VANSTONE PRECAST (PTY) LTD
Manufacturer

Customer	
User Client	Eskom
Project	Eskom Substation, Klerksdorp
Product	Trench Cover 750x300x55 vastrap

Order Requirements:

Customer Drawing	Vanstone Product Code	Number off	Description
0.54/390 17A	P4-7063	4000	Trench Cover Eskom 750x300x55 vastrap

METHOD STATEMENT

Introduction:
This method statement describes the manufacturing process for the above product/s.

Preparations:
Verify order received and financial arrangements in place.
Prepare manufacturing drawings.
Send drawings to Customer for review/approval.
After approval is received, issue drawings for manufacture
If applicable, observe QCP requirements throughout.

Manufacture:
Study drawing thoroughly.
Build casting moulds.
Cut bend and build reinforcing steel cages. Tack-weld together for sufficient rigidity to handle and maintain in place.
Place reinforcing steel in moulds using appropriate spacers.
Cast concrete and vibrate through.
After initial hardening, remove products from moulds, check, post-treat and cure. Load, secure and deliver.

Raw Materials:

Water: Potable from municipal source

Concrete mix:

Mix Recipe	C:W ratio	Binder	Coarse aggregate	Fine aggregate	Additive
No 57	±3:1	OPC 52.5N SANS 50197-1	19mm norite	Crushed norite	N/A
fcu = 30MPa		76kg	150kg	140kg	

Reinforcing Steel:
High yield steel and mild to SANS 920-2011
Mesh ref 635 as specified is not available.

Testing and Inspection:
Before casting: Check mould, check reinforcing steel, check spacers.
Final checks: Defects, appearance, marking if applicable.
Tests: Daily concrete cube tests and statistical result analysis and report.



16 Aug 2025

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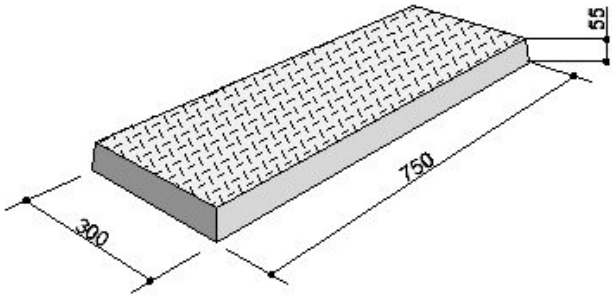
For Vanstone Precast (Pty) Ltd Date:

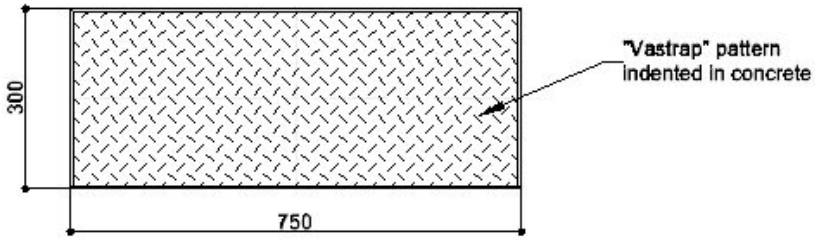
Pictures:



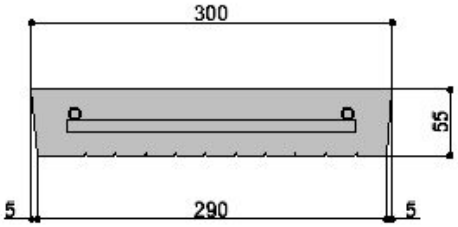


Drawing:





TOP VIEW



CROSS SECTION ENLARGED

SPECIFICATION:
Concrete:
30Mpa at 28 dyas
Reinforcing:
High tensile reinforcings bars to SANS 920
2 Y10 bars longitudinaly, 4 Y10 across
This is more than Ref 635 mesh.
Ref 635 mesh is not reinforcing but fencing
mesh and not made of high tensile rebar.

Quantity to Cast:	100	Product Name: TRENCH COVER ESKOM 0.54/390 Sheet 17A VASTRAP 750 x 300 x 55 REINFORCED Product Code: P4-7063
Concete Mix:	57	
Reinforcing: To be checked by Eng	Yes	

Vanstone