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METHOD STATEMENT FOR FUEL SYSTEM (DIESEL SUPPLY SYSTEM FOR GENERATOR)

Project No:	
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REVISION HISTORY	ISSUE DATE	DESCRIPTION	REVIEW / STATUS
00			

PREPARED BY:	REVIEWED & APPROVED BY:
QA QC ENGINEER	PROJECT ENGINEER

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1.0. Scope of Work

Installation & connection with the Generator.

1.1.1. Painting of Pipe:

- Check the Clean the pipe is clean for any dust or grease on the pipes before installation.
- The paint will be done per the manufacturer's recommendation, per project specification.
- Painting requirements for flow direction identification with color code.
- Pipe will be painted as per approved material Please ensure both sides (top & bottom) are painted evenly.
- The painting area shall be barricaded with corrugated sheets or any other appropriate methods to control the accumulation of sand inside.
- Safe and level work surfaces/Platforms shall be provided for personnel performing preparation, blasting and painting activities
- Eye wash facilities shall be available near the work area.
- Airless spray equipment shall be properly grounded before use
- Painting shall not be performed if one or more of the following conditions exist unless the coating is specifically formulated for the averted conditions
- The substrate temperature is less than or more than the temperature limit given in the applicable product datasheet.
- Threaded Joining Method will be used for all piping systems.

1.1.2. Threading the pipes:

- Start the machine and feed the material into the die head. Maintain sufficient force on the carriage to ensure the dies do not have to pull the carriage and tools along with them.
- The helix angle of the dies (q.v.) is a critical feature of the die segment, as it is responsible for propelling the dies forward over the material.
- Any additional forces that hinder or accelerate this motion against the helix angles will lead to deformed threads.
- Ensure a steady flow of high-quality cutting fluid to the die head, sufficient to fully flood the cutting surfaces of the die segments.

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- Periodically pause during thread cutting to inspect the condition of the dies.
- Verify that the dies are not becoming dull or accumulating fused or welded material on the cutting edges.
- If either of these issues is detected, stop the operation immediately. Continuing to use dull or fused dies will damage the threads and likely ruin the dies as well.

1.1.3. Threaded fittings pipe joint installation:

- Trained and skilled personnel will be used to perform the joint installation.
- Clean the interior and exterior surfaces of pipes and fittings, ensuring the removal of scale, slag, dirt, and debris prior to assembly.
- Thread pipe with tapered pipe threads according to ASME B1.20.1. Cut threads fully clean
- Using sharp dies. Ream threaded pipe ends to remove burrs and restore the full inside diameter (ID) of the pipes.
- Measure the internal thread length within fittings or valve ends and assess the position of the internal seat or wall to determine the appropriate depth for threading the pipe into the joint
- Measure the length of pipes required for installation, marking due allowance for any pipe fitting to be used, and cut the piece to the measured length ensuring that the end cut is squared and the burr is removed from the pipe.
- Use emery paper and cloth to clear the pipes from rust and dust.
- Paint the pipes with the approved type & color (follow instructions from the manufacturer recommendation)
- Apply several windings of pipe thread tapes over the threaded ends of pipes.
- Align threads at the point of assembly.
- Use a wrench to securely tighten the joint. Apply the wrench to the pipes, fittings, and valve ends where the pipe is being threaded.
- Avoid using pipes or fittings with damaged or corroded threads, as they may compromise the connection.
- Check if the paint needs retouching due to any scratches that occurred on the pipes during installation.

1.1.4. Installation of piping:

- The new pipes will be installed in the positions. All connections shall be cleaned and inspected before installing the pipes.

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- Ensure workers are wearing the required mandatory protective clothing, equipment, and other additional safety equipment necessary before execution of works.
- Ensure that scaffolding equipment is safe to use or marked “green” by the safety department
- Ensure a copy of the approved construction piping layout and detailed drawings showing floor plans, elevation, and details indicating penetrations in floor and walls and their relationship to other trade installation.
- Inspect and confirm the placement of necessary sleeves for pipe penetrations through floors, walls, and roof structures.
- Refer also to the layout and drawing indicating penetration and installation in floors, walls, and roofs for pipe sleeves.
- The pipes must be buried a minimum of under 0.4m from ground level. Also, it is recommended to insulate the piping before covering with sand where temperature exceeds 40C in summer.
- In the case of a submersible pump, the piping must be designed in such a way that the shearing level of the shear valve must match with its land level.
- All above-ground pipework should be protected against mechanical damage.
- Before installation, all fittings and pipe sections shall be inspected and cleaned inside to ensure the absence of dust, grease, rust, and foreign matters.
- During installation, precautions shall be taken to prevent pipe connections from contamination. Exposed threads after connection shall be immediately treated and coated against corrosion.
- Pipework passing through wall or ground slab shall be sleeved and sealed properly with suitable corrosion protection materials.
- Connection with the Generators: All the piping connections will be done with the (2) generators installed as per the drawing.

1.1.5. Pressure testing:

- Isolate the pipework to be tested at both ends.
- Fit a test rig at one end of the line and fit a blank to the other end
- Introduce air pre into the line.
- All pipe work must be subjected to an air pressure test (pneumatic) {150 percent of the maximum anticipated pressure of the system = 3.75 (nominal =4 bar)} The test pressure

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shall be maintained for a minimum of 2 hours while the joints are inspected for leakage
(Note: for more than 10 minutes minimum as per NFPA 30 standards)

- The test Performed before the equipment's are connected to ensure no leakages.
- Calibrated and certified pressure gauge should be used in the pressure test as per project specification and NFPA standards
- Apply soapy water to all exposed joints and check for leaks.
- Check for any pressure drop in the line after each (10) minutes. If there has been no loss of pressure, the line is sound, and a Line Test Certificate can be issued.
- If the line has lost pressure and there are signs of leakage on the exposed joints, the line has failed and must not be put into service.
- Line failure must be reported to the Site Manager.
- On completion of the tests, reconnect the lines and in the case of suction lines, prime the pumps
- Repeat test for all pipe work and issue certification on completion
- The protection of pipe joints, bends, fittings, and similar from corrosion underground (buried). To protect the substrate from the environment.
- Ensure full coverage and maintain close contact with the entire surface.

1.1.6. Installation of Filling Box:

- Remove the packaging materials from the unit.
- Thoroughly inspect the unit for shipping damage. If damage is found, do not use the unit.
- The unit features a mounting port on its base for installation.
- Additionally, mounting brackets are located on the top and bottom of the rear panel. Use these brackets along with appropriate bolts and nuts (not included) to securely mount the unit
- The piping connection outlet should be plumb/square to facilitate proper connection of the mating pipe.
- Proper cutting of the gypsum board will be done as per the filling box drawing.
- Use thread sealant on the threaded pipe connection on the unit.
- Attach the desired mating pipe, or pipe fitting, to the connection on the unit.
- All elements of this system, including the grounding stud, piping, and tank must be connected to a common earth electrical ground.

WARNING: Before final inspection and placing the system in service, it is the responsibility of the installer to pressure test the entire piping assembly, to ensure the integrity of the piping, valves, and fittings.

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Testing parameters listed in NFPA30 should be followed and performed by someone familiar with these systems.

1.1.7. Installation of the daily tank above ground:

- A. Tank Piping
 - Prior to starting the piping or installing any accessories, ensure that all shipping caps are removed from each flange.
- B. Tank Vent
 - Each tank shall be adequately vented to prevent the build-up of pressure or vacuum inside the tank when filling, emptying, or when subjected to atmospheric temperature changes. The vent shall be in no case smaller than 1 ¼" nominal inside diameter.
- C. Openings Below Liquid Level
 - Each opening below the liquid level through which liquid does not normally flow shall be plugged with a liquid-tight closure.
- D. Openings Above Liquid Level
 - Any openings that are not utilized upon completion of the installation must be securely sealed using a liquid-tight metal threaded pipe plug.

1.1.8. Electrical Installation:

- All cables connecting the equipment, submersible pumps, and other accessories shall go through conduits. The communication cable must use a separate conduit if it's used
- Conduits must be run directly from the distribution room for each equipment.
- The cables should be oil-resistant with copper core for equipment, submersible pumps, and other accessories.
- The main power switch shall be installed indoors. The capacity of the switches and fuses shall comply with the dispenser-rated amperages.

1.1.9. Earthing:

- All equipment like submersible pumps and equipment should be effectively connected to the earth and bonded to prevent electrostatic accumulation
- The whole electrical system should be grounded to the earth by the main electrical panel connected to a copper-clad ground rod.
- An Earthing point should be provided at the tanker bay for discharging static electricity from road tankers.

1.1.10. Installation of fuel system components & accessories:

- The new fuel system components will be installed in the positions.

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- All connections shall be cleaned and inspected for wear and tear before installing the fuel system components.
- All installation should be according to approved material, as per project specification and manufacturer recommendation.

1.1.11. Installation of tank monitoring system (EVO):

- Visually inspect all components for defects or damage before installation.
- Install the console in an indoor, non-hazardous area. Ensure it is positioned in a location that is easily accessible for personnel to operate.
- The console must be mounted in a location where explosive or flammable vapors are not present, otherwise, an explosion hazard will be created which can result in severe injury, death, serious property damage, and/or environmental contamination
- The console features two mounting screw holes positioned on its interior. Use fasteners that have enough load-carrying capacity and which are appropriate for wall construction.
- Make sure that there is enough room around the console for conduit coming to the unit.
- Use the FFS-approved, moisture-resistant, no-strip splice connectors Supplied with the device for liquid-level probes.
- 20 Amp — providing power only for the console.
- Use Schedule 40 2" riser pipes for liquid level probes installation.
- The appropriate FFS 2" or 4" probe installation kit must be used when installing TSPLL2 (not -I) leak detection probes and/or Density Measurement float kits.
- Use the manufacturer's Tank Chart and other documentation for installation and programming.

Overfill valve installation:

1.1.12. Visually inspect all components for defects or damage before installation.

1.1.13. Remove the tight fill cap and adaptor and the existing drop tube from the tank riser pipe.

Measure the distance from the top of the riser pipe to the inside of the tank.

MARK THE TUBE:

Place the measuring "stick" on the bottom side of the upper drop tube flange.

SECURE THE TEMPLATE:

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Wrap the drilling template TIGHTLY around the drop tube so that the side marked "cut end" is on the mark made in Step 2 and the two reference lines of the template are lined up where they overlap to ensure a square cut off

- 1.1.14. Carefully drill (5) 1/16 dia. pilot holes through the drop tube at the positions marked
- 1.1.15. Remove the hose clamp and drilling template from the upper tube. Remove the burrs from the drilling and sawing operations from the inside of the drop tube with a fine half-round file or other appropriate debarring tool. Make sure the cut end of the tube is flat and square.
- 1.1.16. Measure 5/16" up from the cut edge and drill a 1/16" pilot hole between lines in the groove.
Re-drill with an 11/64" drill

APPLY SEALANT AND INSTALL UPPER TUBE:

Remove the yellow warning tag attached to the valve. Locate the upper drop tube onto the valve body and push the tube past the sealant until it sits on the machined shoulder. Make sure all (3) holes are in perfect alignment with the countersunk holes on the valve body.

INSTALL SCREWS:

Assemble the screw and tighten. Repeat on two remaining screws. Wipe off excess sealant.

INSTALL LOWER TUBE:

Slide the drilled and dimpled end of the lower drop tube onto the bottom of the valve body, aligning the (3) dimpled holes with the tapped holes in the body, assemble (3) screws and tighten

CUT DROP TUBE AT 45° ANGLE:

Mark the overall length of the drop tube a minimum distance of B minus 6" or a from the measurements taken in Step 1 Saw off the excess material at an angle of 45° and remove sharp burrs.

REMOVE ELASTIC BAND:

Remove the elastic band securing the float to the valve body. The float will move into an outward position

INSERT THE DROP TUBE:

Hold the float down into the valve body and insert the drop tube overfill valve into the riser pipe

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CHECK INSTALLATION:

Insert the drop tube all the way into the tank until the flange and gasket seat onto the riser pipe. The float will swing out into the operating position as passes into the tank. Make sure the overfill prevention equipment does not interfere with other tank components. Float must not be obstructed from fully extending.

2.0. Testing & Commissioning

2.1. System Description:

The Fuel Oil System consists of (2) fuel oil storage tank, (2) fuel oil submersible pumps for each tank, one daily tank, one Overfill Prevention Valve for each storage tank ,1 control panel for all system,1 set tank monitoring system with level and control probe for each tank.

2.1.1. Testing:

GENERAL MECHANICAL CHECK:

- a. The testing of the work operations will be done according to the contract, Testing & Commission standards, codes of practice, approved drawings, specifications and manuals.
- b. Manufacturer reports/catalogues for fuel transfer pumps, and equipment, etc. shall also be checked accordingly. All testing and commissioning work shall be carried out by suitably trained and competent persons.
- c. Appropriate personal protective clothing PPE (Personal Protective Equipment) and safety equipment used by people involved for fuel station testing.
- d. During the process of testing and commissioning, display warning sign boards necessarily provided and barricade the area, if required.
- e. Check whether required guards are provided for rotating equipment's before first start up.

2.1.2. Test equipment (tools) list:

The necessary minimum equipment / tools to carry out the work are detailed in the table below:

2.1.3. Test personnel:

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The overall personnel and skill requirements for this test are the following:

1. One T&C Engineer
2. Two T&C Technicians.

T&C Engineer shall attend the test to make sure from power supply availability, required voltage, required frequency, required earthing, required protection and any electrical safety.

2.1.4. Installed Products Commissioning /Start-up test report:

Installed Products commissioning /Start-up, test records or certificates contain, the following information:

- a. Start-up test report for Pipes & fittings.
- b. Start-up test report for Vent Cap.
- c. Start-up test report for filling box
- d. Start-up test report for fuel oil submersible pump.
- e. Start-up test report for main storage tanks
- f. Start-up test report for daily tank.
- g. Start-up test report for control panel.
- h. Start-up test report for tank monitoring.
- i. Start-up test report for tank monitoring probes.
- j. Start-up test report for hand pump.

2.1.5. Pre commissioning:

The purpose of this procedure is to outline the step-by-step methodology for implementing proper practices during the pre-commissioning and commissioning of the "Fuel Oil System." The guidelines provided herein ensure that the execution of the work aligns with project requirements and achieves the intended functionality to a satisfactory level.

The following pre-requisites must be fulfilled:

- a. Completion of all pre-commissioning testing.
- b. Verify that the system installation is fully completed and that mechanical completion has been officially approved.

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- c. Confirm that no damage has occurred between the stages of mechanical completion and pre-commissioning.
 - d. Repair all damages to the equipment & piping.
 - e. Check that the Fuel Oil piping network is complete with proper filling pipe valves & pressure switches in place as per final approved shop drawing.
 - f. Ensure that the fuel oil pumps are as per approved material submittal.
 - g. Approval of snag items / clearance of items affecting testing and commissioning.
 - h. Confirmation that the system conforms to the requirements of the specification.
- A. The following pre-requisites must be fulfilled:
- Completion of all pre-commissioning testing.
 - Verify that the system installation is fully completed and that mechanical completion has been approved.
 - Confirm that the fuel oil supply piping network is fully installed, including the proper placement of valves, drains, vents, strainers, pressure switches, and isolation valves.
 - Check the Gasket and Proper Sealing.
 - Check pipes & fittings are properly supported.
 - Ensure that all relevant valves & pump discharge valve are in open position.
 - Opening the suction and discharge valve and checking visually the leakage at suction, discharge piping, pressure gauge port and mechanical seal if found any leakage rectify the same before start- up.
 - Verify that no damage has occurred between mechanical completions and pre-commissioning. Repair any identified damage to equipment and piping.
Ensure sufficient lighting is available in the work area during nighttime operations.
Secure all service area or work area openings with appropriate barricades, caution tape, and safety nets.
 - All test records and certificates shall be maintained and updated for the service life of the station
 - Visual Check cracks on the Tank (Absence of defects and physical damage)
 - Visual Check piping connection. (All connection not present damage or cracks.)
 - Installation of the fuel oil system control panel is completed.
 - Power available, in case building permanent power not available during time of commissioning, temporary generator power can be used to test fuel oil system Pumps and accessories.
 - Obtain all required permits.
 - Method Statement checking and approval.

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- No visible sign of cracks, damages, rust etc. on fuel oil system pumps and accessories.
 - Record the fuel oil system pumps and accessories Manufacturer name, Model number and serial numbers.
 - Test Documentation available.
 - Pipework pressure testing completed and approved.
- B. Electrical check:
- Ensure electrical termination is completed and has received approval.
 - Ensure that electrical power connections is proper.
 - Check power supply matches fuel oil system Pumps and other accessories rated voltage in the devices name plate.
 - Ensure the electrical power supply is isolated and the switchgear is locked out, regardless of whether the work involves rotating equipment or electrical panels.
 - Check Supply Motor KW with respect to MCC/Panel.
 - All cables connecting the pumps and other accessories shall go through conduits. The communication cable must use a separate conduit if it's used
 - Conduits must be run directly from the control panel for each equipment's.
 - The cables should be copper core for pumps and other accessories.
 - The whole electrical system should be grounded to the earth
 - An Earthing point should be provided at tanker bay for discharging static electricity from road tankers.
 - Approval of snag items / clearance of items affecting testing and commissioning.
 - Confirmation that the system conforms to the requirements of the specification.
- C. Bulk storage tanks:
- Check the top of the tank is totally free of any storage and was not submitted to any heavy weight
 - The fill pipe (tank supply) and Vent pipes Installed.
 - Check if End of vent pipe terminate outside building with a vent cap having a free open area.
 - The fuel tank has been fitted with an approved content gauge unit and level sensing equipment.
- D. Daily tank:
- Top of the tank is totally free of any storage and was not submitted to any heavy weight and no Scratch/damage
 - Inspect the installation of the fill pipe (tank supply) and vent pipes.

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- Ensure the end of the vent pipe terminates outside the building, equipped with a vent cap that provides a free and open area
- Check Vent and fill pipe are properly supported independently from tank
- Open the tank inlet and outlet isolation valves
- The fuel tank is equipped with an approved content gauge unit and level sensing system.

E. Piping and valves:

- Shut off valves position to fully open position.
- All valves and control shut off has been provided and properly installed in lines
- Remove test plugs used during piping inspections and temporary sealing plugs installed during the piping installation process.
- Remove and clean strainer screens. Close drain valves.
- Confirm that all pre-commissioning checks are completed successfully.
- Attach suitable hazard warning notice at all main entrances in public places.
- Fill the fuel storage tank with diesel fuel

F. Filling box:

- Check for protective wraps, caps, plugs etc. Was removed before installing the unit.
- The filling free of defects, and the inside of free of foreign objects
- Visual examination and leak test of piping (No leak)
- Grounding Lug is used for filling line.

G. Over fill prevention valve:

- Check the over fill valve installed in bulk storage tank filling line
- The valve is free and no interface with any another equipment inside the tank
- The valve can be detached for maintenance or inspection purposes.
- Clean and inspect the valve to insure there is no debris (valve Interior clean)

H. Duplex transfer pumps:

- Pre-functional checklists are primarily static inspections and procedures to prepare the system for initial operation, start up (Energization).
- The tests are performed to make sure that all system components are installed correctly, and the system is ready for functional tests.
- Prior to commencing the pre-functional test, installed system must be checked for proper installation and connection as per method of statement.

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3.0. Tools, Plant & Equipment:

Before starting the activity of installation of Fuel Pump, Dispenser and all related accessories following tools / equipment should be arranged:

- Forklift/Crane
- Basic Electrical Tools
- Measuring Tape
- Portable Hand Tools
- Spirit Level / Water Level
- Angel Cutter
- Spanner / Screw Drivers
- Torque Wrench
- Electrical Grinding Machine
- Hot Work-Welding Machine
- Grinding Machine / Grooving Machine
- Drill Machine
- Chain Blocks
- Step Ladder
- Scaffolding with Platform
- Threading Machine

NOTES:

- All tools and equipment shall be functionally safe and checked regularly.
- All tools and equipment shall be free from any defects before delivery to site.
- Standard PPE kit (safety shoes, helmet, Hi vis. Vest) is not included in the above materials.
- However, PPE kit is mandatory for all site works.

4.0. List of Safety Equipment & PPE:

SERIAL NUMBER	ITEM NAME	QUANTITY	REMARKS

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5.0. Attachments:

- Risk Assessment
- Testing& Commissioning Plan
- Checklists