



VAPOR RECOVERY UNIT

Recover Valuable Natural Gas & Avoid Vapor Emissions

Key Benefits

Profit From Your Investment

- Capture valuable natural gas that would otherwise be vented or flared

Manage Environmental Impact

- Reduce harmful emissions or wasted vapor
- Safeguard against spills with the rugged skid-mounted containment system
- No leaks with our rugged welded piping

Simplify Operation and Maintenance

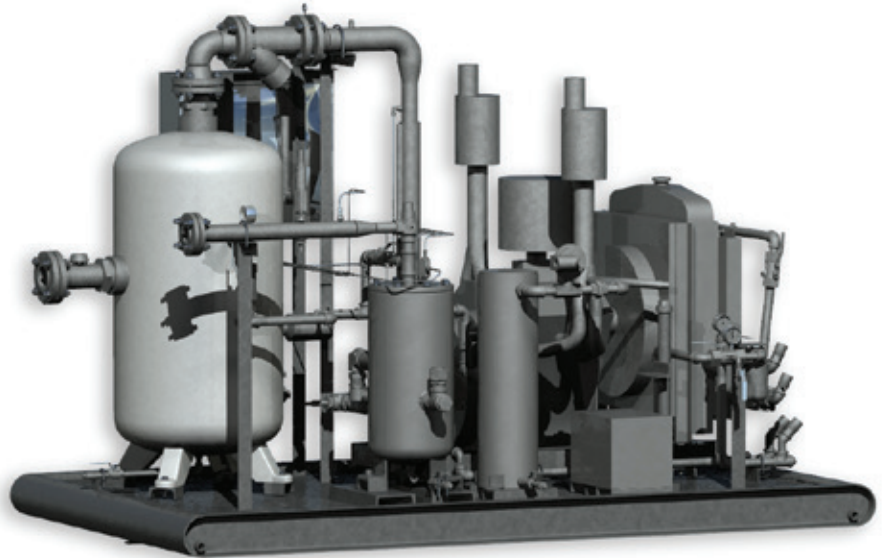
- Advanced easy-to-use engine, motor and compressor controls
- Large capacity water and containment knock-out tanks
- V-belt or variable frequency drive for flexible pressure and volume matching
- Gas engine oil reservoir with self-leveling system
- Easy-fill oil separator tanks
- Automatic lubrication system for critical bearings

Standard Features

- Skid-mounted containment system
- PLC-based precision pressure control
- Oxygen monitoring of compressed vapor
- ½ - 12 ounce automatic tank pressure protection
- Belt-driven compressor with VFD speed control and unloader valve
- High-capacity oil filter and easy oil filler and drain for compressor
- Aluminum oil coolers with thermostatic temperature control
- 30 or 80 gallon water knock-out tank
- Fuel-gas liquid knock-out tank
- Precision fuel gas regulator

Gas Engine Models:

- Kawasaki 10 hp, General Motors 22 hp, 44 hp, 75 hp or Cummins up to 250 hp
- Engine oil reservoir with self-leveling system



OVERVIEW

The Exterran Production Solutions™ Vapor Recovery Unit (VRU) is an economical, pre-engineered, customizable package that is ideal for well sites where air quality regulations require vapor recovery.

Our vapor recovery system employs compression to recover vapors from condensate and natural gas liquid (NGL) storage as an alternative to flaring or venting to the atmosphere.

OPERATION

Exterran's VRU consists of a belt-driven compressor, fuel-gas and water knock-out tanks, oil coolers, a precision pressure controller, and a rugged skid-mounted containment system. The unit can be outfitted with a rotary screw, piston or scroll compressor powered with either an electric motor or EPA-certified natural gas engine.

The VRU is connected to your storage tanks or VRU towers containing condensate or NGL. Tank pressure is continuously monitored by a pressure transducer and is controlled using compression in a range of pressures from .25 to 10 psi.

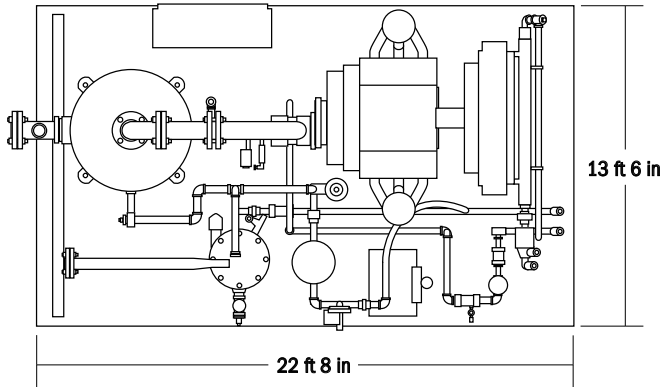
During the compression cycle, condensate or NGL enters the recovery unit and is scrubbed to extract valuable gas vapor. The captured gas can be routed to a station compressor or be used as fuel gas for other components. Compression stops when vapor pressure falls below the low threshold. The recovery unit continuously maintains tank pressure within safe limits and corrects out-of-range operating parameters.

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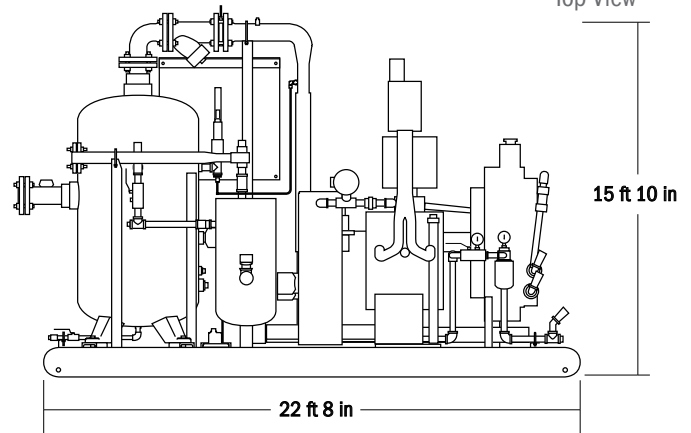
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DIMENSIONS

Side View



Top View



Dimensions shown here are approximate and will vary depending on model. Precise measurements for freight should be confirmed prior to shipping.

Gas Engine Models and Specifications

| Gas Model No. | Flow Rate (Mscfd) | Discharge Pressure (psi) |
|---------------|-------------------|--------------------------|
| JV-SCG8-KAWC | 55 | 100 |
| JV-SCG10-262C | 100-200 | 100 |
| JV-SCG14-350C | 225-300 | 100 |

Electric Motor Models and Specifications

| Electric Model No. | Flow Rate (Mscfd) | Discharge Pressure (psi) |
|----------------------|-------------------|--------------------------|
| JV-SCG8-15-4803 65 | 100 | 100 |
| JV-SCG8-20-4803 85 | 100 | 100 |
| JV-SCG10-40-4803 | 121 | 100 |
| JV-SCG14-50-4803 | 225 | 100 |
| JV-SCG14-75-4803 | 500 | 100 |
| JV-285-100-4803 600 | 100 | 100 |
| JV-1750LP-4803D 4000 | 2,000 | 100 |

*The optional gas blanketing system monitors tank pressure of the recovery unit's compressor. If pressure drops below the low threshold, the control system routes outlet gas to the tank to prevent oxygen from being drawn into it from mechanical vacuum breaks.

Options Checklist

- Natural gas tank blanketing system*
- Carbon steel suction scrubber with stainless steel demister pads
- 120 or 240 gallon knock-out tank with scrubber
- Blowcase
- Manual isolation valves
- Class 1, division 1, group C, D wiring
- Remote monitoring (if cell phone service is available)
- Insulated structural enclosure
 - Explosion proof heater
 - Explosion proof lighting
 - Explosion proof automatic liquid removal pump
 - Explosion proof inverter duty electric motor with VFD single or 3-phase

Compressor Requirement

- Piston Rotary Screw Scroll

Engine/Motor Sizing Requirements

- Natural gas engine Electric motor
- Cummins engine _____HP
- 10 hp Kawasaki V-twin cylinder natural gas engine
- 22 hp GM 181 4 cylinder natural gas engine
- 44 hp GM 262 6 cylinder natural gas engine
- 75 hp GM 350 8 cylinder natural gas engine



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