

AMMONIA PLANT
TPM STEP-4
AMMONIA BOOSTER COMPRESSOR K-1441/1442

Description of WRVT510 Compressor

The Howden oil injected screw compressor is a positive displacement capacity controlled oil flooded rotary machine.

Compression is achieved by the meshing of two asymmetric profile steel rotors with parallel shafts housed in a casing. Each rotor is supported by two plain white metal bearings fitted adjacent to the compression chamber. The action of the rotor is entirely rotary. The accurately machined rotors are called male and female. The male (driving) rotor has four lobes which mesh with six flutes in female (driven) rotor, each rotor having the same outside diameter.

Compressor lubricating oil is injected into the bearings and rotor space at a pressure equivalent to discharge pressure plus 2 bars. The bearings therefore also act as shaft seals within the compressor. The compressor input shaft is fitted with a mechanical seal hence the compressor is completely sealed from atmosphere.

Rotor end thrust is accommodated by tilting pad thrust bearings. The male rotor which takes the majority of end thrust is also fitted with a balance piston. One side of the balance piston is subjected to oil pressure whilst the other is at gas suction pressure. The balance piston thrust therefore opposes normal rotor end thrust, ensuring that the thrust bearings are lightly loaded.

GAS System:

Gas is drawn into the compressor via a non return valve and suction strainer. The non return valve is necessary to prevent the compressor being motored in the reverse direction when it is stopped with high gas pressure at the discharge. On leaving the compressor the gas oil mixture enters a combined primary separator / reservoir vessel. The majority of the oil separates from the gas stream on entering this vessel, due to the reduction in velocity, the separated oil falling by gravity into the reservoir base.

The gas and entrained oil droplets then pass through a knitted stainless steel wire mesh separator element mounted in the upper portion of the vessel. Almost all the remaining oil is collected by impingement on the very fine wire mesh, from which it falls by gravity into the reservoir base. The gas leaving this separator contains approximately 30 to 50 ppm of oil by weight. The separator / reservoir vessel is also provided with a safety / relief valve.

The gas then passes through a gas cooler before entering a high efficiency secondary oil separator. This separator incorporates replaceable high efficiency filter elements which are 100% effective in the removal of liquid phase oil. Oil carry over d/s of this separator is less than 5 ppm by weight.

Separated oil is returned to the compressor through a small pipe fitted with a filter, orifice and isolating valves. Isolating valves and a thermal relief valves are provided for the separator. A non return valve is also fitted downstream of the separator.

A gas bypass line with a control valve rated for 10 percent capacity is also provided. Capacity control from 10% to 0% is achieved via this line. An air operated ball valve is also included which opens automatically on shut down to equalize the pressure in the system.

Parts in Gas Circuit:

1. Non Return Valve:

Suction and discharge non return valves are Wafer type with body and seat manufactured in low temperature steel and disc in alloy steel

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**United States. Department of the
Army**



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Air Force Manual United States. Department of the Air Force,1953 **AF Manual** United States. Department of the Air Force,1962 Design Manual, Mechanical Engineering United States. Naval Facilities Engineering Command,1972

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