2 Process Gas Compressor 1st Stage (CPM-XA48.1/.2/.3)

DOCUMENTATION LIST

Order No. FE15C704T1,FE15C710T1,FE15C711T1
Type AECKS2045630B7001 **Customer** Industrial Services International
Total Sets 3 **User**
Issued Date DEC.7.2015 **Customer PO.** 93E1769

Item	Drawing No.	Drawing Name	Rev	Item No.	Note
1	3A057H186-82524	Specification Table	07	--	Change
2	3A040V222	Outline Dimensions	07	--	Change
3	3B040Z270X1	Primary Terminal Box Schematic Drawing	00	01	Change
4	4B040M747	Neutral Point Terminal Box Schematic Drawing	02	01	Change
5	4B040D474	Heater Terminal Box Schematic Drawing	01	11	Change
6	4B040M432	WDG & BRG & Air RTD Common Terminal Box Schematic Drawing	00	03	Change
7	3A040D754	CT Terminal Box Schematic Drawing	25	01	Change
8	4B040L664	Shaft Schematic Drawing	02	--	Change
9	4B040M698	Primary Name Plate Schematic Drawing	00	--	Change
10	4A040U778	Spare Parts List Schematic Drawing	00	--	Change
11	3A061H419	SCHEMATIC STATOR CONNECTION	00	--	Change
12	3A061H574	SCHEMATIC SPACE HEATER	00	--	Change
13	FE15C704T1-T-I-L	T-N/I-N VS Load Curve	00	--	Change
14	FE15C704T1-E-P-L	Eff & Pf VS Load Curve	00	--	Change
15	FE15C704T1-TIME	Time-Current and Thermal Limit Curve	00	--	Change
16	FE15C704T1-PS	Painting Specification	00	--	Change

FINAL AS BUILT
FE15C704T1,FE15C710T1,
ORDER NO. FE15C711T1

TECO ELEC. & MACH. CO., LTD.

DOC NO.
FE15C704T1
REV.08 1 / 1

SPECIFICATION TABLE OF 3-PHASE SQUIRREL CAGE INDUCTION MOTOR	CUSTOMER	Industrial Services International	USER	G.I.S.D.Co
	INQ. NO.		EQUIPMENT	Process Gas Compressor 1st stage
	JOB NO.	FE15C704T1,FE15C710T1 FE15C711T1	MACHINE	
	TOTAL SETS	3	ITEM NO.	MN-CPA48.1/2/3

Item	Terms	Description			
1	Model	AECK-S2			
2	Code or Standard	Dimensions	Frame Assignment	Performance	Test
		IEC	TECO	IEC	IEC
3	Rating	4200 kW 4 Pole 11000 Volt 3 Phase 50 Hz			
4	Service Duty	Continuous Rating , S.F. 1.15			
5	Starting Method	D.O.L. or 80% R.V.S.			
6	Rotation	Facing The Drive End : CCW			
7	Drive Method	Direct Coupling			
8	Environment	Amb. Temp. : -14.8 ~ 50 ℃			
		Humidity : Less Than 54 %RH			
		Altitude : Up to 1720 M			
9	Enclosure & Protection	IPW55 : Totally Enclosed Outdoor			
10	Cooling	IC611 : Fan Cooled With Built-in Air Cooler			
11	Mounting	IM1001 : HS, Foot			
12	Dimensions	Dr# 3A040V222 (REV.07) Frame No : 800C			*
13	Frame & Bracket	Frame : Steel Plate Bracket : Steel Plate			
14	Fan & Fan Cover	Fan :Aluminum Fan Cover :Steel Plate			
15	Terminal Box	Steel Plate			
16	Lead Terminals	(TLK70-10)X6			
17	Lubricant	Oil Viscosity : ISO VG68			
18	Painting	Color : RAL 7032			
19	Stator Winding	Ins. Class F			
20	Rotor Conductor	Cu-Alloy GD^2 : 1612 Kg-m^2			
21	Starting Performance	LRC/FLC 550 % LRT/FLT 80 %			
22	Operating Performance	Hz/V	50/11000		Break Down Torque
		%Load	100	75	50	220 %FLT
		Amp.	255	196	137	
		Eff.%	96.1	96.0	95.8	Temp. Rise Limit. (Res.)
		P.F.%	90.0	88.0	84.0	Stator 70 ℃
		R.P.M.	1493	1495	1496	at S.F.1.0 & 1720M A.S.L.
23	Approximate Weight	Motor : 22000kg Rotor : 5250kg			
24	Note	1. With Space Heater : 1φ 230V 1377W 2. With Winding RTD : PT 100Ω/0℃ 6pcs 3. With Bearing RTD : PT 100Ω/0℃ 4pcs (dual) 4. With Air RTD : PT 100Ω/0℃ 2pcs (dual) 6. Corrosion & Tropic Proof 7. Load GD2 = 1670kg-m2 8. Acceleration Time at 100% rated voltage = 10 sec 9. Acceleration Time at 80% rated voltage = 32 sec 10.Starting Current/Nominal Current = 550% 11.Pull Out Torque = 220% Full Load Torque Note : [*] at the end represent revised item ◦			

FINAL AS BUILT
Order No. FE15C704T1,FE15C710T1 FE15C711T1

APPD.	Spencer Chien	NOV. 13 2015	TECO ELEC. & MACH. CO., LTD.	DWG NO. 3A057H186-82524
CHKD.	Andrea	NOV. 13 2015		REV.07 1/2
DWN.	Alice	NOV. 13 2015		

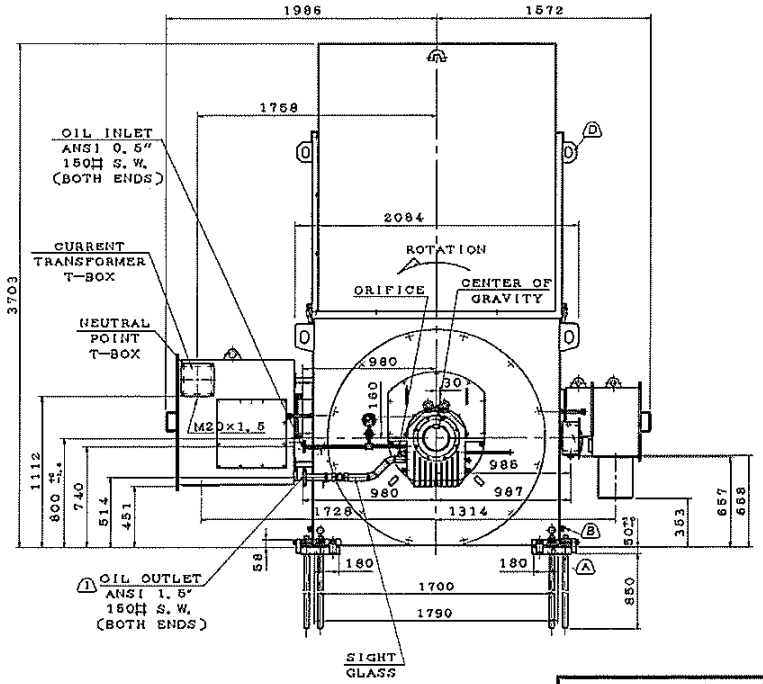
Item	Terms	Description
24	Note	12.Stall Torque = 2211 kg-m 13.With Shaft Key 14.With Sole Plate, Packing Shims. 15.Painting: Min. paint thickness shall be 150 micron in 2 or 3 layers. 17.Noise : Below 85 dBA at 1 Meter Distance No Load. 18.Vibration: Below 50μm(P-P) On Shaft No Load Below 1.8mm/sec(RMS) on Bearing Housing No Load 19.NDE Bearing Is Insulated. 20.Coupling would be supplied by ISI but attaching of the half- coupling onto the motor shaft end shall be included in the manufacturer's scope of work, before shop running test. 21.Two earhing Terminal on the motor frame. 22.Earhing Terminal in the terminal boxes 23.With Foundation nuts and bolts. 24.Rotor balance shall be as per quality G1.0 FINAL AS BUILT Order No. FE15C704T1,FE15C710T1 FE15C711T1 Note : [*] at the end represent revised item。

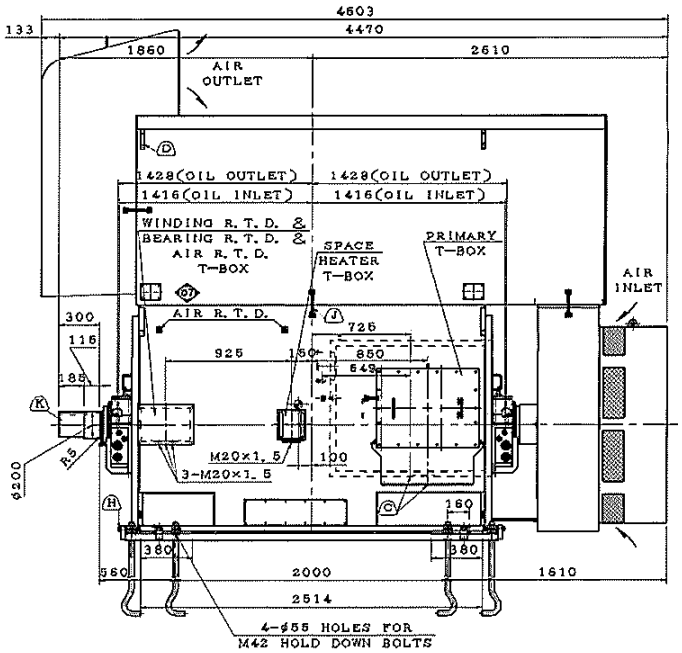
TECO ELEC. & MACH. CO., LTD.

DWG NO.
3A057H186-82524
REV.07 2/2

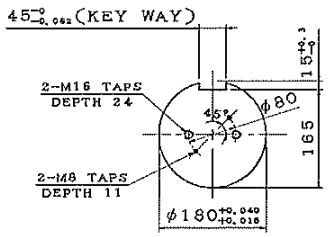
TYPE	OUTPUT HP.	OUTPUT kW.	POLE	TIME RATING	VOLTAGE V	Hz	SYN. SPEED R. P. M.
AECK-52		4200	4	CONT	11000	50	1500

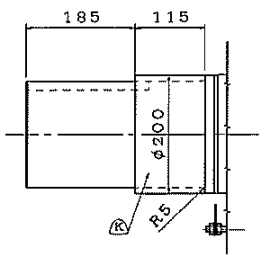
TOTALLY ENCLOSED AIR-TO-AIR COOLED TYPE, SQUIRREL CAGE ROTOR



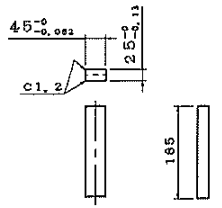


FINAL AS BUILT
Order No. FE15C704T1, FE15C710T1
FE15C711T1

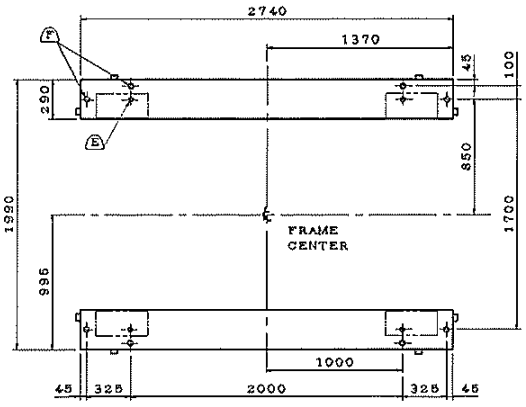




SHAFT END
(ENLARGED VIEW)



DETAIL OF KEY
(ENLARGED VIEW)



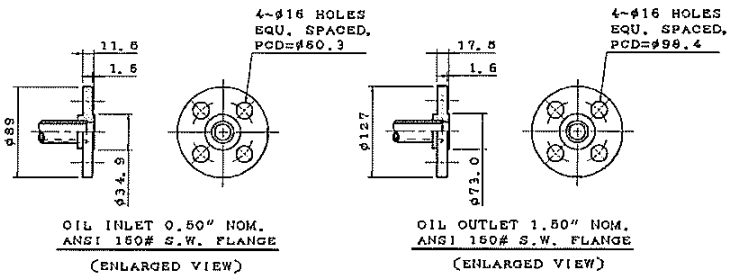
Ⓖ SOLEPLATE DETAIL

			TECO	OUTLINE DIMENSIONS
			DATE	3-PHASE INDUCTION MOTOR
DWN.	S. WANG	JUL 09 2015	東元電機股份有限公司 TECO Elec. & Mach. Co., Ltd.	DWG NO. 3A040V222
CHKD.	S. WANG	JUL 14 2015		
APPD.	C. LIU	JUL 14 2015		REV:07

TYPE	OUTPUT HP.	OUTPUT kW.	POLE	TIME RATING	VOLTAGE V	Hz	SYN. SPEED R. P. M.
AECK-S2		4200	4	CONT	11000	50	1500

TOTALLY ENCLOSED AIR-TO-AIR COOLED TYPE. SQUIRREL CAGE ROTOR

NOTE:
1. DIMENSIONS IN mm.
2. FRAME NO. 800C.
3. F CLASS INSULATION. S. F. :1. 15.
4. FOR DIRECT FLEXIBLE COUPLING.
5. SLEEVE TYPE BEARING. AXIAL THRUST LOAD NOT ALLOWED.
6. THE MOTOR ENDPLAY IS ±7mm. A LIMITED END FLOAT TYPE COUPLING IS REQUIRED TO LIMIT ENDPLAY TO ±2. 4mm.
7. BEARING SIZE: DRIVE END: 18-180(UNINSULATED)
   NON-DRIVE END: 18-160(INSULATED)
8. NON-DRIVE END BEARING LINER(SHELL) IS INSULATED FROM THE HOUSING. METAL CONNECTIONS MADE TO THE BEARING SHELL MUST BE INSULATED TO PREVENT AN INSULATION SHORT CIRCUIT. METAL CONNECTIONS MADE TO THE HOUSING DO NOT NEED TO BE INSULATED.
9. BEARING LUBRICATION: FORCED OIL LUBRICATION
   A. OIL VISCOSITY: ISO VG68(275~325SSU AT 100°F)
   B. OIL FLOW RATE: DRIVE END: 5. 5~6. 8 L/min.
   NON-DRIVE END: 5. 5~6. 8 L/min.
   C. OIL INLET PRESSURE: 2. 0~3. 0 barG.
   D. OIL INLET ORIFICE DIAMETER: DRIVE END: 2. 4mm.
   NON-DRIVE END: 2. 4mm.
   E. OIL INLET TEMPERATURE: 35°C~55°C.
   F. EXTERNAL OIL SUPPLY UNIT TO BE PREPARED BY THE CUSTOMER.
10. WITH SPACE HEATER:1φ, 230V, 1377W.
11. WITH WINDING R. T. D. : PT 100Ω/0°C, 6PCS.
12. WITH BEARING R. T. D. : PT 100Ω/0°C, DUAL ELEMENTS. 4PCS. (2 PER BEARING)
13. WITH AIR R. T. D. : PT 100Ω/0°C, DUAL ELEMENTS. 2PCS.
14. CURRRENT TRANSFORMERS TO BE SUPPLIED AND INSTALLED BY CUSTOMER.
15. WITH ADJUSTMENT SHIMS (ONE PER FOOT TOTAL 3. 6mm):
    0. 1mm(2PCS), 0. 2mm(2PCS), 0. 5mm(2PCS), 1. 0mm(2PCS).
16. VIBRATION:BELOW 1. 8mm/s(RMS) ON BEARING HOUSING NO LOAD.
17. NOISE:BELOW 85dBA AT ONE METER DISTANCE NO LOAD.
18. ENCLOSURE:IPW55, OUTDOOR SERVICE.
19. CORROSION PROOF & TROPIC PROOF.
20. MOTOR APPROX. WEIGHT:22000kg.
    ROTOR APPROX. WEIGHT:5250kg.
21. TECO IS NOT RESPONSIBLE FOR FOUNDATION DESIGN. THE SUPPORT REACTIONS NECESSARY FOR FOUNDATION DESIGN ARE AS FOLLOWS —kgf PER BOLT AT CENTERLINE OF HOLD DOWN BOLT HOLES:
    STATIC X = MOTOR WEIGHT/4
    RATED MOTOR TORQUE X = MOTOR WEIGHT/4 ± 923 kgf.
    MAXIMUM MOTOR TORQUE X = MOTOR WEIGHT/4 ± 7401 kgf.

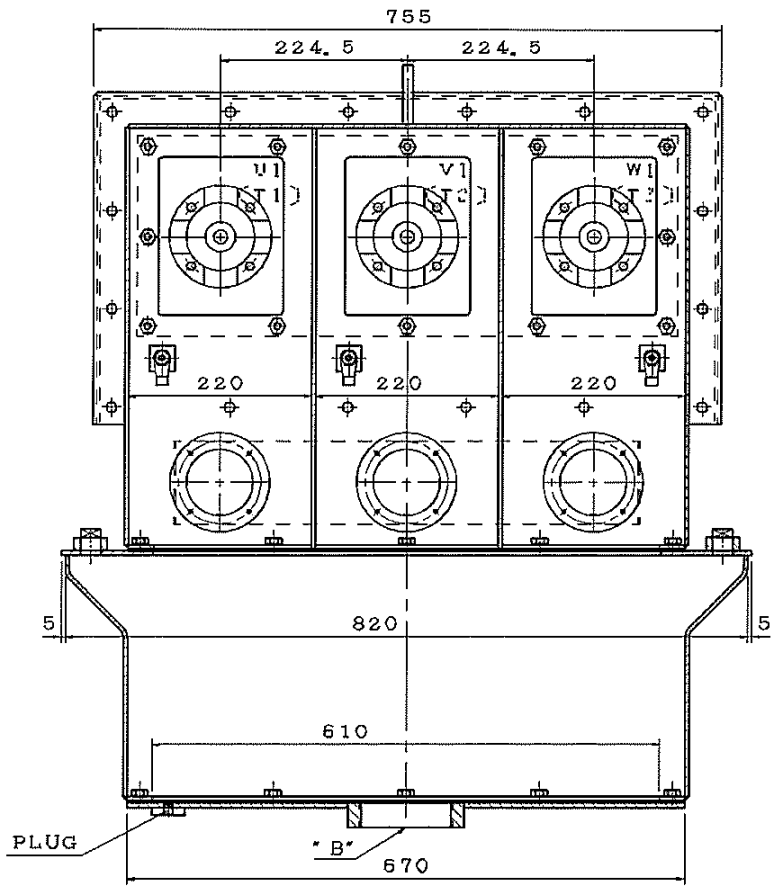


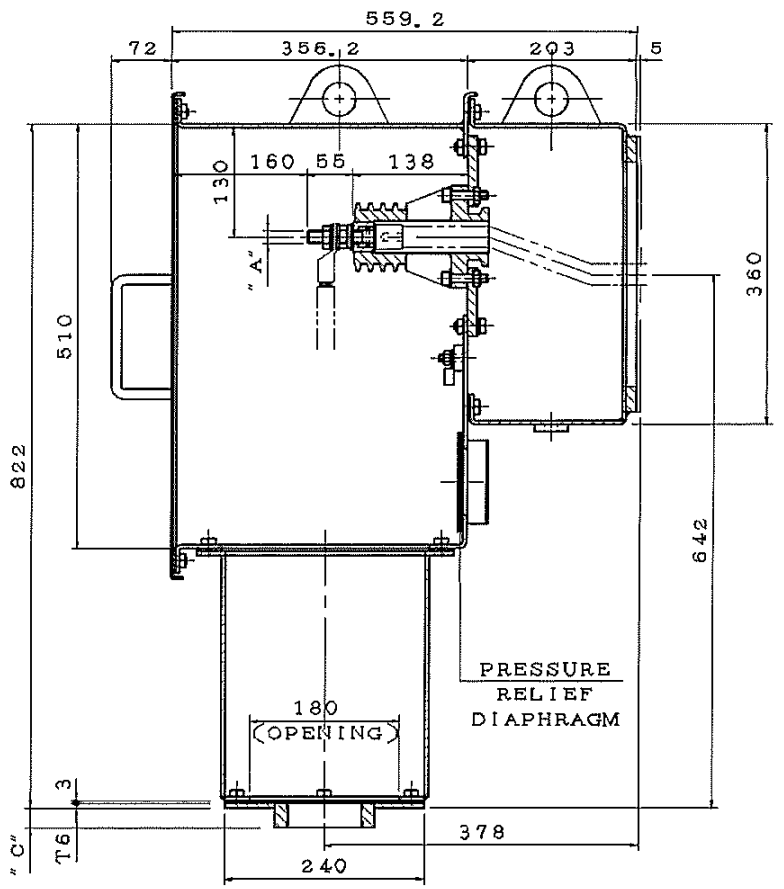
FINAL AS BUILT
Order No. FE15C704T1,FE15C710T1 FE15C711T1

Ⓐ M20 VERTICAL JACKING HOLE. ONE HOLE PER FOOT. WITH VERTICAL JACKING SCREWS 4PCS. MOUNTED ON FOOT.
Ⓑ FOUR M12 TAPPED GROUNDING PADS, WITH TWO GROUNDING STUD & (R60-12) TERMINAL LOCATED AS SHOWN.
Ⓒ REMOVABLE COVER FOR CABLE ENTRY TO BE DRILLED BY THE CUSTOMER.
Ⓓ FOUR LIFTING LUGS FOR LIFTING AIR CABINET AND HEAT EXCHANGER ONLY. DO NOT USE FOR LIFTING MOTOR.
Ⓔ φ55 HOLE THRU FRAME FOOT. M42 TAPPED HOLE THRU SOLEPLATE FOR M42 HOLD DOWN BOLTS. (1 HOLE PER FOOT, 4 HOLES TOTAL.)
Ⓕ φ42 HOLE THRU SOLEPLATE FOR M36 FOUNDATION BOLTS (8 PLACES).
Ⓖ SOLEPLATES TO BE SHIPPED LOOSE WITH MOTOR.
Ⓗ M20 ADJUSTMENT STUD, 8 PLACES.
Ⓘ OIL DRAIN LINES SHOULD BE SLOPED A MINIMUM OF 45mm PER METER. FOR PROPER DRAINING, A VENT MUST BE PLACED IN THE DRAIN LINES AS CLOSE TO THE MOTOR BEARINGS AS POSSIBLE.
Ⓙ BONDING STRAPS.
Ⓚ SHAFT SLEEVE.
Ⓛ ANCHOR BOLTS AND NUTS ARE SUPPLIED BY KSL.

DWN.	S. WANG	JUL 09 2010
CHKD.	S. WANG	JUL 14 2010
APPD.	C. LIU	JUL 14 2010

TECO
DATE
OUTLINE DIMENSIONS
3-PHASE INDUCTION MOTOR
東元電機股份有限公司
TECO Elec. & Mach. Co., Ltd.
DWG NO. 3A040V222
REV:07





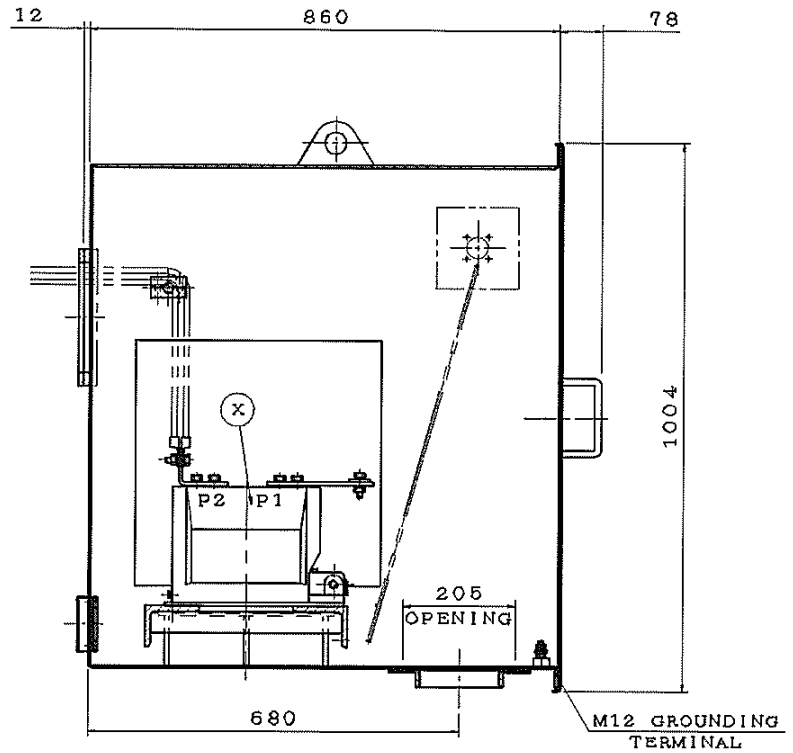
ITEM	"A"	"B"	"C"
010	M16	0	0
020	M12	0	0
030	M10	0	0
040	M8	0	0
050	M16	NPT4"	30
060	M12	NPT4"	30
070	M10	NPT4"	30
080	M8	NPT4"	30
090	M16	NPT3"	30

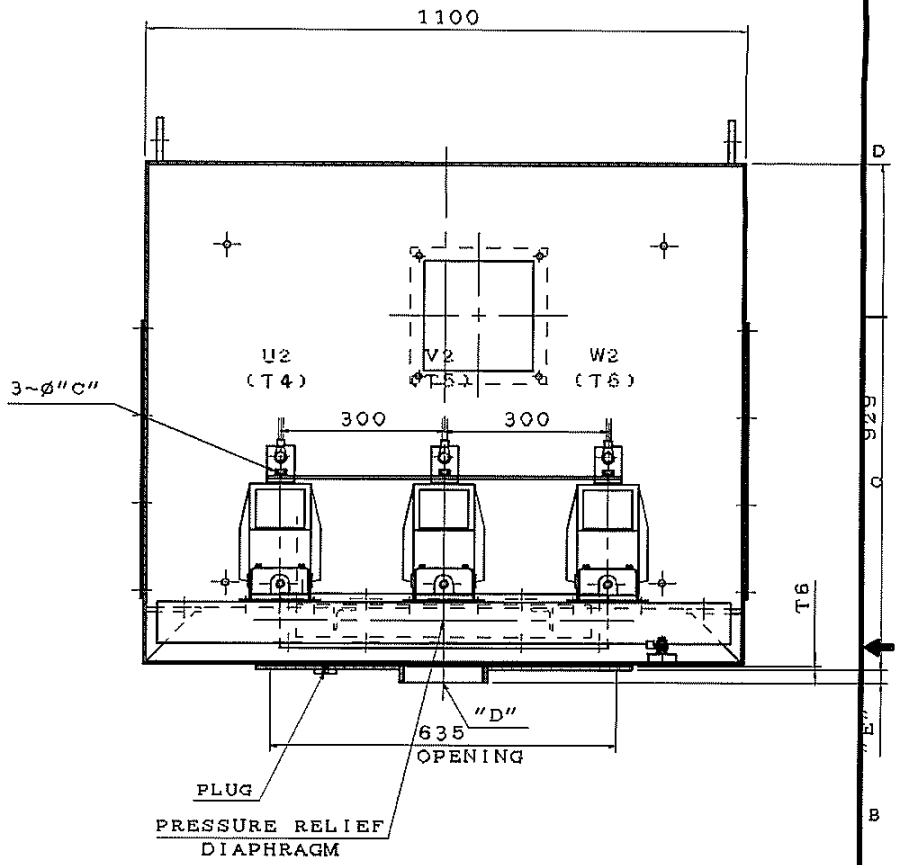
FINAL AS BUILT
Order No FE15C704T1,FE15C710T1 FE15C711T1

NOTE: 1. DIMENSIONS IN mm.
2. PRIMARY T-BOX
3. VOLTAGE:11KV

DWN.	S. WANG	AUG 08 2018
CHKD.	S. WANG	AUG 07 2018
APPD.	C. LIU	AUG 07 2018

TECO
DATE
SCHEMATIC DRAWING
TERMINAL BOX
東元電機股份有限公司
TECO Elec. & Mach. Co., Ltd.
DWG NO. 3B040Z270X1
REV:00





ITEM	C	D	E
01	11	0	0
02	13	0	0
03	17	0	0
04	11	NPT3"	24
05	13	NPT3"	24
06	17	NPT3"	24
07	11	NPT4"	24
08	13	NPT4"	24
09	17	NPT4"	24
10			

FINAL AS BUILT
Order No. FE15C704T1,FE15C710T1 FE15C711T1

NOTE:
1. DIMENSIONS IN mm.
2. NEUTRAL POINT T-BOX.
3. ENCLOSURE: IP65.

(X) CURRENT TRANSFORMERS TO BE SUPPLIED AND INSTALLED BY CUSTOMER.

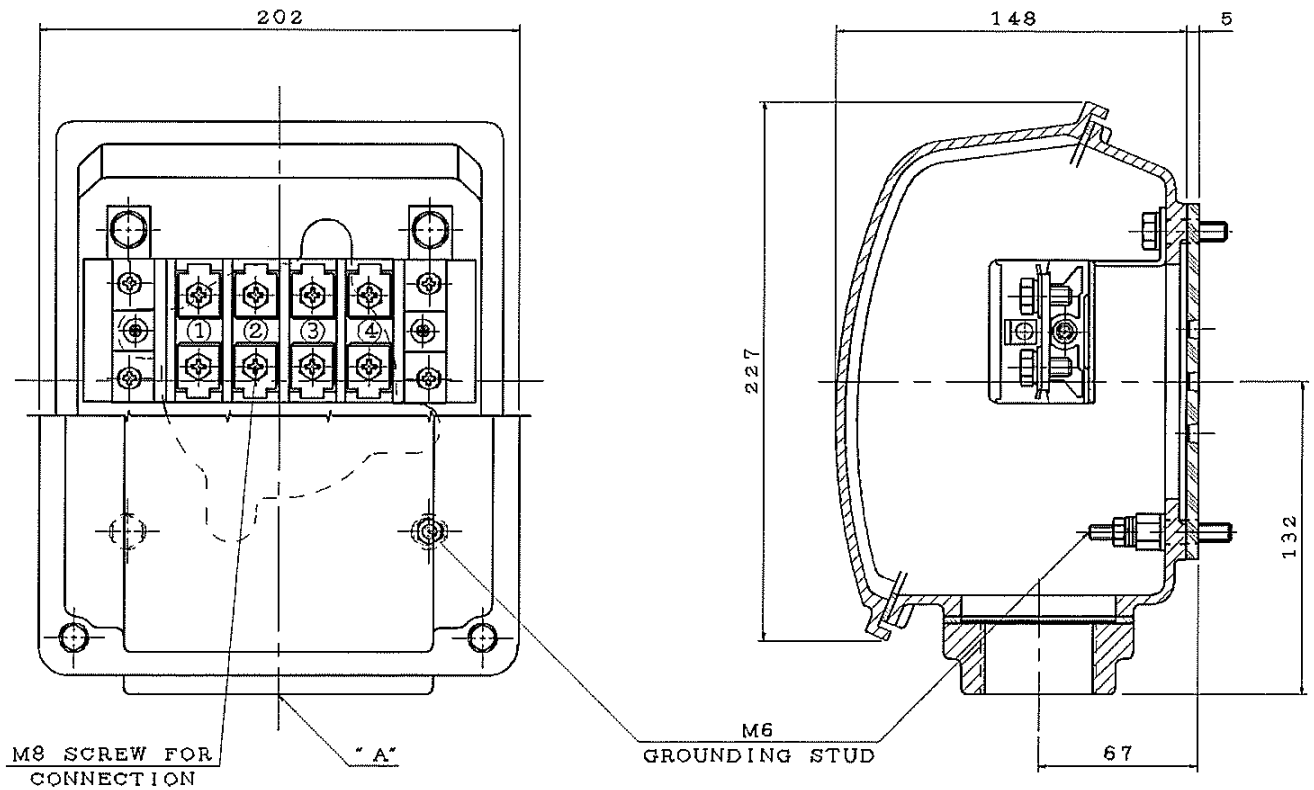
DWN.	S. WANG	AUG 05 2015
CHKD.	S. WANG	AUG 07 2015
APPD.	C. LIU	AUG 07 2015

TECO
DATE

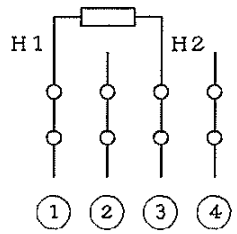
SCHEMATIC DRAWING
TERMINAL BOX

東元電機股份有限公司
TECO Elec. & Mach. Co., Ltd.

DWG NO. 4B040M747
REV:02



ITEM	A
01	PF-1″
02	PF-1.5″
03	PF-2″
04	NPT-1″
05	NPT-1.5″
06	NPT-2″
07	M25×1.5
08	M32×1.5
09	M50×1.5
10	NPT-0.75″
11	M20×1.5
12	NPT-0.25″
13	
14	
15	
16	
17	
18	
19	
20	

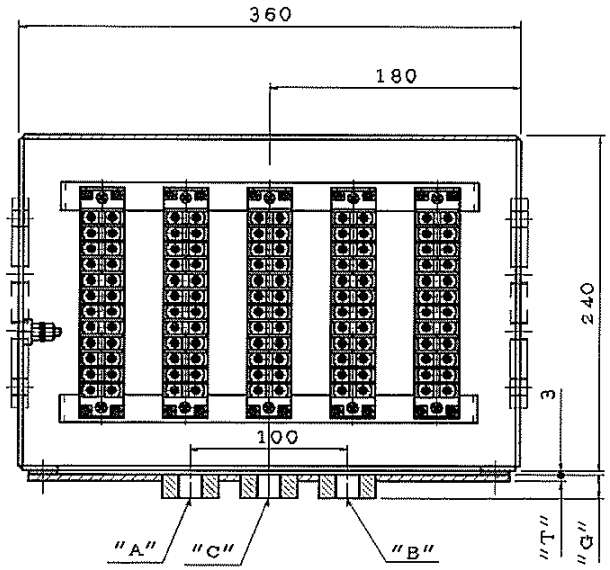


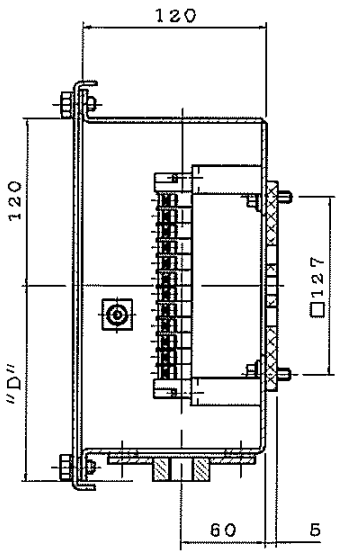
FINAL AS BUILT
Order No. FE15C704T1,FE15C710T1 FE15C711T1

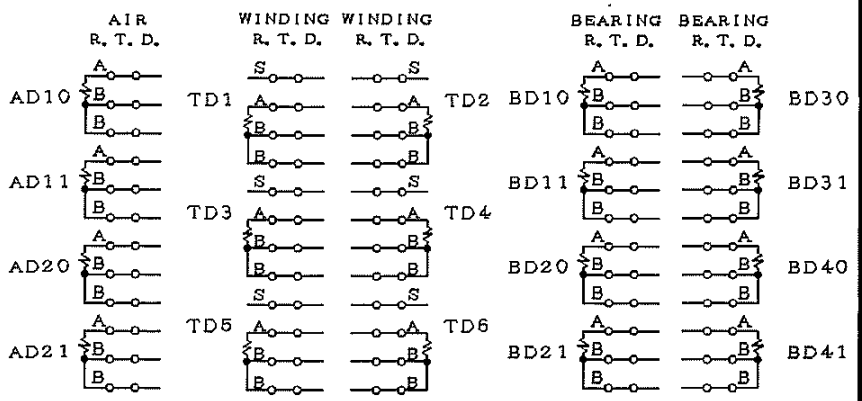
NOTE:
1. DIMEMSION IN mm.
2. TW—36.
3. SPACE HEATER T—BOX.

DWN.	C. LEONG	JUL 25 2013
CHKD.	S. WANG	JUL 26 2013
APPD.	B. LIN	JUL 26 2013

TECO
DATE
SCHEMATIC DRAWING
TERMINAL BOX
東元電機股份有限公司
TECO Elec. & Mach. Co., Ltd.
DWG NO. 4B040D474
REV:01



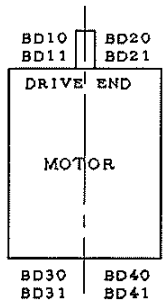




FINAL AS BUILT

Order No. FE15C704T1,FE15C710T1 FE15C711T1

ITEM	A	B	C	D	G	T
01	0	0	0	127.5	4.5	4.5
02	NPT2"	NPT1"	0	143	20	4.5
03	M20×1.5	M20×1.5	M20×1.5	143	20	4.5
04						
05						
06						
07						
08						
09						
10						



VIEW FROM TOP

NOTE:
1. DIMENSIONS IN mm
2. WINDING R. T. D., BEARING R. T. D. & AIR R. T. D. T—BOX.
3. TD1 & TD2 FOR U PHASE
   TD3 & TD4 FOR V PHASE
   TD5 & TD6 FOR W PHASE
   BD10, BD11, BD20 & BD21 FOR DRIVE END BEARING
   BD30, BD31, BD40 & BD41 FOR NON—DRIVE END BEARING.
   AD10 & AD11 FOR HOT AIR
   AD20 & AD21 FOR COLD AIR.
4. TERMINAL SIZE: R1.25—3.7 to R2—4.

DWN.	S. WANG	JUL 22 2015
CHKD.	S. WANG	JUL 22 2015
APPD.	C. LIU	JUL 22 2015

TECO

DATE

SCHEMATIC DRAWING

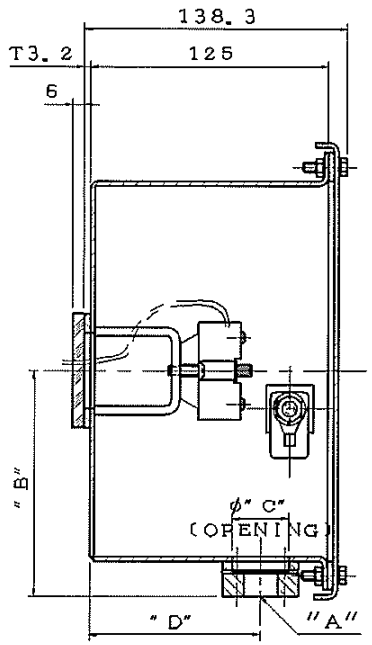
TERMINAL BOX

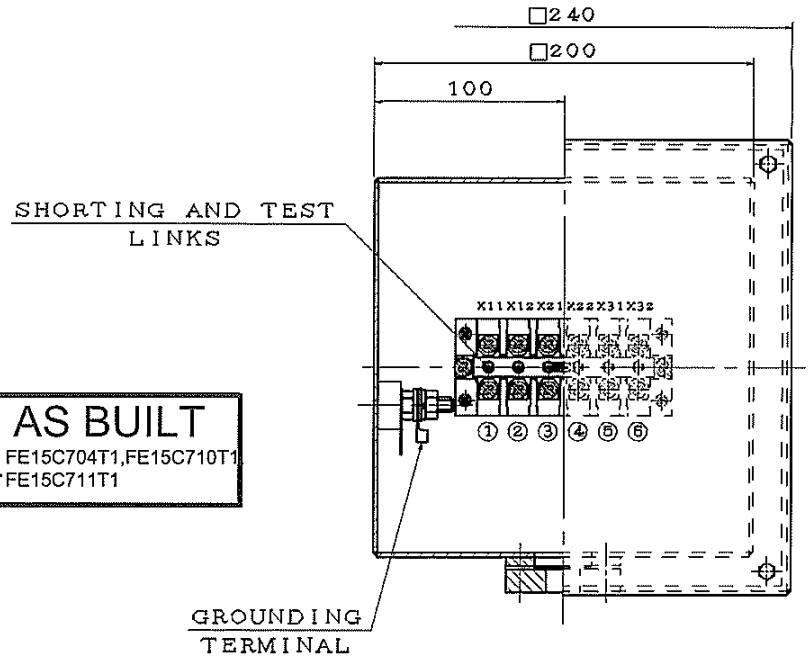
東元電機股份有限公司
TECO Elec. & Mach. Co., Ltd.

DWG NO. 4B040M432

REV:00

1/1

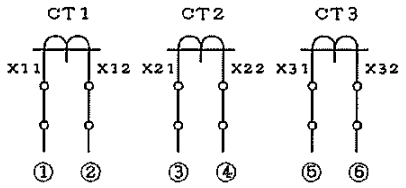




FINAL AS BUILT
Order No. FE15C704T1,FE15C710T1, FE15C711T1

ITEM	A	B	C	D
01	M20×1.5	118.5	30	90
02	NPT0.75"	118.5		
03	PF0.75"	118.5		
04	NPT1"	118.5		
05	0	112.5		
06	BPT1.5"	118.5	50	75
07	NPT2"	118.5	30	90
08	NPT1.25"	118.5	50	75
09	NPT2"	118.5	50	75
10	PF1"	118.5	30	90
11	NPT1.5"	122.5	50	75
12	M32×1.5	122.5	50	75
13	M25×1.5	118.5	50	75
14	NPT0.5"	118.5	30	75

CURRENT TRANSFORMER



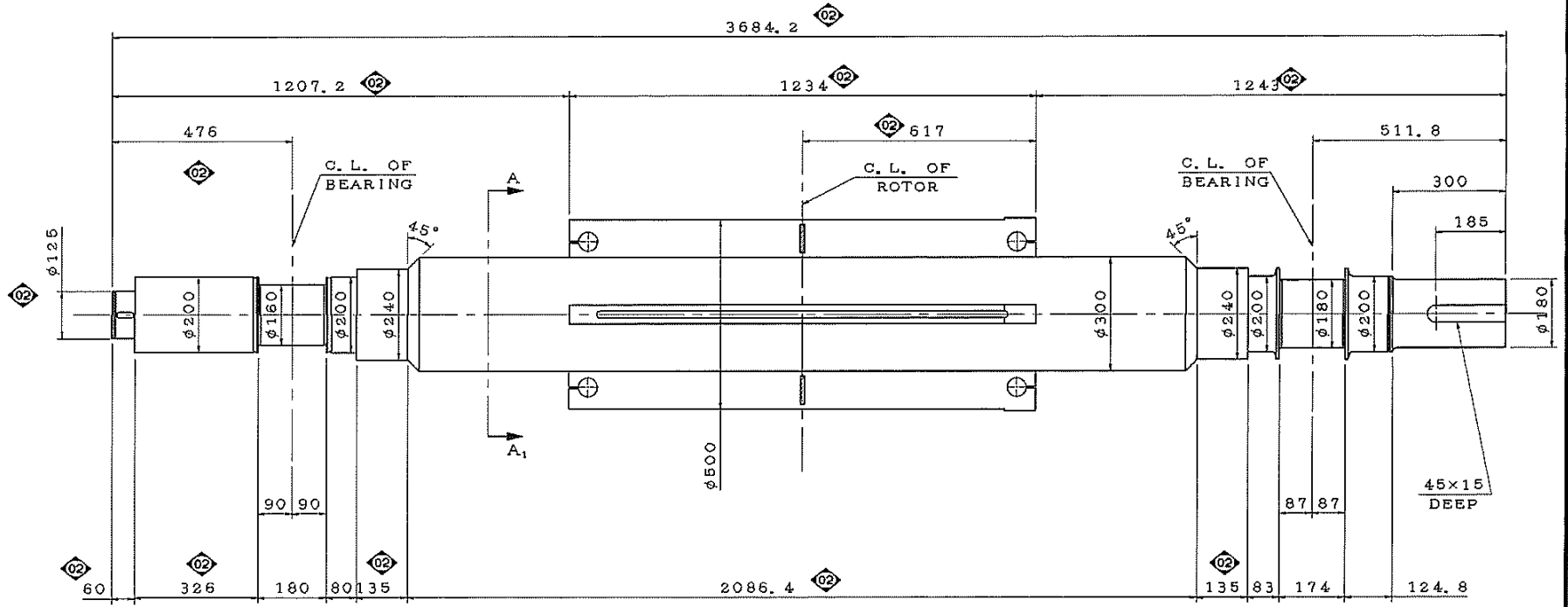
NOTE:
1. DIMENSIONS IN mm.
2. CURRENT TRANSFORMER T—BOX.
3. ENCLOSURE: IPW55.

DWN.	S. WANG	FEB. 21, 2001
CHKD.	B. YANG	FEB. 21, 2001
APPD.	T. CHEN	FEB. 21, 2001

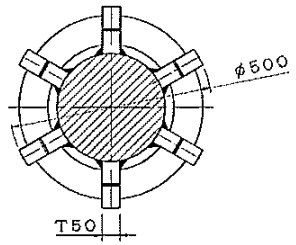
TECO
DATE
SCHEMATIC DRAWING
TERMINAL BOX
東元電機股份有限公司
TECO Elec. & Mach. Co., Ltd.
DWG NO. 3A040D754
REV:25

NONE—DRIVE END

DRIVE END



FINAL AS BUILT
Order No FE15C704T1,FE15C710T1, FE15C711T1



VIEW A—A1

NOTE:
1. DIMENSIONS IN mm.

TORSIONAL ANALYSIS DATA

MOTOR WR²: 403.0 kg—m²

SHAFT TORSIONAL STIFFNESS: 1.22E09 kgf—mm/rad
(FROM ROTOR CENTERLINE TO COUPLING END OF SHAFT) (FOR REFERENCE ONLY)

SHAFT MATERIAL: JIS G 4105 SCM430 (AISI 4130 EQUIV.)
SPIDER PLATE: ASTM A36

SHAFT ULTIMATE TENSILE STRENGTH: 85 kgf/mm² MIN

SHAFT YIELD STRENGTH IN TENSION: 75 kgf/mm² MIN

SHAFT SHEAR MODULUS OF RIGIDITY: 8300 kgf/mm²

DWN.	S. WANG	JUL 13 2018
CHKD.	S. WANG	JUL 14 2018
APPD.	C. LIU	JUL 14 2018

TECO

DATE

SCHEMATIC DRAWING

SHAFT

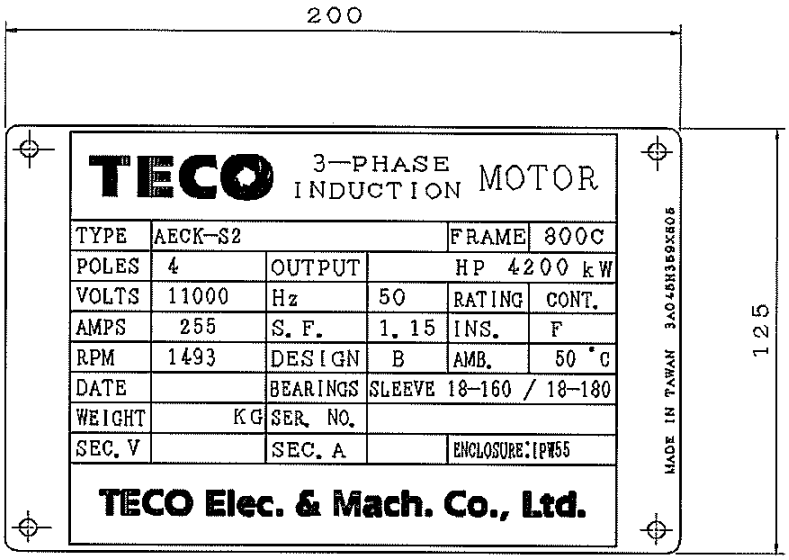
東元電機股份有限公司
TECO Elec. & Mach. Co., Ltd.

DWG NO. 4B040L664

REV:02

1/1

TECO	SCHEMATIC DRAWING	MODEL
DATE	NAME PLATE	



FINAL AS BUILT
Order No. FE15C704T1, FE15C710T1 FE15C711T1

NOTE:
1. DIMENSION IN mm.
2. SER. NO. FE15C704T1—1,
FE15C710T1—1,
FE15C711T1—1.
3. MATERIAL: SUS304.

DWN.	S. WANG	JUL 09 2018	TECO Electric & Machinery Co., Ltd.	DWG NO. 4B040M698	REV:00
CHKD.	S. WANG	JUL 14 2018			
APPD.	C. LIU	JUL 14 2018			

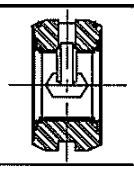
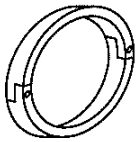
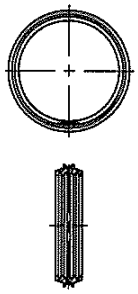
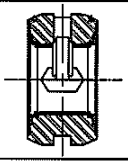
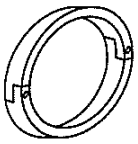
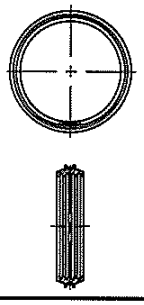
TECO	RECOMMENDED	MODEL
DATE	SPARE PARTS LIST	

CUSTOMER:

MACHINE: 4P—4200kW MOTOR

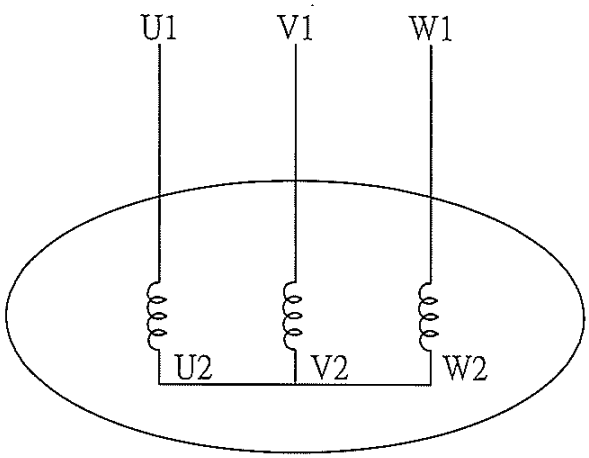
ORDER NO: FE15C704T1(TOTAL UNIT:1)
FE15C710T1(TOTAL UNIT:1)
FE15C711T1(TOTAL UNIT:1)

FINAL AS BUILT
Order No. FE15C704T1,FE15C710T1 FE15C711T1

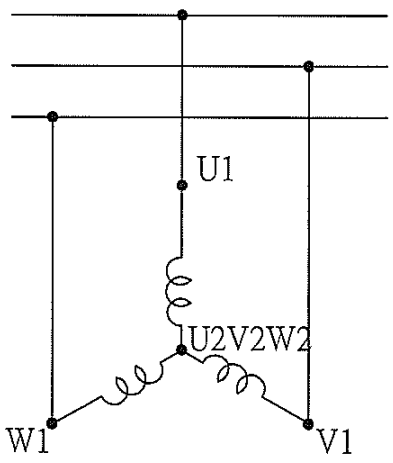
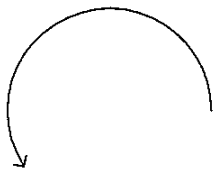
ITEM	PART NAME	SKETCH	SPEC.	QUANTITY		PART NUMBER
				WORKING FOR 1 SET	TOTAL (PCS/UNIT)	
1	SLEEVE BEARING		BRG SIZE #18—180 (D. E.)	1	1	3A231C0152100
2	OIL RING		BRG SIZE #18 (D. E.)	1	1	3A236C0250302
3	FLOATING LABYRINTH SEAL		BRG SIZE #18 (D. E.)	2	2	3A206C0080700
1	SLEEVE BEARING		BRG SIZE #18—160 (N. D. E.)	1	1	3A231C0152002
2	OIL RING		BRG SIZE #18 (N. D. E.)	1	1	3A236C0250302
3	FLOATING LABYRINTH SEAL		BRG SIZE #18 (N. D. E.)	2	2	3A206C0080700

DWN.	S. WANG	NOV 30 2011	**TECO Electric & Machinery Co., Ltd.**	DWG NO. REV:00
CHKD.	S. WANG	NOV 30 2011		4A040U778
APPD.	B. LIN	NOV 30 2011		

DATE	SCHEMATIC WYE CONN 6 LEADS	MODEL



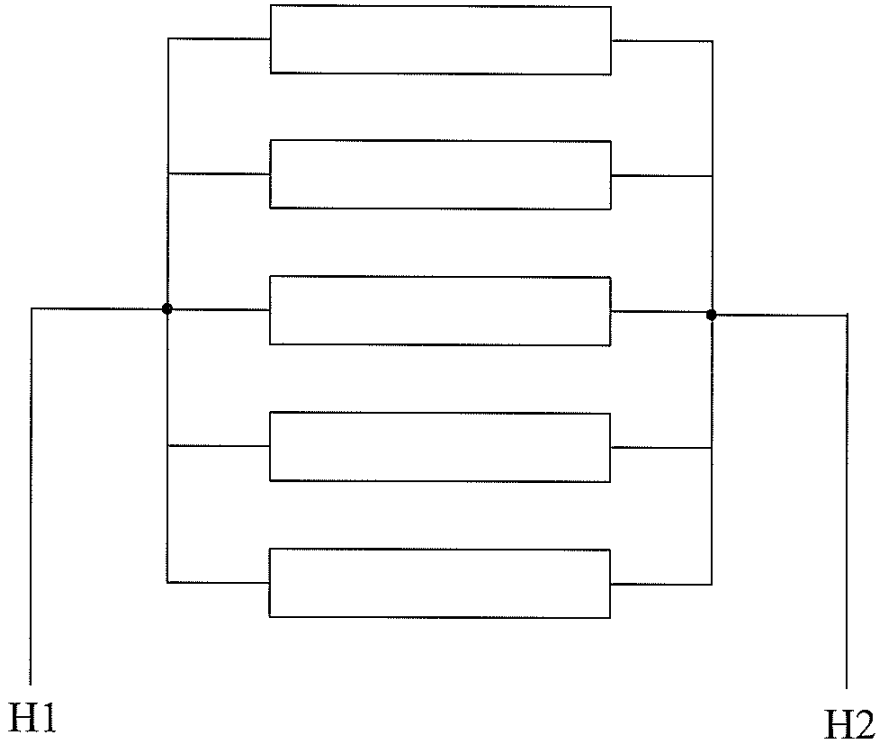
SCHEMATIC - WYE CONN - 6 LEADS

CONNECTION	ROTATION (VIEWED FROM DRIVE END)
	

FINAL AS BUILT
Order No. FE15C704T1,FE15C710T1
FE15C711T1

DWN.	S.HUANG	MAR・03・2003	TECO ELEC. & MACH. CO., LTD.	DWG NO. REV: 00
CHKD.	T.HSIAO	MAR・03・2003		3A061H419
APPD.	T.HSIAO	MAR・03・2003		

DATE	SCHEMATIC SPACE HEATER	MODEL



FINAL AS BUILT
Order No. FE15C704T1,FE15C710T1
FE15C711T1

DWN.	ANDREA	JUL • 03 • 2012	TECO ELEC. & MACH. CO., LTD.	DWG NO. REV: 00
CHKD.	HB.LIN	JUL • 03 • 2012		3A061H574
APPD.	H.CHIANG	JUL • 03 • 2012		

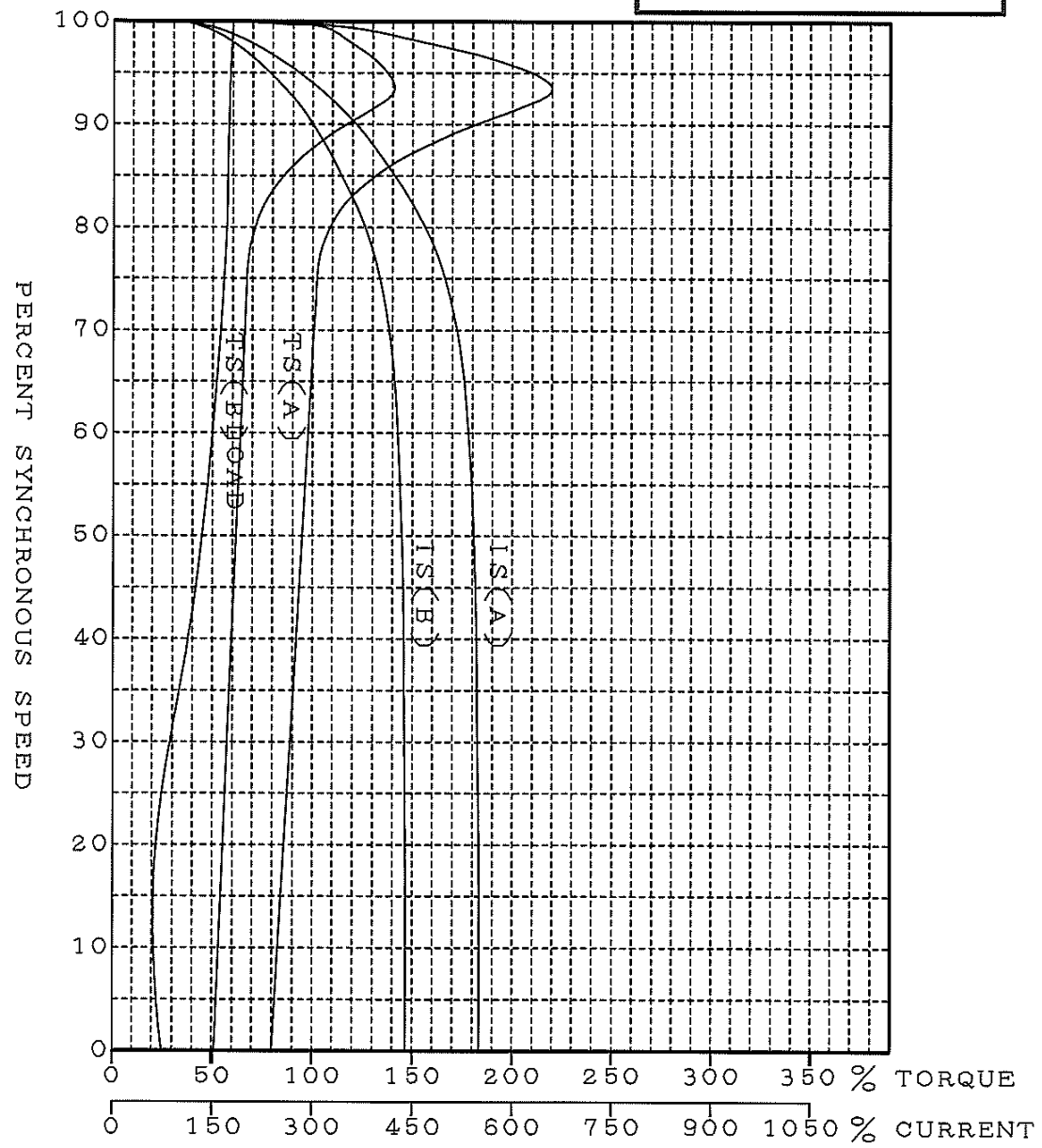
INDUCTION MOTOR STARTING CHARACTERISTICS

T—N/I—N CURVE

TYPE:AECK KW:4200 VOLTS:11000 ORDER NO: FE15C704T1
HZ:50 POLES:4 RPM(FLS):1493 FE15C710T1
FE15C711T1

VOLTS: (A)100% (B):80%

FINAL AS BUILT
Order No. FE15C704T1,FE15C710T1, FE15C711T1



DWG.	F. C. KU	20150709
APPD.	T. HSIAO	20150709

TECO Electric & Machinery Co., Ltd.

DWG NO. REV:00
FE15C704T1
T—I—L

Input Ver:00

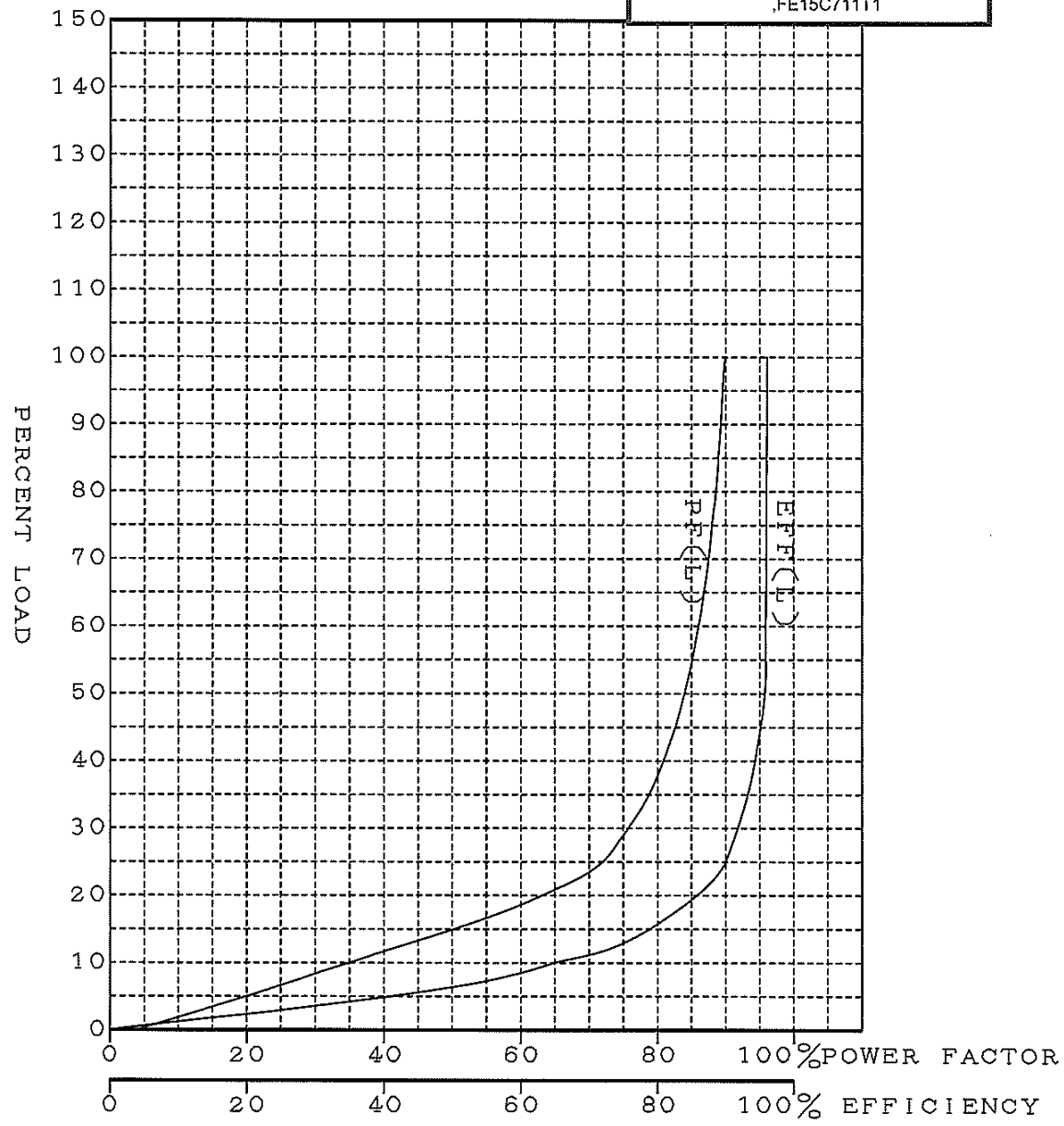
INDUCTION MOTOR STARTING CHARACTERISTICS

Efficiency & Power Factor Vs Load Curve

TYPE:AECK KW:4200 VOLTS:11000 ORDER NO: FE15C704T1
HZ:50 POLES:4 RPM(FLS):1493 FE15C710T1
FE15C711T1

VOLTS: (A)100% (B):80%

FINAL AS BUILT
Order No.FE15C704T1,FE15C710T1 ,FE15C711T1



DWG.	F. C. KU	20150709
APPD.	T. HSIAO	20150709

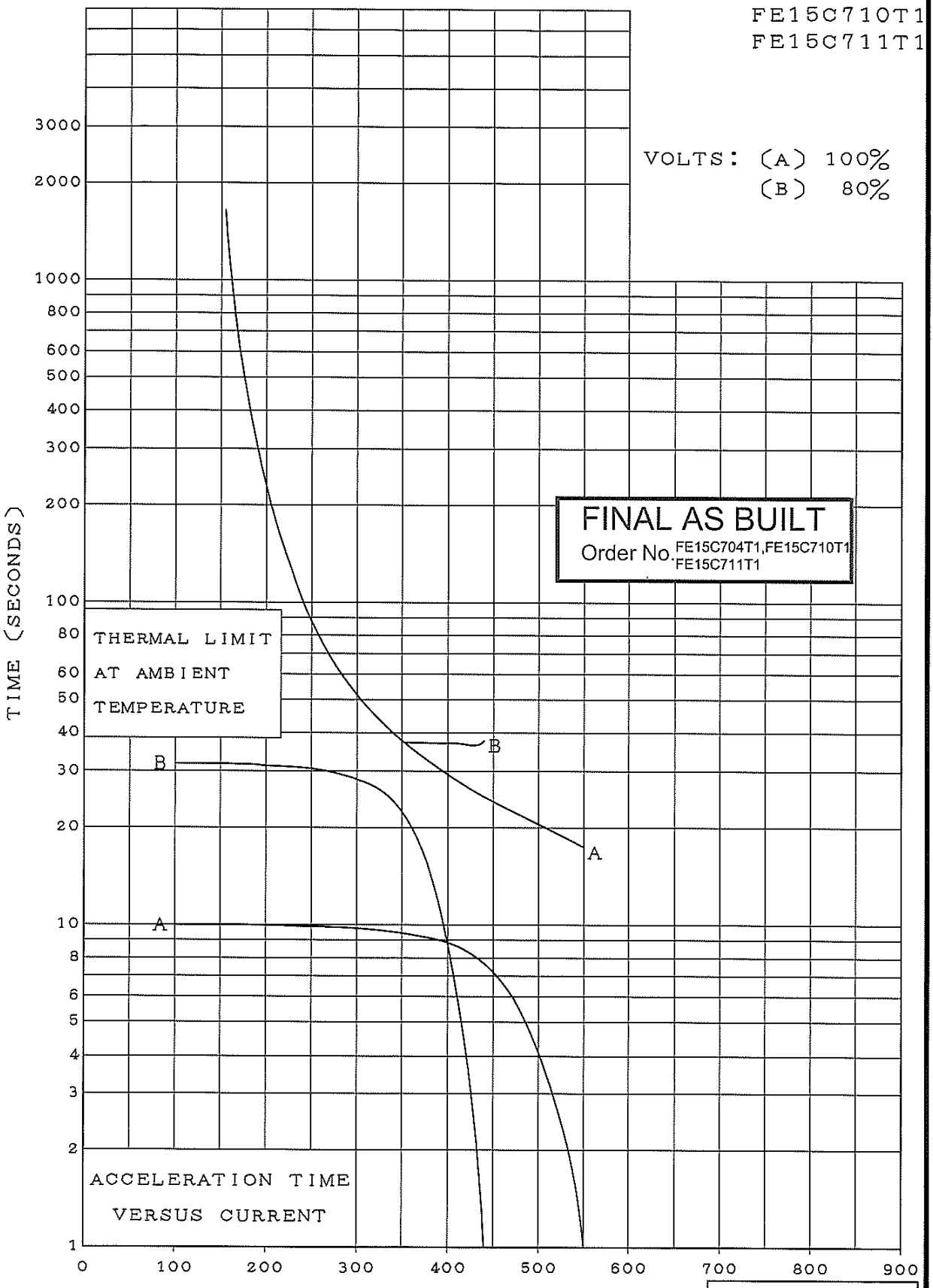
TECO Electric & Machinery Co., Ltd.

DWG NO. REV:00
FE15C704T1
E—P—L

Input Ver:00

TIME — CURRENT AND THERMAL LIMIT CURVES

LOAD GD² (KG—M²):1670 MOTOR GD² (KG—M²):1612
TYPE:AECK POLE:4 KW:4200 NO. : FE15C704T1
FE15C710T1
FE15C711T1



DWG.	F. C. KU	20150709
APPD.	T. HSIAO	20150709

TECO Electric & Machinery Co., Ltd.

DWG NO. REV:00
FE15C704T1
TIME

Input Ver:01

TECO STANDARD CORROSION RESISTANT PAINTING

OUTDOOR USE

CONSTRUCTION MATERIALS	SURFACE TREATMENT		
STEEL PLATE	SHOT BLASTING	SSPC-SP10	NEAR WHITE BLAST CLEANING
CAST IRON	SHOT BLASTING	SSPC-SP10	NEAR WHITE BLAST CLEANING

PROCEDURES	PAINTS	COLOR	FILM THICKNESS
PRIMARY COATING	EPOXY RESIN PRIMER	LIGHT GREEN	25 MICRO-M
SECONDARY COATING	TWO-PACK EPOXY RESIN ENAMEL	MUNSELL 7.5B 3.5/0.5	50 MICRO-M
FINISH COATING	POLYURETHANE RESIN ENAMEL	RAL 7032	75 MICRO-M
TOTAL FILM THICKNESS			150 MICRO-M

FINAL AS BUILT
Order No. FE15C704T1,FE15C710T1 FE15C711T1

SSPC : STEEL STRUCTURES PAINTING COUNCIL
SP : SURFACE PREPARATION

Dwg : FE15C704T1-PS
Dwg : FE15C710T1-PS
Dwg : FE15C711T1-PS
Rev : 00