



MAHAGANPATI ASSOCIATE

Gat No. 887, Khedkar Vast, Ranjangaon Ganapati, Shirur, Pune 412209

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GSTIN No.: 27LCWPK4064P1ZD State 27- Maharashtra

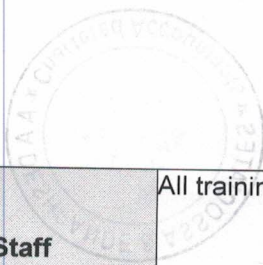
Date: 03/03/2023

Method Statement

Ref No.:77

| | | | |
|--|--|---------------------------------------|------------------------|
| Description of the Task/Activity: | MANUFACTURING OF FURNACE | | |
| Project Name: | Alicon Castalloy Ltd | Project Ref: | DPT-02-03-563 |
| Site Address/ Location: | Gat No 1450 Shikrapur Shirur Pune | Start Date/Time: | 05/03/2023 |
| | | Finish Date/Time: | 18/04/2023 |
| Personnel involved: | Name | Role/Trade | |
| | Dhanaji Shinde | Worker | |
| | SANJAY MARUTI TODKAR | Worker | |
| | DHANAJI MADHAVRAO SHINDE | Worker | |
| | SUBHASH NAMDEV DHUMAL | Worker | |
| | | | |
| Works Supervisor: | KANIF HARIBHAU KOLHE | Role: Manager (Supervise Work) | Tel: 9860526639 |
| Key Plant and Tools Required: | Drawings, Cuter, Manufacturing tools etc. | | |
| Key Materials Required: | Stainless steel, aluminized steel, aluminum, brass, copper, and fiberglass | | |
| Other Essential Equipment: | Tools and Fixtures | | |
| Specific Identified Residual Hazards: (or refer to the task specific risk assessment(s)) | None | | |





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| <p>Specific Staff Training Requirements:</p> | <p>All training related to manufacturing furnace is given.</p> |
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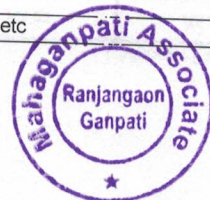















Sequence of Operations:

(Specifying methods of working, tools, materials and equipment utilised)


1. • The primary heat exchanger is formed from two separate pieces of 409 stainless steel sheet. Each half is formed into shape by a 400 ton hydraulic press. The two halves are then fused together by a 25 ton hydraulic press.
- The secondary heat exchanger is formed from 29-4°C stainless steel tubing and fins. The fins are welded to the tubing to form a radiator type configuration.
- The primary heat exchanger is crimped to the secondary heat exchanger through a transition box. The flue draft blower is attached to the secondary heat exchanger.
- The burners are constructed of aluminized steel and arrive at the plant preformed. They are then attached to a plate on the input side of the primary heat exchanger. There is one burner for each heat exchanger in the furnace.
- The vendor supplied gas control valve is mounted to the heat exchanger and burner assembly. It is connected to the burner through a pipe.
- The air circulation blower housing is formed through the same hydraulic press formation as the primary heat exchanger. The vendor supplied motor and squirrel cage rotor are connected and attached to the blower housing with brackets.
- A plate is then attached for mounting the blower assembly to the heat exchanger assembly. Another mounting plate containing the vendor supplied furnace control circuitry and transformer are attached to the blower housing.
- The air circulation blower assembly is then mounted to the heat exchanger assembly with screws and nuts.
- The cabinet consists of two doors and the cabinet housing. The cabinet housing is supplied as a flat pre-painted sheet of steel and placed in a hydraulic press to form a three sided configuration. Sheets of fiberglass insulation are glued to the sides of the cabinet.
- The cabinet is installed around the furnace assembly and secured with screws and nuts. The doors are installed on the front of the cabinet assembly. The completed assembly is boxed and prepared for shipment.

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| <p>Temporary Supports and Props needed to facilitate the works:</p> | <p>None</p> |
| <p>Method of Access and Egress to the work area:</p> | <p>Ladders/MEWPS/Scaffold/Trestles/Step Ladder etc</p> |
| <p>Fall Protection Measures: (Where work at height cannot be eliminated - consider both Personnel & Materials)</p> | <p>Guard Rails/Toe Boards/Brick Guards/Safety Harnesses/Exclusion Zones etc</p> |
| | <p>Lubricants/Solvents/Flammable Materials/Refrigerants/Welding Gases etc</p> |



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|---|--|---|--|---|--|---|--|
| Hazardous Substances: (Attach COSHH Assessments and MSDS) |  Very Toxic |  Harmful/Irritant |  Corrosive |  Dangerous for the environment |  Oxidising |  Highly flammable |  Explosive |
| | Applicable: | No | No | Yes | No | Yes | Yes |
| SWL's: | (Detail any limits on the loadings applicable to temporary plant/equipment or fixed elements of the structure where the work is taking place.) | | | | | | |
| Required Personnel Protective Equip.: |  Safety Boots |  Hard Hats |  Safety Gloves |  Hearing Protection |  Respiratory Protection |  Eye Protection | Other: 1. Hi-Viz 2. Coveralls 3. |
| | Yes | Yes | Yes | Yes | Yes | Yes | |



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| Emergency Procedures: | Call Ambulance to reach near Multispecialty Hospital located in Shikrapur. | |
|  | First Aid Facilities: | Name of On-Site First Aider: Pawan Deshmukh |
| | First Aid Box Location: | At Employee Rest Room |
| | Location of Nearest Hospital: | |
| Other Information & Comments: | | |

All work will be undertaken by qualified competent persons with experience of the type of work described above, and in all cases in full accordance with safety procedures specified in the companies Health and Safety Policy.

Pawan Deshmukh
Prepared by: Pawan Deshmukh

Position: Production Manager

Date: 03/03/2023

Kanif Kolhe
Reviewed by: Kanif Kolhe

Position: Manager

Date: 03/03/2023

