

VRC-2 Compressor Start Up Check List
PRE-START UP

COMPRESSOR GENERAL INFORMATION

Compressor Model _____	Serial No. _____
Cylinder Serial No. _____	_____
Driver _____	Rated Speed _____
Packager _____	Packager Unit No. _____
Date Packager Shipped _____	Start Up Date _____
Serviceman _____	Customer _____
Location _____	Field Contact _____
Field Telephone No. _____	Unit Location _____
Frame Oil - Make _____	Grade _____
Cylinder Oil - Make _____	Grade _____

NOTES / COMMENTS:

PRE-START UP

1. Are the correct Arrow parts book, technical manual, special tools, and spares available?
2. Have the design limitations for the compressor model such as rod load, maximum and minimum speed, discharge temperature been checked?
3. Have the design operating conditions been determined?

YES	NO

Pressure, PSIG (kPa): Suction _____ Discharge _____

Temperature, °F (°C): Suction _____ Discharge _____

Maximum RPM _____ Minimum RPM _____

4. Soft Foot Check: Have the compressor feet and crosshead guide supports been shimmed so that the machine is not twisted or bent?
5. Have bottom crosshead clearances on all corners been checked?
Max. 0.0015" (0.0381 mm) feeler inserted to 1/2" (12.7 mm) Max. depth.
6. Record top crosshead minimum feeler clearance below

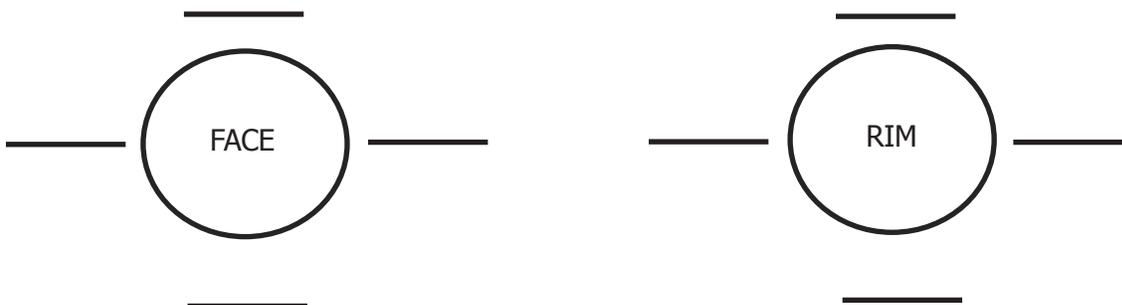
YES	NO

THROW No. 1 _____ 2 _____

7. Have the piping and supports been checked to be sure they do not bend or stress compressor?
8. Have the coupling bolt torque values been rechecked?
9. Has the compressor to driver alignment been checked?
Maximum allowable 0.005" (0.127mm) TIR

YES	NO

10. Record coupling dial indicator readings in inches at the 3, 6, 9, 12 o'clock positions on the lines provided.



Compressor Model _____

Serial No. _____

	YES	NO
27. Is the cylinder lubricator system primed?		
28. Is the cylinder lubrication system no flow shutdown installed and working?		
29. Is the cylinder lubrication overpressure indicator installed? Check rupture disc for color. Aluminum is standard @ 2350 psi.		
30. Has the lubricator instruction plate or Divider Block Selection and Cycle Time (Table 6.2) been checked for proper lube feed rate?		
31. Is there a working vibration shutdown mounted on the compressor?		
32. Are the primary and secondary packing vents and the distance piece vents open, and when necessary, tubed off of the skid or out of the building?		
33. Is there some method of suction pressure control?		
34. Are the suction pressure, inter stage pressure and discharge pressure shutdowns set and working?		
35. Are the safety relief valves installed and set to protect cylinders and piping for each stage of compression?		
36. Are the gas discharge temperature shutdowns installed, set and working?		
37. Have the gas suction lines been blown out to remove water, slag, dirt, etc?		
38. Have temporary screens been installed at cylinder suction?		
39. Has the machine been rolled with the starter to make sure it is free? The oil pressure should come up noticeably while rolling on the starter.		
40. For engine driven units, has the machine been rolled with the starter to make sure it is free? The oil pressure should come up noticeably while rolling on the starter		
41. Does the driver rotation match the compressor rotation?		
42. For machines compressing a combustible gas, have the piping and compressor been purged to remove all air?		
43. Have the start-up instructions for other equipment on the package been followed?		
44. Has the Packager's representative done the required review of the Packager's Start Up and Operating Instructions for the unit with the unit operator?		

AFTER START UP

Compressor Model _____

Serial No. _____

	YES	NO
1. Did the oil pressure come up immediately?		
2. Any strange noises or shaking in the compressor or piping?		
3. Is low oil pressure shutdown set at 25 PSIG		
4. Are the high discharge gas temperature shutdowns set at approximately 10% above normal discharge temperature? 325°F (163°C) to a maximum of 350°F (177°C).		
5. Is the divider block cycle indicator pin moving, and have you set lubricator for proper break-in flow rate?		
6. Are there any oil leaks? If so, where?		
7. Are the scrubber dumps and high level shutdowns working?		
8. Are the scrubbers removing all liquids from the gas? How often do the scrubbers dump? (_____ min.)		
9. Are there sands or oxides in the gas?		
10. Is the overspeed shutdown set?		
11. Are rod packing sealing properly?		
12. Have all safety functions been tested to ensure shutdown of unit upon malfunction?		