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USACE / NAVFAC / AFCEA / NASA                      UFGS-42 22 13.00 40 (February 2011)  
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Preparing Activity:    NASA                              Superseding  
                                                            UFGS-42 22 13 (May 2010)

UNIFIED FACILITIES GUIDE SPECIFICATIONS

References are in agreement with UMRL dated April 2011

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DIVISION 42 - PROCESS HEATING, COOLING, AND DRYING EQUIPMENT

SECTION 42 22 13.00 40

CENTRIFUGAL PROCESS CHILLERS AND COOLERS

02/11

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### SECTION 42 22 13.00 40

#### CENTRIFUGAL PROCESS CHILLERS AND COOLERS

02/11

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NOTE: This specification covers the requirements  
for packaged self-contained hermetic compressor units.  
Rewrite if unit is not self-contained per definition.

Adhere to [UFC 1-300-02](#) Unified Facilities Guide  
Specifications (UFGS) Format Standard when editing  
this guide specification or preparing new project  
specification sections. Edit this guide  
specification for project specific requirements by  
adding, deleting, or revising text. For bracketed  
items, choose applicable items(s) or insert  
appropriate information.

Remove information and requirements not required in  
respective project, whether or not brackets are  
present.

Comments, suggestions and recommended changes for  
this guide specification are welcome and should be  
submitted as a [Criteria Change Request \(CCR\)](#).

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## PART 1 GENERAL

### 1.1 REFERENCES

\*\*\*\*\*

NOTE: This paragraph is used to list the  
publications cited in the text of the guide  
specification. The publications are referred to in  
the text by basic designation only and listed in  
this paragraph by organization, designation, date,  
and title.

Use the Reference Wizard's Check Reference feature  
when you add a RID outside of the Section's  
Reference Article to automatically place the  
reference in the Reference Article. Also use the  
Reference Wizard's Check Reference feature to update  
the issue dates.

References not used in the text will automatically  
be deleted from this section of the project  
specification when you choose to reconcile  
references in the publish print process.

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The publications listed below form a part of this specification to the  
extent referenced. The publications are referred to within the text by the  
basic designation only.

AIR-CONDITIONING, HEATING AND REFRIGERATION INSTITUTE (AHRI)

AHRI 480 (2007) Refrigerant-Cooled Liquid Coolers,  
Remote Type

AHRI 550/590 (2003) Performance Rating of  
Water-Chilling Packages Using the Vapor  
Compression Cycle

ANSI/AHRI 520 (2004) Performance Rating of Positive  
Displacement Condensing Units

AMERICAN SOCIETY OF HEATING, REFRIGERATING AND AIR-CONDITIONING  
ENGINEERS (ASHRAE)

ASHRAE EQUIP SI HDBK (2008; Errata 1 2010) Handbook, HVAC  
Systems and Equipment (SI Edition)

ASME INTERNATIONAL (ASME)

ASME BPVC SEC VIII D1 (2007; Addenda 2008; Addenda 2009) BPVC  
Section VIII-Rules for Construction of  
Pressure Vessels Division 1

INTERNATIONAL ORGANIZATION FOR STANDARDIZATION (ISO)

ISO 1940-1 (2003; Cor 2005) Mechanical Vibration -  
Balance Quality Requirements for Rotors in  
a Constant (Rigid) State - Part 1:  
Specification and Verification of Balance

NATIONAL ELECTRICAL MANUFACTURERS ASSOCIATION (NEMA)

NEMA 250 (2008) Enclosures for Electrical Equipment  
(1000 Volts Maximum)

NEMA MG 1 (2009) Motors and Generators

U.S. DEPARTMENT OF ENERGY (DOE)

DOE CE-2 (2000) How to Buy an Energy-Efficient  
Water-Cooled Electric Chiller

DOE CE-6 (2000) How to Buy an Energy-Efficient  
Air-Cooled Electric Chiller

1.2 SUBMITTALS

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NOTE: Review Submittal Description (SD) definitions in Section 01 33 00 SUBMITTAL PROCEDURES and edit the following list to reflect only the submittals required for the project. Keep submittals to the minimum required for adequate quality control.

A "G" following a submittal item indicates that the submittal requires Government approval. Some submittals are already marked with a "G". Only delete an existing "G" if the submittal item is not complex and can be reviewed through the Contractor's Quality Control system. Only add a "G" if the submittal is sufficiently important or complex in context of the project.

For submittals requiring Government approval on Army projects, a code of up to three characters within the submittal tags may be used following the "G" designation to indicate the approving authority. Codes for Army projects using the Resident Management System (RMS) are: "AE" for Architect-Engineer; "DO" for District Office (Engineering Division or other organization in the District Office); "AO" for Area Office; "RO" for Resident Office; and "PO" for Project Office. Codes following the "G" typically are not used for Navy, Air Force, and NASA projects.

Choose the first bracketed item for Navy, Air Force and NASA projects, or choose the second bracketed item for Army projects.

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Government approval is required for submittals with a "G" designation; submittals not having a "G" designation are [for Contractor Quality Control approval.] [for information only. When used, a designation following the "G" designation identifies the office that will review the submittal for the Government.] Submit the following in accordance with Section 01 33 00 SUBMITTAL PROCEDURES:

#### SD-01 Preconstruction Submittals

Material, Equipment, and Fixture Lists[; G][; G, [\_\_\_\_]]

#### SD-02 Shop Drawings

Connection Diagrams[; G][; G, [\_\_\_\_]]

Control Diagrams[; G][; G, [\_\_\_\_]]

Installation Drawings[; G][; G, [\_\_\_\_]]

Record Drawings[; G][; G, [\_\_\_\_]]

#### SD-03 Product Data

Centrifugal Water-Chiller[; G][; G, [\_\_\_\_]]

Compressor[; G][; G, [\_\_\_\_]]

Condenser[; G][; G, [\_\_\_\_]]  
Control And Control Panels[; G][; G, [\_\_\_\_]]  
Cooler[; G][; G, [\_\_\_\_]]  
Equipment Foundation Data[; G][; G, [\_\_\_\_]]  
Equipment and Performance Data[; G][; G, [\_\_\_\_]]  
Insulation[; G][; G, [\_\_\_\_]]  
Motors[; G][; G, [\_\_\_\_]]  
Purge System[; G][; G, [\_\_\_\_]]  
Spare Parts[; G][; G, [\_\_\_\_]]  
Special Tools[; G][; G, [\_\_\_\_]]  
Vibration Isolation[; G][; G, [\_\_\_\_]]

#### SD-04 Samples

Manufacturer's Standard Color Chart[; G][; G, [\_\_\_\_]]

#### SD-05 Design Data

Design Analysis and Calculations[; G][; G, [\_\_\_\_]]

#### SD-06 Test Reports

Test Reports[; G][; G, [\_\_\_\_]]

#### SD-07 Certificates

Listing of Product Installation[; G][; G, [\_\_\_\_]]

Referenced Standards Certificates[; G][; G, [\_\_\_\_]]

#### SD-10 Operation and Maintenance Data

Operation and Maintenance Manuals[; G][; G, [\_\_\_\_]]

### 1.3 SYSTEM DESCRIPTION

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NOTE: Include in drawings or schedule capacity,  
capacity conditions, pressure drops, control  
diagrams, and refrigerant used.  
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NOTE: If Section 23 00 00 AIR SUPPLY, DISTRIBUTION,  
VENTILATION, AND EXHAUST SYSTEMS is not included in  
the project specification, applicable requirements  
therefrom should be inserted and the following  
paragraph deleted. If Section 23 05 48.00 40

VIBRATION AND SEISMIC CONTROLS FOR HVAC PIPING AND EQUIPMENT is not included in the project specification, applicable requirements therefrom should be inserted and the second paragraph deleted. If Section 26 60 13.00 40 LOW-VOLTAGE MOTORS is not included in the project specification, applicable requirements therefrom should be inserted and the third paragraph deleted.

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[Section 23 00 00 AIR SUPPLY, DISTRIBUTION, VENTILATION, AND EXHAUST SYSTEMS applies to work specified in this section.]

[Section 23 05 48.00 40 VIBRATION AND SEISMIC CONTROLS FOR HVAC PIPING AND EQUIPMENT applies to work specified in this section.]

[Section 26 60 13.00 40 LOW-VOLTAGE MOTORS applies to this section.]

#### 1.3.1 Equipment and Performance Data

Submit [material, equipment, and fixture lists](#) for centrifugal chiller systems including manufacturer's style or catalog numbers, specification and drawing reference numbers, warranty information, and fabrication site information.

Submit [equipment and performance data](#) for centrifugal water chillers indicating the guaranteed maximum brake power at 75-, 50-, 25-, and 10-percent points of full compressor capacity at design condenser water temperature. Develop this information from data specified herein.

Ensure [manufacturer's standard color chart](#) indicates the manufacturer's standard color selections and finishes for chiller units.

#### 1.3.2 Required Drawings and Diagrams

Submit shop drawings of [connection diagrams](#) indicating the physical layout of all controls, internal tubing and wiring details, and the relations and connections of the following items:

- a. Centrifugal Water Chiller
- b. Compressor
- c. Condenser
- d. Cooler
- e. Purge System
- f. Motors
- g. Control and Control Panels

Submit [design analysis and calculations](#) for centrifugal chillers indicating the manufacturer's recommended power ratings, rotational speeds, and piston speeds.

Submit [equipment foundation data](#) including equipment weight and operating loads, location and projection of anchor bolts, and horizontal and vertical

clearances for installation, operation, and maintenance. Also include dimensions of foundations and relative elevations, and installation requirements such as noise abatement, vibration isolation, physical features, dimensions, ratings, equipment weights and utility services. Include foundation data for the following:

- a. Centrifugal Water Chiller
- b. Compressor
- c. Condenser
- d. Cooler
- e. Purge System
- f. Motors

Submit [control diagrams](#) for centrifugal chiller units showing the physical and functional relationship of equipment. Show on electrical diagrams the size, type, and capacity of the system.

Submit [record drawings](#) for centrifugal chiller units providing current factual information including deviations from, and amendments to, the drawings and concealed and visible changes in the work.

#### 1.4 QUALITY ASSURANCE

Submit [listing of product installation](#) for centrifugal chiller units showing at least 5 installed units, similar to those proposed for use, that have been in successful service for a minimum period of 5 years. Include purchaser name, address of installation, service organization, and date of installation.

##### 1.4.1 Equipment and Performance Data

Submit equipment and performance data for centrifugal water chiller system for the following:

- a. Centrifugal Water Chiller
- b. Compressor
- c. Condenser
- d. Cooler
- e. Purge System
- f. Motors
- g. Control and Control Panels
- h. Insulation
- i. Vibration Isolation
- j. Special Tools

k. Spare Parts

#### 1.4.2 Referenced Standards Certificates

Submit certificates for following items showing conformance with referenced standards in this section:

- a. Centrifugal Water Chiller
- b. Compressor
- c. Condenser
- d. Cooler
- e. Purge System
- f. Motors
- g. Control and Control Panels
- h. Insulation
- i. Vibration Isolation
- j. Special Tools
- k. Spare Parts

#### PART 2 PRODUCTS

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NOTE: Ensure Pump and Motor balance conforms to ISO 1940-1 - (1986) Balance Quality Requirements of Rigid Rotors - Determination of Permissible Residual Unbalance unless otherwise noted. Ensure Motor vibration levels conform to NEMA Specification MG-1, Motors and Generators, Part 7 unless otherwise noted.

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NOTE: Specify all rotating machinery is capable of having shaft alignment and machine balance following installation. This requirement includes "skid-mounted" and "self-contained" units.

\*\*\*\*\*

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NOTE: Balance is the process of improving the mass distribution of the pump components in order to minimize damaging centrifugal forces. No component can be perfectly balanced. There will always be some remaining unbalance. The minimum recommended balance grade is ISO grade 2.5. Select an ISO grade or insert a standard.

\*\*\*\*\*



## 2.1 CENTRIFUGAL WATER-CHILLER PACKAGE

Ensure centrifugal water-chiller assembly is packaged and self-contained, and includes compressor-condenser, cooler (refrigerant evaporator) accessories, control panel, and intercomponent piping and wiring ready for field-terminal connections.

Provide unit and spare parts conforming to the applicable requirements of AHRI 550/590, AHRI 480, and specified requirements. Ensure Energy Efficiency Ratings (EER) meets or exceeds the full-load efficiency and the integrated part-load value (IPLV) efficiency ratings as described in AHRI 550/590 and the recommended levels specified in DOE CE-2 and DOE CE-6.

## 2.2 COMPRESSOR

\*\*\*\*\*  
NOTE: At higher than 3,600 rpm speeds, reevaluate  
0.025 millimeter vibration limit. Do not use  
compressor that will operate at 20,000 or higher rpm.  
\*\*\*\*\*

Provide [single] [multistage], [direct] [gear-driven] centrifugal type compressor, with hermetically sealed, compressor-motor assembly. Provide with [refrigerant] [water-cooled] motor windings. Ensure rotor assembly is statically and dynamically balanced to ISO 1940-1 -1986, [G6.3] [G2.5] [G1.0] [\_\_\_\_], with replaceable sleeve-insert type shaft main bearings.

Provide compressor lubrication system of the forced-feed type with oil sump, hermetically sealed motor-driven positive displacement pump, oil filter, strainer, with oil temperature thermostatically controlled. Provide a mechanically operated oil supply to the bearings during spin down in event of power interruption. Include interlocked differential oil-pressure cutout with starting equipment, which allows the compressor to operate only when the required oil pressure is available at the bearings.

Provide compressor with temperature-actuated capacity reduction and of the multiple radial blade or butterfly-damper type Variable Frequency Drive (VFD) compressor motor control to provide automatic capacity regulation from 100 percent to 10 percent of capacity. Provide automatic hot-gas bypass if required to maintain stable operation, with control system including automatic stopping, when load falls below 10 percent capacity point, and automatic unloaded restarting on load demand. Ensure capacity modulation is controlled by the temperature of the water leaving the cooler, with unit controller capable of maintaining leaving-water temperature at plus or minus 0.25 degrees C 0.5 degree F of the set point.

## 2.3 CONDENSER

Provide shell-and-tube cleanable-type condenser, complying with ASHRAE EQUIP SI HDBK, Chapter 13, and ASME BPVC SEC VIII D1 regarding quality of materials used, methods of construction, design of components, and testing of materials, assemblies, connections, and appurtenances. Ensure minimum water-side working pressure is 1050 kilopascal 150 psig, and minimum refrigerant-side working pressure is saturation pressure of refrigerant used at 29 degrees C 85 degrees F. Pneumatically test spaces not subject to ASME code due to size or other limitations at 1-1/2 times working pressure or 310 kilopascal 45 psig, whichever is greater.

Provide with seamless copper tubing with integral fins, individually

removable from either end of shell, rolled or brazed into tube sheet. Provide intermediate tube supports so that distance between supports does not exceed approximately 900 millimeter 3 feet. Fit supports to the tubes in a manner that will preclude corrosion, vibration, and abrasion.

Fit and arrange water boxes or removable elbows to permit cleaning of tubes without disturbing piping beyond elbows, with flanged- or grooved-coupling type elbows, and hinged-mounted end bells.

\*\*\*\*\*  
NOTE: R-12 is designated as a restricted material.  
Use available substitutes as apply to specified's  
application. CFC's are being phased out. No new  
designs using CFC's are allowed.  
\*\*\*\*\*

Design the unit to permit pump-down and isolation of the entire refrigerant charge within 80 percent of available condenser volume. If the unit condenser does not have sufficient pump-down capacity, provide a separate pump-out tank.

\*\*\*\*\*  
NOTE: Many present-day nonchromate water treatment  
chemicals degrade at temperatures as low as 38 to 57  
degrees C 100 to 135 degrees F and tend to severely  
foul heat-transfer surfaces. The difference between  
a fouling factor of 0.0005 and 0.001 could  
approximate 7 percent of machine capacity. Cost of  
unit with 0.001 fouling factor will be higher and  
may be restrictive.

Limiting water velocity to 2 meter per second 7 feet  
per second (fps) could force selection of next  
larger size machine.

Tube protectors are usually required at velocities  
in excess of 2 meter per second 7 fps.

Select one of the following two paragraphs.  
Normally, select the first paragraph.

\*\*\*\*\*

Base the condenser performance on a maximum water velocity of 3 meter per  
second 10 feet per second (fps) and a fouling factor of 0.001. Ensure  
design and construction provisions preclude tube failure due to erosion.

Base the condenser performance on a maximum water velocity of 2 meter per  
second 7 fps and a fouling factor of 0.001.

#### 2.4 COOLER (REFRIGERANT EVAPORATOR)

Provide cooler conforming to the requirements specified herein in paragraph  
entitled, "Condenser," and the following:

Base the cooler capacity on refrigerant suction temperature in excess of 0  
degrees C 32 degrees F and a fouling factor of 0.0005.

Provide a frangible safety relief device. Device to be piped to building  
exterior.

## 2.5 PURGE SYSTEM

\*\*\*\*\*  
NOTE: R-11 and R-113 are restricted materials.  
Purge system applies only to existing units and  
modifications. An available substitute should be  
found and incorporated immediately.  
\*\*\*\*\*

When HCFC-123 refrigerant is used, provide a high efficiency purge system connected to the main refrigeration system. Ensure when in operation, the purge system functions automatically to remove air, water vapor, and noncondensable gases from the refrigeration system and condenses, separates, and returns any refrigerant present therein to the system. Ensure purge system manually or automatically starts and stops and is assembled as a compact unit. Verify purge system is complete with operating and safety devices, with an oil separator if recommended by the manufacturer. When a positive-pressure refrigerant is used by the manufacturer in the basic liquid chiller unit, a purge system is not required. Ensure units purge no more than 0.045 kg 0.1 pounds of non-condensable.

## 2.6 CONTROL AND CONTROL PANELS

\*\*\*\*\*  
NOTE: Select the following paragraph only after  
checking control panel sizes and numbers to be sure  
they can be unit mounted. Some or all starters may  
be mounted in motor control center and unit will not  
be totally self-contained.  
  
Coordinate with Section 23 09 33.00 40 ELECTRIC AND  
ELECTRONIC CONTROL SYSTEM FOR HVAC and electrical  
requirements.  
\*\*\*\*\*

Provide water-chilling unit with one or more control panels containing safety and operating devices and intercomponent piping and wiring for field terminal connection and fully automatic operation.

Coordinate the controls with automatic temperature controls systems and electrical work specified and indicated. Provide control panel containing control equipment specified, and control equipment normally furnished and recommended by the manufacturer for optimum operation of the system. Permanently identify control panel items, including at least the following:

\*\*\*\*\*  
NOTE: The following are manufacturer's standard  
items. If the last two listed items, motor  
controllers and NEMA 1 enclosures, are specified  
elsewhere, delete from this paragraph.  
\*\*\*\*\*

- a. Refrigerant suction and discharge pressure gages
- b. Oil-pressure gages
- c. Purge-drum pressure gage

- d. Refrigerant low-temperature or low-pressure cutout
- e. Refrigerant high-pressure cutout
- f. Time delay relays
- g. Motor high-temperature cutout
- h. Lubricating-oil high-temperature cutout if required by equipment
- i. Oil differential-pressure interlock
- j. Interlock relays and reset button
- k. Manual/automatic selector switches and controls for purge pumps
- l. Pilot lights indicating position of safety controls
- m. System start/stop provisions with condition-indicating lights
- n. Load-limiting device to operate capacity-control mechanism
- o. Cooler refrigerant thermometer with well
- p. Main circuit protective and interruptive device
- q. Transformers for any other source-voltage requirements
- r. Terminals for field-installed equipment
- [ s. Motor controllers
- ] [t. NEMA 250, Type 1 enclosures
- ] Provide the following items as part of the installation:

\*\*\*\*\*  
 NOTE: Coordinate with drawings. Select, delete, or  
 supplement. These are normally field-installed by  
 the Contractor.  
 \*\*\*\*\*

- a. Audible-alarm bell, 100 millimeter 4-inch diameter
- b. Chilled-water and condenser supply-and-return thermometers with wells
- c. Indicating-type chilled-water thermostat with well
- d. Chilled-water low-temperature cutout

## 2.7 MOTORS

Provide hermetically sealed motors conforming to NEMA MG 1, ANSI/AHRI 520 and requirements for motors as specified herein.

Provide with [oil-lubricated, replaceable-sleeve, insertable type]  
 [permanently lubricated, rolling element type] bearings.

\*\*\*\*\*  
NOTE: Limit percent of full-load amperes at which  
motor controller overload will trip, gas pressure  
differential, pumps, sprays, unit capacity, or  
other. Coordinate with motor controller  
specification and drawings.  
\*\*\*\*\*

[ Provide motor with two manually resettable thermal-overload protective  
devices located within windings.  
]

\*\*\*\*\*  
NOTE: Coordinate the following with the following  
motor controller specification and drawings.  
Rewrite as necessary to suit designed size and type  
equipment.  
\*\*\*\*\*

If water-chilled unit or any component could be damaged by reverse motor  
operation, and when proposed water-chiller unit contains a mechanically  
driven lubricating-oil pump, the manufacturer's responsibility includes:

Providing reverse-phase rotation protection, if motor controllers are  
provided as part of package.

Indicating in shop drawings that reverse-phase rotation protection is  
necessary if motor controllers are in a motor-control center not  
provided by the manufacturer.

## [2.8 INSULATION

\*\*\*\*\*  
NOTE: Select the following paragraphs only when  
specified equipment is to be provided with factory  
insulation. Normally provide for field insulation  
of cooler headers.  
\*\*\*\*\*

Insulate and vapor seal cooler shell and suction piping between evaporator  
and first stage of each compressor unit. Insulate the water boxes to  
provide for ease of access to heads for inspection and repair. Where  
motors are the gas-cooled type, provide insulation and vapor seal on the  
cold-gas inlet connection to the motor.

Provide manufacturer's standard color elastomeric unicellular foam vapor  
seal material of 25 millimeter 1 inch minimum thickness to preclude  
condensation of ambient moisture on any surface under site-operating  
conditions. If unicellular material is black or is otherwise coated, only  
use polyvinylchloride lacquer for coating. Remove and replace any coating  
that cracks when unicellular material is compressed with specified coating  
at no additional expense to the Government.

## ]2.9 VIBRATION ISOLATION

Provide vibration isolation conforming to requirements specified in Section  
23 05 48.00 40 VIBRATION AND SEISMIC CONTROLS FOR HVAC PIPING AND EQUIPMENT.

## 2.10 SPECIAL TOOLS

Provide [one] [\_\_\_\_\_] complete set[s] of special tools, as recommended by the manufacturer, for field maintenance of the system, in a locked toolbox. Provide two [sets of ]keys to the Contracting Officer.

## PART 3 EXECUTION

### 3.1 INSTALLATION

Install equipment as specified, and in accordance with manufacturer's [installation drawings](#) and written instructions, including ratings and service requirements.

### 3.2 MANUFACTURER'S REPRESENTATIVE

Provide the services of a competent factory-trained representative to supervise the assembly, charging, testing, and startup of equipment. Also make provisions for Government personnel to receive [8] [\_\_\_\_\_] hours of instructions in proper operation and maintenance procedures. Provide documentation that a factory performance test has been conducted on every chiller in accordance with [AHRI 550/590](#), witnessed by Government and Contractor.

Submit [6] [\_\_\_\_\_] copies of the [operation and maintenance manuals](#) 30 calendar days prior to testing the centrifugal chiller system. Update and resubmit data for final approval no later than 30 calendar days prior to contract completion.

### 3.3 REFRIGERANT AND OIL CHARGE

Completely charge unit(s) with refrigerant and oil before operation.

### 3.4 ALIGNMENT

Before attempting alignment, demonstrate that the pump does not have any load/force imposed by the piping system. Minimum alignment values (below) are for pump and driver at normal running temperatures. Ensure values are compensated for thermal growth. Ensure limited movement of the pump or driver (commonly known as bolt-bound) is corrected to ensure alignment capability. Do not undercut hold down bolts in order to perform adjustment.

Provide commercially die-cut shims, without seams or folds, made of corrosion resistant stainless steel. Use no more than four shims at any single point.

Provide installed alignment jack bolts on all units with a drive motor over [7.5] [10] [15] [20] [25] hp.

Provide pump and driver with an intermediate shaft, spacer, or spool piece (sometimes called a jackshaft). Based on the motor nominal operating speed, align the pump and driver to the following minimum specifications:

Speed (RPM)	Close-Coupled Offset (mils)	Close-Coupled Angle (mils/in.)	Spool Piece Angle (mils/in. @ coupling pt.)
600	6.0	2.0	3.0
900	5.0	1.5	2.0
1200	4.0	1.0	1.5

Speed(RPM)	Close-Coupled Offset (mils)	Close-Coupled Angle(mils/in.)	Spool Piece Angle (mils/in. @ coupling pt.)
1800	3.0	0.5	1.0
3600	1.5	0.4	0.5
7200	1.0	0.3	0.4

Perform pump alignment under the direction of the manufacturer's representative.

Provide final alignment settings as part of the final test data.

### 3.5 FIELD TESTING

Prior to final acceptance, verify pump and motor conformance to specifications using vibration analysis, with vibration levels not exceeding .075 in/sec at 1 times run speed and at pump frequency, and .04 in/sec at other multiples of run speed.

Use a Fast Fourier Transformer (FFT) analyzer to measure vibration levels, having the following characteristics:

- a. Dynamic range greater than 70 dB;
- b. A minimum line resolution of 400;
- c. A frequency response range of 5 Hz-10 KHz(300-600000 cpm);
- d. The capacity to perform ensemble averaging;;
- e. The capability to use a Hanning window;
- f. Auto ranging frequency amplitude;
- g. A minimum amplitude accuracy over the selected frequency range of plus or minus 20 percent or plus or minus 1.5 dB.
- h. An accelerometer, either stud-mounted or mounted using a rare earth, a low mass magnet and sound disk(or finished surface) used with the FFT analyzer to collect data.

Ensure the mass of the accelerometer and its mounting have minimal influence on the frequency response of the system over the selected measurement range.

Upon completion of the installation, and within 60 calendar days after the date of initial operation, conduct performance tests in the presence of the Contracting Officer. Conduct these tests until the performance of the system is proven, with [8] [\_\_\_\_\_] hours of successful operation as a minimum period. Correct any equipment defects or performance deficiencies, and repeat the tests until performance is fully accepted by the Contracting Officer. Determine the water flows from pressure-drop across chiller and condenser, and from pump curves. Provide calibrated test instruments. Government will provide load.

Ensure each unit is tested for leaks under pressure and evacuated and dehydrated to 2 degrees C 35 degrees F wet bulb, or an absolute pressure of not over 813 pascal 0.24 inch of mercury

Provide final test reports to the Contracting Officer. Provide reports with a cover letter/sheet clearly marked with the system name, date, and the words "Final Test Reports - Forward to the Systems Engineer/Condition Monitoring Office/Predictive Testing Group for inclusion in the Maintenance Database."

-- End of Section --