

Vertiv™ Liebert® STS2, SR MODEL
STS1 Replacement
GUIDE SPECIFICATION
Automatic Static Transfer Switch
400A-600A

1.0 GENERAL

1.1 Summary

These specifications describe the requirements for an automatic static transfer switch. The Liebert® STS2 is a solid-state, three-pole, dual-position transfer switch designed to switch automatically and manually between two synchronized three-phase AC power sources without an interruption of power to the load typically less than 1/4 cycle.

The input power shall be supplied from two different AC power sources, which are nominally of the same voltage level, phase rotation and frequency. The primary purpose of the Liebert® STS2 is to allow virtually uninterrupted transfer from one source to the other in case of the failure of one source or by manual initiation for test or maintenance. The switching action shall not connect together the two sources of power that would allow backfeeding one source to the other. The Liebert® STS2 shall allow for either source to be designated as the preferred source. The switch will automatically transfer to the preferred source and remain so until manually initiated to transfer or until the selected source fails. If the selected source fails, the Liebert® STS2 shall transfer without interruption typically in less than 1/4 cycle to the other source, designated as the alternate source. The Liebert® STS2 shall be furnished with key-interlocked static switch isolation and bypass Molded-case Switches (MCSs) to each source, which allow uninterrupted manual transfer to and from either source for maintenance.

For Optimized Transfer, the transfer will be within the ITIC/CBEMA voltage quality standard. This is an optional setting which minimizes the resulting downstream transformer saturation inrush current.

1.2 Standards

The specified system shall be designed, manufactured, tested and installed in accordance with:

- American National Standards Institute (ANSI)
- Institute of Electrical and Electronics Engineers (IEEE)
- ISO 9001
- National Electrical Code (NEC)
- National Electrical Manufacturers Association (NEMA)
- National Fire Protection Association (NFPA 70)
- Underwriters Laboratories (UL)
- EN 61000-6-4 & 6-2

The Liebert® STS2 shall be UL listed per UL Standard 1008 for Automatic Transfer Switches or 1008S for Solid State Transfer Switches.

The Liebert® STS2 shall comply with the latest FCC Part 15 EMI emission limits for Class A computing devices and the emission limits of EN/IEC61000-6-4 Class A.

The Vertiv™ Liebert® STS2 shall safely withstand without misoperation or damage:

- Transient voltage surges on either AC power input as defined by ANSI/IEEE C62.41 for Category B3 locations (high surge exposure industrial and commercial facilities)
- Electrostatic discharges (ESD) up to 10 kV at any point on the exterior of the unit
- Electromagnetic fields from portable transmitters within 3 ft. (1m) of the unit

The Liebert® STS2 shall comply with the immunity requirements of EN/IEC61000-6-2 Class A.

1.3 Definitions

- **STS** - Static Transfer Switch.
- **SCR** - Silicon Controlled Rectifier.
- **MTBF** - Mean Time Between Failure is the actual arithmetic average time between failures of the critical AC output bus.
- **Molded-case Switches (MCS)** - A circuit breaker that has no automatic thermal overload trip element but does have a magnetic trip element for short-circuit/fault protection. Short-circuit and overload protection must be provided by an upstream overcurrent device.

1.4 System Description

1.4.1 Design Requirements

1. **Voltage.** Input/output voltage specifications of the Liebert® STS2 SR shall be (208) (480) volts, three phase, 60 Hz, 3-wire plus ground.
2. **Output Load Capacity.** Specified output load capacity of the Liebert® STS2 SR shall be (400A) (600A). The Liebert® STS2 SR shall be continuous rated to carry a full 100% load.

1.4.2 Modes of Operation

The Static Transfer Switch shall be a three-pole, double-throw, solid-state, automatic transfer switch that is fed from two AC power sources. One source shall be designated as the preferred source, while the other is the alternate source. The preferred input source shall be user selectable from the operator control panel. All transfers shall be a fast break-before-make with no overlap in conduction from one source to the other. All transfers, including sense and transfer times, shall typically have less than a 1/4 cycle interruption in power to the load.

The Static Transfer Switch is fuseless and consists of six pairs of SCRs connected in an AC switch configuration. The SCRs are continuous rated to carry 100% of the Liebert® STS2 rated load while operating within the STS2 specifications. The use of fuses for protection is not permitted due to possible fuse clearing in an out of phase transfer.

The Static Transfer Switch logic power shall automatically power up when connected to the power source. The control panel shall be active as long as one input to the Liebert® STS2 is energized. The Liebert® STS2 shall be supplied with factory default settings; mechanical trim pots shall not be used for calibration or adjusting settings. All settings must be adjustable; the settings shall be adjusted/configured from the LCD display.

1. **Normal Mode.** The unit is fed by two sources with the output connected to the load. In normal operation, the load shall be connected to the preferred source as long as all phases of the preferred source are within the acceptable limits. The transfer voltage limits shall default to $\pm 10\%$ of the nominal input voltage for steady state conditions, with low voltage transfer limits having an inverse time relationship that is within the IEEE Std. 446 computer voltage tolerance envelope. Upon failure of the preferred source, the load shall be transferred to the alternate source. After the preferred source returns to within the acceptable voltage limits for at least the preset adjustable retransfer time delay (typically 3 seconds) and is in phase with the alternate source, the load shall be retransferred automatically to the preferred source. The automatic retransfer to the preferred source can be disabled if so selected by the user from the operator control panel. When the automatic retransfer is disabled, emergency transfers from the alternate source to the preferred source shall not be disabled upon alternate source failure.
2. **Load Current Inhibit (also called Ipeak or Peak Current Overload).** The Vertiv™ Liebert® STS2 shall sense the load current and, if the load current exceeds an adjustable preset level deemed to represent a load inrush or fault condition, the Liebert® STS2 shall disable the automatic transfer even if the voltage on the selected source exceeds the transfer limits. The load current transfer inhibit shall be [(automatically) (manually)] reset after the current returns to normal to allow for continued protection against a source failure.
3. **Manual Transfer.** The Liebert® STS2 shall allow manually initiated transfers between the two sources, providing the alternate source is within acceptable voltage limits and phase tolerances with the preferred source. Allowable phase differences between the sources for manually initiated transfers shall be adjustable from the operator control panel. The Liebert® STS2 shall be capable of tolerating transfers up to 180 degrees out of phase for emergency conditions. The user-adjustable phase synchronization window shall be limited to ± 30 degrees, without the Optimized Transfer option. With the Optimized Transfer option installed, the user-adjustable phase synchronization window shall be ± 180 degrees. If the transfer is manually initiated, the Liebert® STS2 shall transfer between the two sources without interruption of power to the load greater than 1 millisecond provided that both sources are available and synchronized within the user-adjustable phase synchronization window. For sources where the two frequencies are not exactly the same (as would be the case between a utility and standby generator source), manually initiated transfers shall be delayed by the Liebert® STS2 until the two sources are within the user-adjustable phase synchronization window.
4. **Emergency Transfer.** In an effort to maintain power to the load, upon loss of the source that the load is connected to, the Liebert® STS2 shall automatically transfer to the other source in less than 1/4 cycle, overriding any retransfer time delays or other inhibits except load overcurrent providing that the other source is available. If one source is shorted upstream, causing an undervoltage condition on that source, the Liebert® STS2 will sense the undervoltage and transfer to the alternate source.
5. **SCR Failure.** The Liebert® STS2 shall continuously monitor the status of the SCR switching devices for proper operation. In the event of a shorted SCR on the source powering the load, the Liebert® STS2 shall automatically alarm the condition and trip open the other source isolation MCS. In the event of a shorted SCR on the other source, the Liebert® STS2 shall automatically alarm the condition and trip open the other source isolation MCS. In the event of an open SCR, the switch shall automatically alarm the condition and transfer to the other source. All open and shorted SCR alarm conditions shall be latched and require the system to be repaired and reset to restore normal operation.
6. **System Bypass.** The Liebert® STS2 shall be furnished with key-interlocked maintenance bypass MCSs that allow the Liebert® STS2 power, controls and monitoring electronics to be bypassed to either input source for maintenance without interruption of power to the load. The packaging of the Liebert® STS2 shall have all electronics isolated from the input, output and bypass connections to allow servicing of any components without access to hazardous voltages when the unit is in maintenance bypass.

1.4.3 Performance Requirements

1. **Nominal Input/Output Voltage:** (208) (480) volts three phase, 3-wire-plus-ground
2. **Default Voltage Range:** +10%, -10% of nominal
3. **Nominal Frequency:** 60 Hz
4. **Maximum Continuous Current:** (400) (600) amps
5. **Source Voltage Distortion:** Up to 10% THD with notches and ringing transients
6. **Surge Protection:** Sustains input surges without damage per criteria listed in ANSI C62.41 Category B3
7. **Sensing and Transfer Time:** typically less than ¼ cycle
8. **Overload Capability:**
 - a. 400A: 125% for 30 minutes
 - b. 400A: 150% for 2 minutes
 - c. 400A: 500% for 15 cycles minimum
 - d. 600A: 125% for 10 minutes
 - e. 600A: 150% for 2 minutes
 - f. 600A: 500% for 15 cycles minimum
9. **Short Circuit Withstand Capability:**

	208-240V	380-480V
400-600A	65kA	65kA

1.4.4 Environmental Conditions

1. **Storage Temperature Range:** -20° to +70°C (-4° to 158°F)
2. **Operating Temperature Range:** 0° to 40°C (32° to 104°F)
3. **Relative Humidity:** 0 to 95% without condensation
4. **Operating Altitude:** Up to 4000 ft. (1200m) above sea level without derating. Above 4000 ft. (1200m), output current is derated by 6% per 1000 ft. (18% per 1000m).
5. **Storage/Transport Altitude:** Up to 40,000 ft. (12,200m) above sea level
6. **Audible Noise:** Less than 55 dBA at 5 ft. (1.5m) with audible alarm off

1.4.5 Reliability

MTBF

The Vertiv™ Liebert® STS2 shall be designed for high reliability and high availability with an MTBF exceeding 1,000,000 hours. To the fullest extent practical, redundant circuits and components shall be used to eliminate single points of failure.

Power Supply

Redundant power supplies shall be provided to prevent any single-point power supply failure mode. The Liebert® STS2 shall have two separate power supplies mounted on separate boards so a power supply can be replaced while the load is on bypass. There shall be two separate DC buses, one from each power supply, to provide redundancy throughout the controls.

Logic

Control logic shall be triple-redundant. Each of the three logic modules shall have its own separate power connection to each power supply bus. Each logic module shall be fused to prevent it from shorting the power supplies if an internal failure occurs. Gating and control logic shall be partitioned so that the failure of one source's gating or sensing logic does not prevent the switch from transferring to the other source.

Components

All electrical components requiring normal maintenance or repair shall be replaceable without de-energizing the load, if at least one source is available. Solid-state switching devices shall be packaged to allow safe repair of the switching devices without having to de-energize the load. All MCSs shall be of a plug-in type to allow replacement without de-energizing the load. All control and logic components shall be mounted separate from the power components.

Fuseless

No fuses are used to protect the solid-state power switching devices.

Access

The Vertiv™ Liebert® STS2 shall be designed for front and rear access. The Liebert® STS2 shall be designed so all installation, repairs and maintenance can be done from the front, rear or top of the unit. The Liebert® STS2 shall be designed to minimize the exposure of hazardous voltages to allow safe servicing of the unit while the load is energized.

2.0 PRODUCT

2.1 Fabrication

2.1.1 Materials

All materials of the Vertiv™ Liebert® STS2 shall be new, of current manufacture, high grade and free from all defects and shall not have been in prior service except as required during factory testing.

The maximum working voltage, current and di/dt of all solid-state power components and electronic devices shall not exceed 75% of the ratings established by their manufacturer. The operating temperature of solid-state component subassembly shall not be greater than 75% of their ratings.

2.1.2 Wiring

Wiring practices, materials and coding shall be in accordance with the requirements of the National Electrical Code (NFPA 70). All bolted connections of busbars, lugs and cables shall be in accordance with requirements of the National Electrical Code and other applicable standards. All electrical power connections are to be torqued to the required value and marked with a visual indicator.

Provision shall be made for power and control cables to enter or leave from the top or bottom of the Liebert® STS2 cabinet.

2.1.3 Frame and Enclosure

The Liebert® STS2 unit, comprised of solid-state, three-pole, dual-position transfer switch, key-interlocked static switch isolation and bypass MCSs, shall be housed in a single free-standing NEMA type 1 enclosure and meet IP20 requirements. The frame shall be constructed of galvanized steel and pop riveted to provide a strong substructure. The frame shall include four heavy-duty swivel castors for ease of installation and four permanent leveling feet for final installation. Doors and removable exterior panels shall be a minimum of 16GA steel and be powder-coated the manufacturer's standard color textured enamel finish paint. A key-lock, hinged front door shall provide access to the MCSs. A tool shall be required to remove exterior panels that expose hazardous voltages. All removable panels shall be grounded to the frame for safety and EMI/RFI protection. The cabinet shall be structurally designed to handle forklifting from the base.

Removable conduit/cable termination plates shall be provided in the top and bottom of the unit for termination of the two-source input and/or output conduits, raceways or cables. Top input can accommodate a top-hat conduit box with integral busbars for customer connections (optional).

The complete STS shall have maximum dimensions of 32 in./813 mm wide by 32 in./813 mm deep by 69.58 in./1765 mm high with panels.

The Liebert® STS2 can be tipped 15 degrees in any direction without falling over.

2.1.4 Cooling

The Liebert® STS2 shall utilize convection air cooling for the enclosure with forced air cooling of the heat sinks. All fans shall be redundant so that a single fan failure will not cause temperature to increase beyond acceptable limits. Individual sensor(s) are located on heat sinks for alarm and shutdown. Heat rejection shall be through screened protective openings in the top of the unit. Air filters shall be located in the front door at the point of air inlet.

2.1.5 Grounding

The Liebert® STS2 shall operate from sources that are solidly grounded or impedance-grounded (for 480V and below). The unit shall not be used on corner-grounded delta systems.

The Liebert® STS2 chassis shall have an equipment ground terminal.

2.2 Components

2.2.1 Molded-case Switches (MCS)

The Vertiv™ Liebert® STS2 shall be equipped with five MCSs. The MCSs shall be UL listed and IEC rated for use at the system voltage. The plug-in feature of the breaker shall include an interlock, which prevents the breaker from being unplugged without being in the Off or Trip (open) position. Three of the MCSs shall provide for total isolation of the solid-state switching devices with an input MCS for each source and a load isolation MCS. Two of the MCSs shall provide for maintenance bypassing of the solid-state switching devices to either input source. Key interlocks shall be provided on the MCSs to prevent improper maintenance bypassing of the solid-state switch. A bypass MCS cannot be closed unless the solid-state switch is connected to the same input source, and only one bypass MCS can be closed at a time. All MCSs shall be equipped with N.O. and N.C. auxiliary switches for monitoring of the breaker positions. The two input MCSs for the solid-state switching devices also shall be equipped with 48 VDC shunt trips to allow for control by the Liebert® STS2 logic.

2.2.2 Silicon Controlled Rectifiers (SCRs)

The Liebert® STS2 consist of six pairs of SCRs connected in an AC switch configuration. The SCRs shall be brick-type and rated to carry the full 100% rated load. The SCRs shall be rated to prevent hazardous device failure in power systems with available fault currents listed under Section 1.4.3, Item I.

2.2.3 Control Panel

The Liebert® STS2 shall be provided with a microprocessor-based Human-Machine Interface (HMI) to configure and monitor the Liebert® STS2. The HMI shall be located on the front of the unit and can be operated without opening the hinged front door. The HMI shall not be mounted to the front door so the door can be easily removed for maintenance. A backlit, menu-driven, full graphics, color touch-screen Liquid Crystal Display (LCD) shall be used to display system information, status information, a one-line diagram of the STS2, active alarms, alarm history information, startup and bypass instructions. No mechanical pushbuttons shall be used.

The mimic screen shall indicate the power flow, the status of all MCSs, the preferred source and the Liebert® STS2 position (connected to source 1 or 2) as well as active alarms.

Pop-up boxes selected from the menu bar shall be provided for operator interface to the HMI for menu selection, control of the preferred source, manual transfer initiation, auto/manual retransfer selection and other system setpoints. In addition, an operator can silence and reset the audible alarm by touching the screen. To facilitate STS operation, help text, step-by-step startup, transfer and maintenance bypass procedures shall be displayed on the LCD screen. For manual transfers, a synscope shall display the leading or lagging real-time phase difference between the two input sources.

The HMI shall be equipped with an internal RS232 port and Flash memory to allow the Liebert® STS2 software to be upgraded by a factory-trained customer engineer without shutting down the load.

To facilitate diagnostics, an event log of the last 512 alarm events shall be stored in non-volatile memory and displayed on the LCD. Two history logs, each having 64 frames of unit status frozen upon an alarm condition designated as a freeze fault, will be stored in non-volatile memory and displayable on the LCD. A frame shall be acquired approximately every 4 milliseconds, with 40 frames before the fault and 23 frames after the fault. Each frame contains metering data, active alarms/faults and unit status. A system calendar and real-time clock shall be included to time-stamp all stored events. Monitored parameters shall be acquired two times per 4-millisecond frame.

CAN bus shall be used to communicate between the logic and the HMI as well as the options.

For remote monitoring, a serial RS-232 port shall provide present switch status information, alarm history information and the history of status screens that are triggered upon a major alarm event.

Metering

The following metering parameters shall be displayed:

- Input AC voltage for both sources, line-to-line for each phase
- Input AC current for both sources for each phase
- Input frequency for both sources
- Output kVA
- Output kW
- Percent load
- Number of switch transfers
- Synchronization phase angle

All voltages and currents shall be measured using true-RMS techniques for accurate representation of non-sinusoidal waveforms associated with computers and other electronic loads. The metering parameters shall have a full-scale accuracy of $\pm 2\%$.

Alarm Messages

Active alarms shall be monitored and displayed simultaneously as part of the LCD event panel. The following alarm messages shall be displayed:

Source 1 Failure	CB1 (Source 1) Open	Power Supply S1 AC Failed
Source 2 Failure	CB2 (Source 2) Open	Power Supply S2 AC Failed
Sources Out of Sync	CB3 (Output) Open	Power Supply DC A Failed
Source 1 Overvoltage	CB3A Open (If used)	Power Supply DC B Failed
S1 Undervoltage (fast)	CB4 (S1 Bypass) Closed	Power Supply Logic Failed
S1 Undervoltage RMS (slow)	CB5 (S2 Bypass) Closed	S1 Voltage sense module failed
Source 2 Overvoltage	CB1 Shunt trip fail	S2 Voltage sense module failed
S2 Undervoltage (fast)	CB2 Shunt trip fail	S1 SCR sense module failed
S2 Undervoltage RMS (slow)	S1 SCR Open	S2 SCR sense module failed
Source 1 Overcurrent	S2 SCR Open	S1 Current sense module failed
Source 2 Overcurrent	S1 SCR Shorted	S2 Current sense module failed
Source 1 Over/Under Frequency	S2 SCR Shorted	S1 Gate drive module failed
Source 2 Over/Under Frequency	Primary fan failure	S2 Gate drive module failed
Source 1 Phase Rotation Error	Control Module Fail	Internal comm failed
Source 2 Phase Rotation Error	S1 I-peak	Option comm failed
Output undervoltage	S2 I-peak	Output voltage sense module failed
STS on alternate source	Auto Retransfer Inhibit	Heatsink Overtemp
Transfer Inhibit		

An audible alarm shall be activated when any of the alarms occurs. All alarms shall be displayed in text form.

2.3 Accessories (Optional Components and Services)

2.3.1 Optimized Transfer

The Vertiv™ Liebert® STS2 shall be furnished with an optimized transfer control algorithm. This algorithm shall optimize the Liebert® STS2 transfer timing such that the volt-seconds applied to a downstream transformer(s) primary is balanced, thus sufficiently minimizing peak saturation current drawn by the downstream transformer(s).

In addition to controlling the transformer primary current and flux, the optimized transfer control algorithm must maintain the load voltage within the CBME/ITIC Standards during the transfer. To maintain load voltage after the preferred source is turned off, the control algorithm must be able to pulse-fire the alternate source SCRs to minimize load discontinuity and voltage disruption.

The STS2 must maintain the above specification under the following conditions:

- a. Loss of source
- b. Loss of a single phase
- c. Voltage droop
- d. Phase-to-neutral short
- e. Phase-to-phase short
- f. Power factor load range of 0.75 to 1.0 leading or lagging
- g. Out-of-phase conditions from +180° to -180°

2.3.2 Programmable Relay Board

A Programmable Relay Board with eight sets of isolated Form C contacts shall be provided to indicate a change of status of any alarm condition. Any alarm can be programmed onto any channel or channels. Up to two programmable relay boards can be installed in the Liebert® STS2 SR. Programming is performed through the touch screen display. Each contact shall be rated 1A @ 30 VDC or 400mA @ 125 VAC.

2.3.3 Input Contact Isolator Board

An Input Contact Isolator Board with eight relay inputs (normally open dry contacts) shall be provided for owner alarm messages. The owner, through the touch screen display, can program the alarm messages.

2.3.4 Communications Board

The Liebert® STS2 shall be provided with a Communications Board that can communicate with a Vertiv™ Liebert® SiteScan™ monitoring system.

The Liebert® STS2 shall be equipped with an RS-422 communication port for communication to a Liebert® SiteScan™ monitoring system using a 2-wire twisted pair for reliable communication up to 3281 ft. (1000m). Information available from the RS-422 port shall include the present switch status information, all monitoring parameters and all active alarms.

2.3.5 Vertiv™ Liebert® IntelliSlot - IS-UNITY-DP Card

The Liebert® STS2 shall be supplied with up to one (1) IS-UNITY-DP Card for remote communication using two of the following protocols: HTTP/HTTPS, Emerson Protocol, Email, SMS, SNMP v1/v2c/v3, BACnet IP/MSTP and Vertiv™ Liebert® Modbus TCP/RTU output. A serial RS-485 two-wire connector shall be supplied.

NOTE: Two of the 3rd party protocols (SNMP, Modbus or BACnet) may be configured and used simultaneously. Modbus RTU and BACnet MSTP cannot both be enabled simultaneously.

2.3.6 Remote Source Selection

The Vertiv™ Liebert® STS2 shall be furnished with Remote Source Selection board to remotely select the preferred source. Closure of one of the two N.O. dry contacts (by others) shall cause the selected source to be the preferred source to which the Liebert® STS2 will connect the load as long as the source is available in the same manner as the local source transfer selection. If both input contacts are closed, the current selected preferred source shall be retained. If the unit preferred source selection and remote source selection shall be active at the same time, the Liebert® STS2 follows the last request for a preferred source change, regardless of whether it was from the local or remote source select controls.

2.3.7 Key Lockout Switch

A key lockout switch shall be provided which activates a software lockout of the touch-screen display to prevent manual transfers and configuration changes. When locked out, the touch screen becomes a read-only display and a key is required to do manual transfers or change settings. The alarm silence button shall not be disabled when in the lockout position. The switch shall be located behind the front door but can be operated without opening the front door.

2.3.8 Redundant Output MCS

A redundant output plug-in, MCS shall be provided and connected in parallel with the output plug-in, MCS to provide redundancy in the output power path. The redundant MCS shall be of the same rating and type as the output MCS.

2.3.9 Certified Test Report

A certified copy of the factory test report shall be provided for each unit.

2.3.10 Factory Witness Test

The owner and/or the owner's representative shall attend a factory test of each unit. The factory will perform its standard witness test to demonstrate that the unit meets the Liebert® STS2 specification.

3.0 EXECUTION

3.1 Field Quality Control

The following inspections and test procedures shall be performed by factory-trained field service personnel during the Vertiv™ Liebert® STS2 startup.

3.1.1 Visual Inspection

- Inspect equipment for signs of damage.
- Verify installation per drawings.
- Inspect cabinets for foreign objects.
- Verify neutral (if used) and ground conductors are properly sized and configured.
- Verify all printed circuit boards are configured properly.

3.1.2 Mechanical Inspection

- Check all control wiring connections for tightness.
- Check all power wiring connections for tightness.
- Check all terminal screws, nuts and spade lugs for tightness.

3.1.3 Electrical Inspection

- Check all fuses for continuity.
- Confirm input voltage and phase rotation is correct.
- Verify control transformer connections are correct for voltages being used.

3.2 Manufacturer's Field Service

3.2.1 Service Personnel

The Liebert® STS2 manufacturer shall directly employ a nationwide service organization, consisting of factory-trained field service personnel dedicated to the startup, maintenance and repair of UPS and power equipment. The organization shall consist of regional and local offices.

The manufacturer shall provide a fully automated national dispatch center to coordinate field service personnel schedules. One toll-free number shall reach a qualified support person 24 hours/day, 7 days/week, 365 days/year. If emergency service is required, response time shall be 20 minutes or less.

An automated procedure shall be in place to ensure that the manufacturer is dedicating the appropriate technical support resources to match escalating customer needs.

3.2.2 Replacement Parts Stocking

Parts shall be available through an extensive network to ensure round-the-clock parts availability throughout the country.

Recommended spare parts shall be fully stocked by local field service personnel with backup available from the national parts center and the manufacturing location. The national parts center Customer Support Parts Coordinators shall be on call 24 hours/day, 7 days/week, 365 days/year for immediate parts availability. Parts from the national parts center shall be shipped within 4 hours on the next available flight out and delivered to the customer's site within 24 hours.

3.2.3 STS Maintenance Training

Maintenance training courses for customer employees shall be made available by the STS2 manufacturer. This training is in addition to the basic operator training conducted as a part of the system startup.

The training course shall cover STS theory, location of subassemblies, safety and STS operational procedures. The course shall include control, metering and feedback circuits to the Printed Circuit Board (PCB) level. Troubleshooting and fault isolation using alarm information and internal self-diagnostics should be stressed.

3.2.4 Maintenance Contracts

A complete offering of preventive and full service maintenance contracts for the STS2 shall be available. An extended warranty and preventive maintenance package shall be available. Factory-trained service personnel shall perform warranty and preventive maintenance service.

NOTE: These Guide Specifications comply with the format outlined by the Construction Specifications Institute per CSI MP-2-1 and CSI MP-2-2. In correspondence, reference Liebert document SL-20610_REV07_05-16.