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## OCCASION

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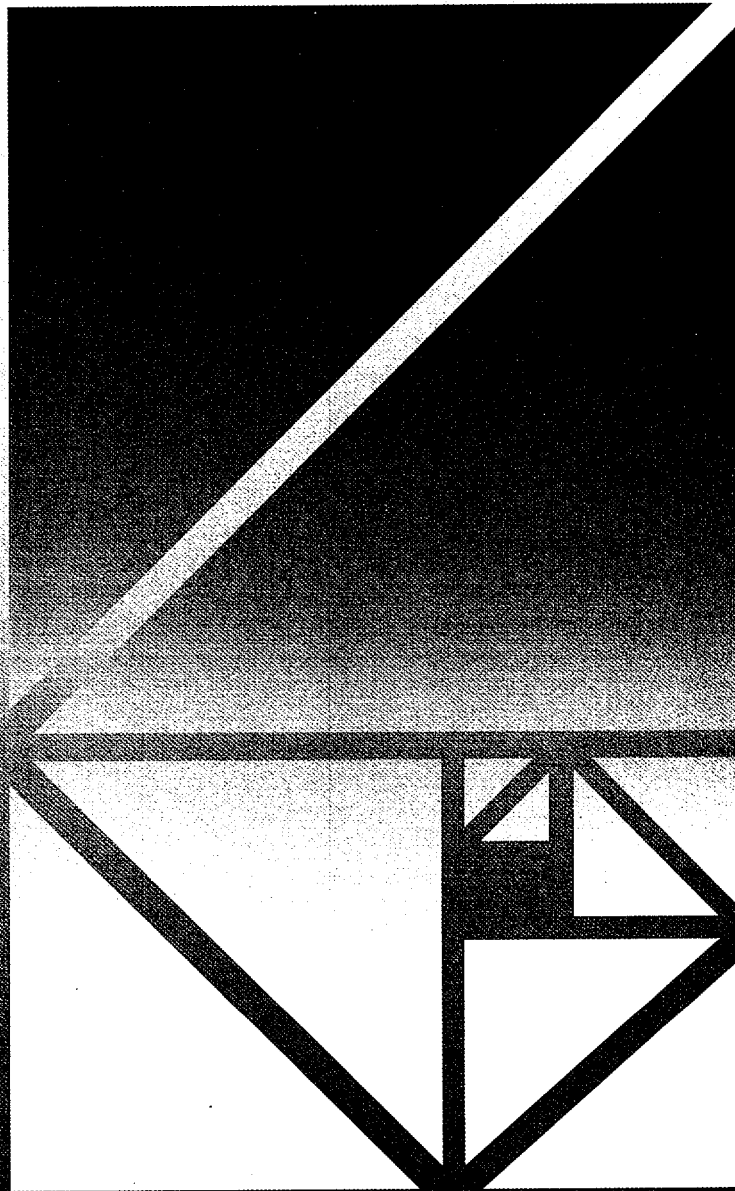
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# PERROS

INDUSTRIALE



**PROGRESS  
THROUGH  
ECOLOGY**

**UNIDO PROJECT NUMBER MP/EGY/95/038  
CONTRACT NO. 95/059**

**PHASING-OUT ODS AT THE REFRIGERATOR PLANT OF HELWAN  
COMPANY, CAIRO, EGYPT**

**FINAL REPORT**

**Report covering all activities as per steps 11 through 12**

**of**

**Terms of Reference**

**including the safety statement of the equipment made by TUV Germany**

## INTRODUCTION

This final report include the following documents:

- “CERTIFICATE OF ACCEPTANCE” signed up by the representative of HELWAN COMPANY FOR METALLIC APPLAINCE and Perros People after starting up the mass production of refrigerators made from 30<sup>th</sup> September to 3<sup>rd</sup> October 1999.
- Here attached is also the safety statement of the equipment made by TUV Germany.

**PERROS INDUSTRIALE S.p.A.**



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**G. BOSSI**  
Project Engineer

## CERTIFICATE OF FINAL ACCEPTANCE TEST

Customer : UNIDO  
P.O. BOX 300  
A-1400 WIEN  
AUSTRIA

Consigne : HELWAN CO. FOR METALLIC APPLIANCE  
Factory 360  
360 El Harby  
Helwan Hamamat - Omar Ebn Addel Aziz Str .  
P.O. BOX 11722  
CAIRO

SUPPLY : HIGH PRESSURE foaming machine and  
equipment for the use of Cyclopentane

Contract : UNIDO n 96/032

Perros reference : L11

From 30/9/1998 to 3/10/1998 C/O HELWAN CO . FOR METALLIC APPLIANCE , our technicians MR. Gianfrancesco and Mr Bianchi have finished the commissioning and have effected the final test of the following Plants :

- 1- Ecod 2-50 DS-P
- 2- Cyclopentane storage
- 3- Polyol storage -
- 4- Safty systems

Starting from 3/10/1998 the plants have successfully started to produce *with the components*  
Raw materials that were in the factory .

During the assembly and the final start -up of the plants the necessary training for operators, maintenance people was done by PERROS specialist .

Perros confirms its availability for supporting HELWAN CO.FOR METALLIC APPLIANCE to solve the pending problems mentioned on the attached minutes of commissioning ( see additional notes/remarks below)

And to solve all problems will occure in the plants in the future according to HELWAN requirements and perros /unido contract .

PERROS INDUSTRIALE SPA

HELWAN CO. FOR METALLIC APPLIANCE

*Professore Alberto*  
*Paolo Basso*

NOTES / remarks

*ok by*  
*3/10/98*  
*S. SHARABIM*  
*3.10.98*

- 1- perros will send the valve of the firing bottle
- 2- perros will send an offer for the recommended spare parts for 3 years
- 3- HELWAN shall declare the antestatic paint wich already shipped by perros and Helwan will paint the floor of the plants after recieved the instructions From perros.
- 4- maintenaince and operators people know how function of saftey system.



Trained group in Helwan Co.

Period 30.9.98 to 3.10.98

- 1- Fuad adly Ismaiel
- 2- Amro yassin Amro
- 3- Mohammed Hassan Abdelrahman

} production operators

- 4- Gameel Mahamoud ATeia → mechanical tech.
- 5- Fathe Ibrahim
- 6- Tarik Ahmed elsaid
- 7- Abdelghany hafiz

} electr. tech. maintenance group

otairky

31/10/98

S. SHARATH

3.10.998

Helwan Co. For metallic appliances



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Unternehmensgruppe TÜV Süddeutschland

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PERROS INDUSTRIALE SPA

Mr. Brianzoni  
Technical Manager  
Strada per Cassinetta, 6

Seite 1 von 5

I - 20081 Abbiategrosso (Milano)

Ihre Zeichen/Nachricht vom

Unsere Zeichen

Tel.-Durchwahl

Fax-Durchwahl

Datum

AW/ka

0731/4915-208

0731/4915-260

26. Oktober 1998

Richardt

K:\AWRICHARDT\8\_DATEN\PERROS\BF2\_BRIANZCNLDOC

Dear Mr. Brianzoni,

according to your request I enjoy to confirm following:

### 1. Background

TÜV-Süddeutschland  
Branch Ulm  
(following referred as TÜV)

has gained experience with safety engineering and certification for refrigerator and foam industries in many countries of the world. In conjunction with the progressive change-over to combustible blowing agents (Pentane, Pentane-Butane-blend) the experts of the Ulm branch of TÜV have used existing standards and developed together with experts of the PU field from engineering companies, plant producers, refrigerator producer and international organisation a safety strategy.

One part of the safety strategy is a safety evaluation of components of the PU plants and of all safety related parts of the plant.

All safety evaluations by the TÜV experts are based on International, European, German and particular national standards. The experience gathered with plant inspections and through evaluation of solutions based on measurements and the investigation of accidents since the start of plant conversion in 1992.

A special safety strategy was developed for fire and explosions hazards.



## 2. Safety evaluation

Safety evaluations by the TÜV experts basically cover the following tasks:

- Coordinate of the safety strategy with fire and explosion protection measures
- Review the feasibility of the proposed safety strategy
- Inspect existing buildings and technical facilities and components
- Functional testing of safety-related equipment at the plants
- Measurements at plant components under fire and explosion protection aspects
- Evaluate existing organisational procedures/requirements
- Review relevant parts of the documentation
- Define the state of the art of safety engineering by a comparison with plants used for similar purposes
- Per example following components of the safety system must be suitable, according to the rules and in good relation to each other:
  - Unloading station (plant specific) with filling pumps etc
  - Storage area (plant specific) with tank and equipment for different solutions
  - Grounding system
  - Wetpart (Components of Perros: Ecomix, Ecodosing, Ecokit), flexible pipes, Mixing head (often plant specific)
  - Drypart (Fixtures, Moulds, Heating system conveyer belts, needs always special solutions)
  - Building (fire proof walls, resistance of floor, Electrostatic, Lightning system, emergency exits, emergency light)
  - Safety panel (give signals and produce reactions together with parts of the equipment in case of failures in different levels)
  - Gas alarm system (depend often on the factory)
  - Ventilation system (depend on the particular situation)
  - Electrical data processing equipment (depend on particular situation)
  - Inertisation (depend on the design of fixtures and moulds)
  - Pentane emergency button (location depend on the particular situation)

- Back up Generator depend on the safety system at all (Ventilation, availability of Batteries for safety relevant systems)
- Marking of components
- Remote panel
- Documentation
- Measurements and protocols
- Safety related organisation.

### 3. Exemplary documents used as a basis for plant evaluation

Technical regulations:

These plant evaluation is based on international, European and national regulations - in that order - as far as these are available and applicable.

These include the following essential regulations:

- permits and requirements of public authorities
- international standards (ISO, IEC)
- Ordinance Regulation Facilities for Storing, Racking and Transporting Combustible Liquids - Germany: VbF
- Decree over electrical components in explosion proof areas. (In Germany ExeV)
- Pressure Vessel Decree (Germany DruckbehV)
- Law about the environment (Germany Immissionsschutzgesetz: BImSchG)
- Law for protection against water-polution (Germany: Wasserhaushaltsgesetz WHG)
- Electrotechnic regulations: international: IEC / European: EN / National: DIN VDE e.g. IEC 60073, IEC 439-1/A2, IEC 204-1, IEC 1310-2, EN 50054, EN 50013, EN 50020, EN 50081, EN 60529, pr. EN 1050, DIN VDE 0165, EN 349, EN 418, EN 294
- Fundamental safety aspects to be considered for measurement and control equipment: Germany DIN-V 19250
- Safety requirements for automated manufacturing systems: Germany VDI 2854
- personal protection regulations / accidents prevention -European: EN..EC / Germany UVV / ZH  
e.g. VBG 1, VBG 6, VBG 61, ZH 1/200, ZH 1/255, ZH 1/8; ZH 1/10

- Technical regulations for combustible liquids and for gases: Germany TRbF / TRG  
e.g. TRbF 100, 110 / TRG 280
- Ex-proof / spark-proof for ventilators: Germany VDMA-24169 part 1
- Homologation of technical plant and equipment - European: conformity certificates (e.g. PTB , Cesi, Damko)
- EN 378, Refrigerating systems and heat pumps, safety and environmental requirements
- pr EN 1612-2 Reaction molding machines
- EG machine directive (89/392 / ESG, revised edition 91/368 / EEC)
- CEI / IEG 335-2-24, Safety of household and similar electrical appliances
- IEC 79-10/EN 60079-10 / VDE 0165 Part 101: Electrical apparatus for explosive gas atmospheres - classification of hazardous areas
- IEC 79-XX in general

#### 4. Investigation of Perros components

TÜV has inspected in the past some refrigerator plants installed by Perros.

In the meantime the components like

- Storage tank
- Eco-mix
- Eco-kit
- Eco-Dosing

has been revised by Perros. The last revision of these components has been checked end of September 1998.

If Perros produce the above mentioned new components in the same way they will meet the TÜV requirements.

The safety of a PU plant at all can only be judged after all components are valuated and the construction and safety relevant functions between all parts is according to the rules and the particular safety strategy.

## 5. Conclusion

Each refrigerator factory which used Pentane as blowing agent needs a safety concept which includes the parts mentioned in chapter 2.

Some of the parts can be standardised but a lot of installations and regulations are very particular for each factory.

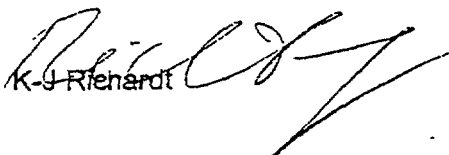
After we worked together with Perros we are able to state that the in chapter 4 mentioned parts of Perros can be included in a safety concept of a PU plant at all.

The parts like Ecokit, Ecodosing and Exomix in the last version met our safety requirements. The investigated Perros equipment together with a safe design, installation and organisation of the whole safety system are able to convert a refrigerator factory to a safe factory which can use Pentane as blowing agent.

TÜV Süddeutschland

Branch Ulm

The expert

  
K.-J. Richardt

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