

UNIT REFURBISHMENT OF A DELAVAL 6B26 CENTRIFUGAL COMPRESSOR

By Marc Rubino

Rotating Machinery Services Inc. (RMS) was contracted to refurbish a DeLaval 6B26 centrifugal barrel compressor for a US based refinery. The completed machine was shipped during the second quarter of 2014 following an extensive repair and part replacement scope.

This 1970s vintage compressor was previously in operation at a Midwest US refinery until site shutdown. After sitting idle for an unknown number of years, the compressor was pulled from the refinery, disassembled, and placed in storage. The fully disassembled compressor was sent to RMS for inspection and reassembly feasibility. All components arrived at RMS corroded and disheveled. After cleaning and evaluating the received compressor parts, a repair plan was developed and executed:

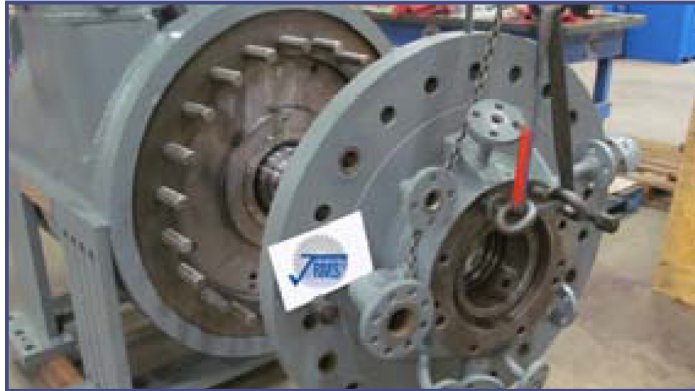


Figure 1

- Weld repaired impellers as needed, shaft reworked, rotor reassembled, and balanced
- New Fluorosint interstage (eye and shaft sleeve) and balance piston seals
- New aluminum labyrinth shaft seals
- Repaired process gas Kaydon seals
- New radial tilt-pad bearings with retrofitted RTDs (thermocouples previously installed)
- Repaired thrust bearings with retrofitted RTDs (thermocouples previously installed)

- New radial and axial proximity probes, cable seals, and enclosures
- New casing vertical joint studs and nuts
- Repaired outer casing connections
- Majority of fasteners and all O-rings replaced
- Complete unit reassembled and painted with corrosion inhibitive coatings
- Compressor stored and shipped in “dog house”, or top-hat style, nitrogen pressurized container



Figure 2



Figure 3



Figure 4

Through the collaborative effort of RMS and its dedicated network of suppliers, the compressor was completely overhauled and reassembled at RMS Power Solutions. RMS anticipates this refurbished compressor to provide many years of successful operation and meet or exceed OEM online reliability. This recent project demonstrates RMS has the expertise and capabilities to provide custom engineered solutions to restore your equipment despite its condition.

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