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		Operations		CCLP-OPS-WI-33	
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1. PURPOSE

1.1 The purpose of this document is to provide proper instructions for installing the Gas Jack Compressor Discharge Block Flange, identified as CCLP item/part number C2230.

2. DESCRIPTION

2.1 Bill of Materials

2.1.1 CCLP Technician or Designee must obtain the Bill of Materials as listed below:

Part #	Description	Quantity
C2230	GASJACK COMPRESSOR DISCHARGE BLOCK	1
C2250	GASJACK COMPRESSOR DISCHARGE BLOCK GASKET	1
N/A	CAP SCREW, 3/8-16 X 2.5", ASTM A193 GRADE B7	4
N/A	WASHER, HARDENED STEEL, .406" ID X .875", .1" THK	4

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2.2 Assembly

2.2.1 CCLP Technician or Designee must complete the following instruction steps, 1. – 6., as listed below:

1. Before installation, check each threaded hole on head to ensure they are clear of debris. If needed, chase threads with 3/8-16 bottoming tap. Holes are 1.25" deep.
2. Old sealing gasket material should be carefully removed from head surface and discharge flange. NEVER use a buffing wheel or abrasive of any kind to remove gasket. If flange shows signs of buffing wheel damage check with straight edge and flashlight. If light can be seen under straight edge of the component being checked (compressor side head or block flange) it should be replaced. Clean both surfaces with a solvent to remove any grease or oil. NEVER apply any other sealant to the gasket, it should be installed dry.
3. With a calibrated steel straight edge and feeler gauge, check discharge block flange and head flange face for flatness/straightness. Check along each edge and across each diagonal. No measurement should be more than .001".
4. Bolts should meet ASTM A193 Grade B7 for high temperature service. Grade 8 and grade 5 fasteners are not acceptable in high temperature service for pressure containing parts.
5. Washers should be *hardened* steel flat washers, .875" OD, .406" ID, .125" thick. Never use spring lock washers.
6. Install in a crisscross pattern across the flange with hand tools until hand tight, see figure 3. Torque the fasteners in order based on lubricated or non-lubricated chart. If there is any question with lubrication being on the bolt, the lower torque value should be used. Anti-seize is not required, but if used, only use very little on the first couple of threads and torque based on the lubricated value.

ATTENTION: Never use air tools or impacts to install the discharge flange.

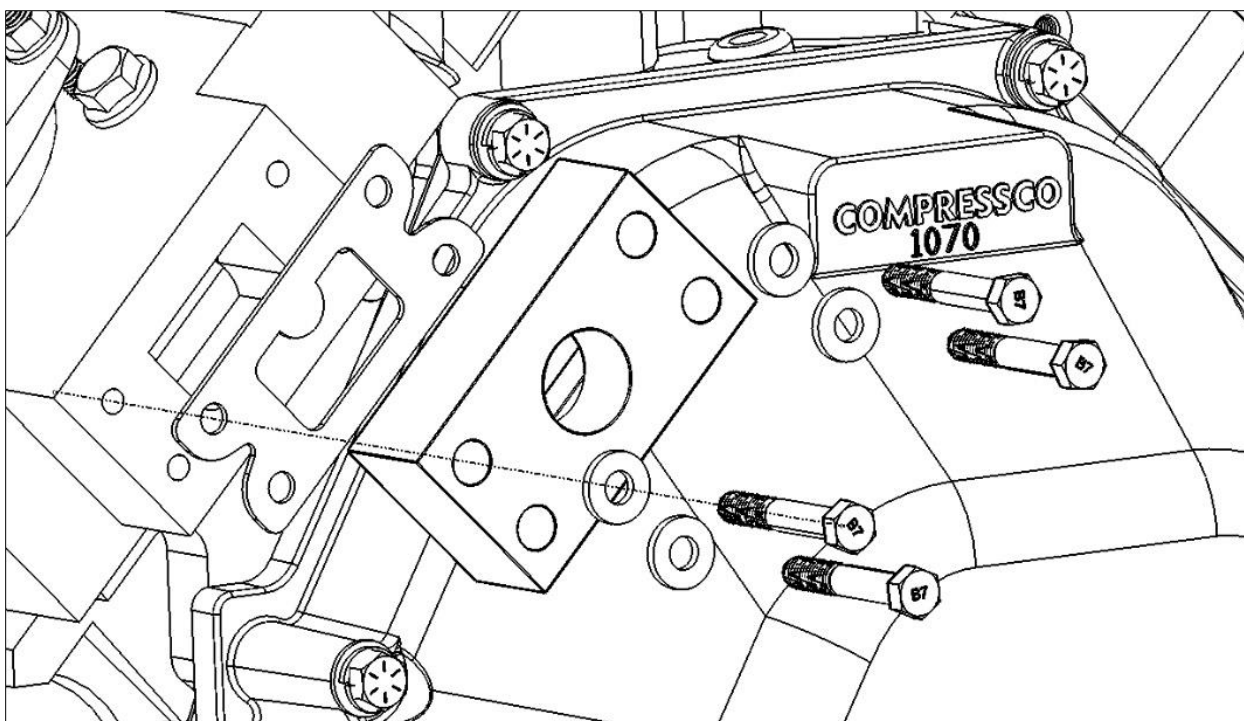


Figure 1: Exploded View

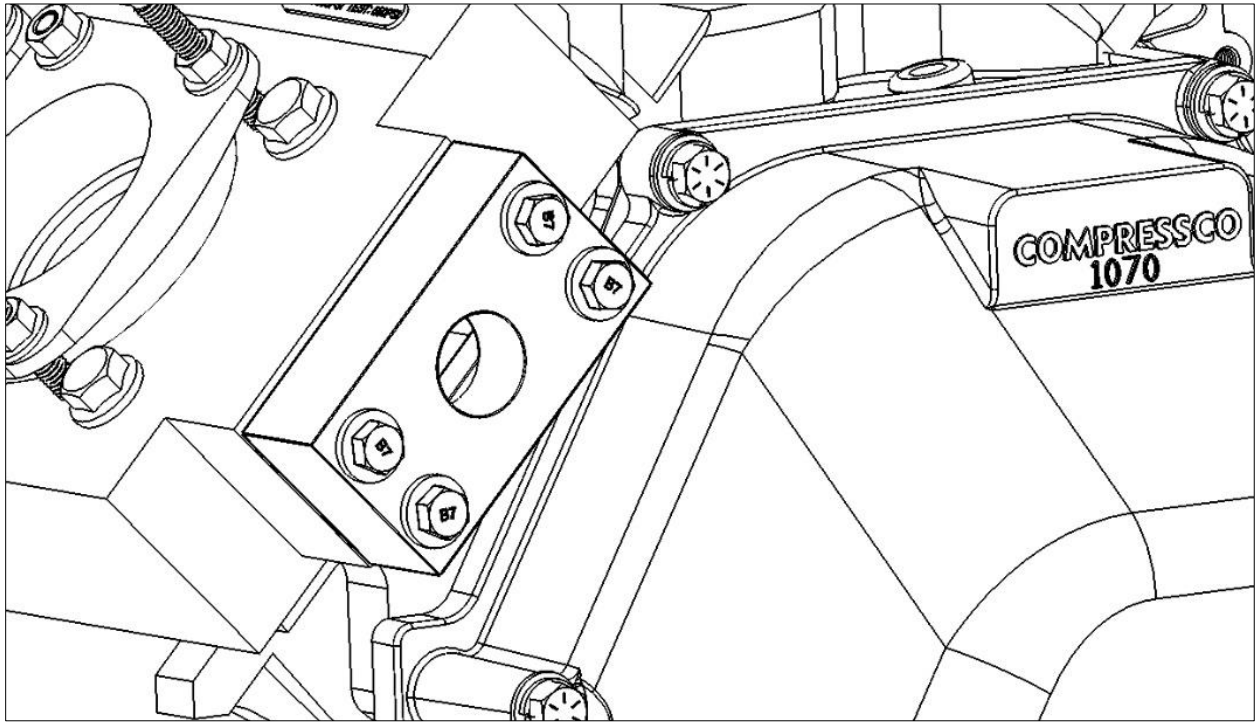


Figure 2: Assembled View

Table 1: Torque Values

3/8-16 A197 Grade B7 Cap Screw Torque	
Lubricated	Dry
24 ft-lbs.	32 ft-lbs.

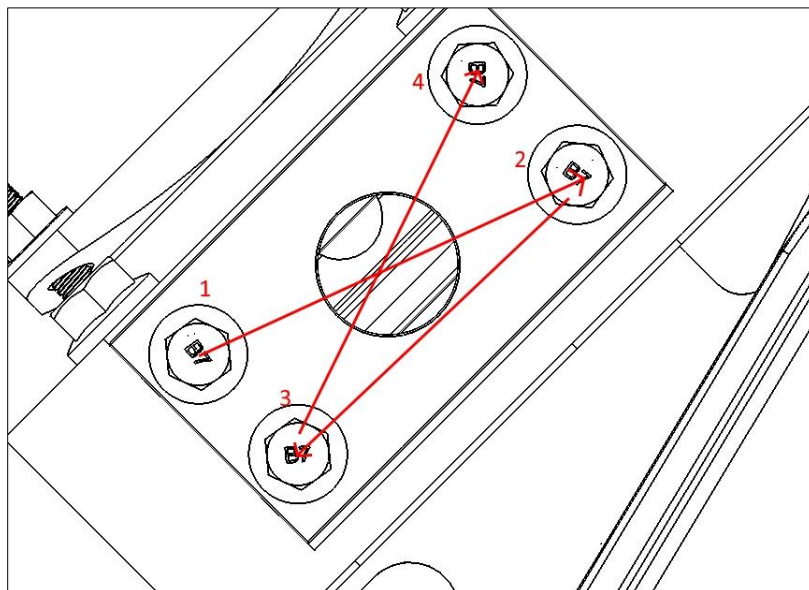


Figure 3: Tightening Pattern

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2.3 Restarting Unit and Additional Checks

- 2.3.1 Upon reassembly of unit and bringing back into service, CCLP Technician or Designee will use a portable gas monitor to ensure no leaks are found at discharge flange.
- 2.3.2 CCLP Technician or Designee must follow this process any time the compressor discharge block flange and/or gasket is replaced, compressor side head is replaced, or an engine swing is performed.

3. TRAINING

- 3.1 Operations Supervisor or Assigned Personnel tasked with any Gas Jack process must be trained and competent in the processes and procedures required to complete the scope of work.

4. RECORD KEEPING

- 4.1 All records of maintenance carried out will be filed and retained according to the TTI-Q-MS-01 Document and Records Control Procedure.

5. REFERENCE

- 5.1 N/A