negligence on the part of Shell GSI or other Shell Company. The benefit of this disclaimer shall inure in all respects to Shell GSI and/or any Shell Company, or companies affiliated to these companies, that may issue DEPs or advise or require the use of DEPs.

Without prejudice to any specific terms in respect of confidentiality under relevant contractual arrangements, DEPs shall not, without the prior written consent of Shell GSI, be disclosed by users to any company or person whomsoever and the DEPs shall be used exclusively for the purpose for which they have been provided to the user. They shall be returned after use, including any copies which shall only be made by users with the express prior written consent of Shell GSI. The copyright of DEPs vests in Shell Group of companies. Users shall arrange for DEPs to be held in safe custody and Shell GSI may at any time require information satisfactory to them in order to ascertain how users implement this requirement.

All administrative queries should be directed to the DEP Administrator in Shell GSI.

TABLE OF CONTENTS

PART I	INTRODUCTION	4
1.1	SCOPE.....	4
1.2	DISTRIBUTION, INTENDED USE AND REGULATORY CONSIDERATIONS	4
1.3	DEFINITIONS	4
1.4	CROSS-REFERENCES	4
1.5	SUMMARY OF MAIN CHANGES.....	4
1.6	COMMENTS ON THIS DEP	5
1.7	DUAL UNITS.....	5
PART II	GENERAL INFORMATION	6
PART III	AMENDMENTS/SUPPLEMENTS TO API 672	7
1	Scope	7
3	Definition of Terms	7
4	General	8
4.1	UNIT RESPONSIBILITY	8
5	Requirements.....	9
5.3	ALTERNATIVE DESIGNS	9
5.4	CONFLICTING REQUIREMENTS	9
6	Basic Design	10
6.1	GENERAL	10
6.3	CASING CONNECTIONS.....	11
6.7	DYNAMICS	11
6.8	BEARINGS AND BEARING HOUSINGS	12
6.9	LUBRICATION	12
6.10	MATERIALS.....	13
6.11	NAMEPLATES AND ROTATION ARROWS	13
6.12	ADDITIONAL REQUIREMENTS OR SPECIAL DUTY PACKAGE	13
7	Accessories.....	13
7.1	DRIVERS	13
7.2	COUPLINGS AND GUARDS.....	14
7.3	BASEPLATE/SUPPORT STRUCTURE	14
7.4	CONTROLS AND INSTRUMENTATION.....	14
7.6	INTERCOOLERS AND AFTERCOOLERS	16
7.7	INLET AIR FILTER/SILENCER	16
7.8	DISCHARGE BLOWOFF SILENCER.....	16
7.10	ADDITIONAL REQUIREMENTS FOR “SPECIAL DUTY” PACKAGES	16
8	Inspection, Testing, and Preparation for Shipment.....	17
8.1	GENERAL	17
8.3	TESTING.....	18
8.5	ADDITIONAL INSPECTION, TESTING & PREPARATION FOR SHIPMENT REQUIRMENTS FOR “SPECIAL DUTY” PACKAGES	18
9	Vendor Data.....	18
9.1	GENERAL	18
9.2	PROPOSALS	19
9.4	ADDITIONAL VENDOR DATA REQUIRMENTS FOR “SPECIAL DUTY” PACKAGES	19
ANNEX C	(INFORMATION ON ROTORDYNAMIC ANALYSIS).....	19
C.2	Lateral Analysis	19
PART IV	REFERENCES	20

PART I INTRODUCTION

1.1 SCOPE

This DEP specifies requirements and gives recommendations for packaged integrally geared centrifugal plant and instrument air compressors. This DEP is based on API 672, Fourth Edition, March 2004 (Errata 2, July 2010); Part III of this DEP amends, supplements and deletes various clauses of API 672.

This is a revision of the DEP of the same number dated January 2008. See (1.5) regarding the changes.

1.2 DISTRIBUTION, INTENDED USE AND REGULATORY CONSIDERATIONS

Unless otherwise authorised by Shell GSI, the distribution of this DEP is confined to Shell companies and, where necessary, to Contractors and Manufacturers/Suppliers nominated by them. Any authorised access to DEPs does not for that reason constitute an authorization to any documents, data or information to which the DEPs may refer.

This DEP is intended for use in oil refineries, chemical plants, gas plants, exploration and production facilities and supply/distribution installations.

When DEPs are applied, a Management of Change (MOC) process shall be implemented; this is of particular importance when existing facilities are to be modified.

If national and/or local regulations exist in which some of the requirements may be more stringent than in this DEP, the Contractor shall determine by careful scrutiny which of the requirements are the more stringent and which combination of requirements will be acceptable with regard to the safety, environmental, economic and legal aspects. In all cases the Contractor shall inform the Principal of any deviation from the requirements of this DEP which is considered to be necessary in order to comply with national and/or local regulations. The Principal may then negotiate with the Authorities concerned, the objective being to obtain agreement to follow this DEP as closely as possible.

1.3 DEFINITIONS

1.3.1 General definitions

The **Contractor** is the party that carries out all or part of the design, engineering, procurement, construction, commissioning or management of a project or operation of a facility. The Principal may undertake all or part of the duties of the Contractor.

The **Manufacturer/Supplier** is the party that manufactures or supplies equipment and services to perform the duties specified by the Contractor.

The **Principal** is the party that initiates the project and ultimately pays for it. The Principal may also include an agent or consultant authorised to act for, and on behalf of, the Principal.

The word **shall** indicates a requirement.

The word **should** indicates a recommendation.

1.4 CROSS-REFERENCES

Where cross-references to other parts of this DEP are made, the referenced section number is shown in brackets ().

Other documents referenced by this DEP are listed in (Part IV).

1.5 SUMMARY OF MAIN CHANGES

The previous edition of this DEP was dated January 2008, and was based on API 672, Fourth Edition, March 2004. There have been numerous changes to reflect the new basis and it is impractical to summarise them here.

1.6 COMMENTS ON THIS DEP

Comments on this DEP may be sent to the Administrator at standards@shell.com, using the DEP Feedback Form. The DEP Feedback Form can be found on the main page of “DEPs on the Web”, available through the Global Technical Standards web portal <http://www.shell.com/standards> and on the main page of the DEPs DVD-ROM.

1.7 DUAL UNITS

This DEP contains both the International System (SI) units, as well as the corresponding US Customary (USC) units, which are given following the SI units in brackets. When agreed by the Principal, the indicated USC values/units may be used.

PART II GENERAL INFORMATION

This DEP gives amendments and supplements to API Std 672, Fourth Edition, March 2004 (Errata 2, July 2010).

Packaged integrally geared centrifugal plant and instrument air compressors shall conform to API Std 672 as amended/supplemented by this DEP.

For ease of reference, the clause (or paragraph) numbering of API Std 672 has been used throughout Part III of this specification. Clauses (paragraphs) in API Std 672 not mentioned in this DEP shall remain valid as written.

A bullet (•) in the margin against certain clauses (paragraphs) in API Std 672 indicates that a decision by the Principal is required. These decisions shall be indicated on the data/requisition sheets, preferably under the heading "Additional Requirements" or stated in the purchase order.