

(Garuda Emblem)  
**Notification of Ministry of Industry No. 18**  
**B.E. 2528 (1985)**  
**Issued pursuant to the Factory Act B.E. 2512 (1969)**  
**Re: Duty of a person engaging in a factory business**  
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By the virtue of section 39(12) and (16) of the Factory Act B.E. 2512 (1969), the Minister of Industry hereby issues the Ministerial Notification prescribing criteria and procedure for a person who receives a factory license to engage in a factory business as follows:

Article 1 All types of factory that make use of a boiler in its business shall arrange to have safety equipment as follows:

1.1 Two sets of safety valve, at least, shall be installed. Diameter size must be of at least 15 millimeters and easy for inspection. A boiler with surface area of less than 50 square meters may have only one set of safety valve. There shall not be a stop valve installed between a boiler and a safety valve and there shall be a steam vent from safety valve to a proper and safe place.

1.2 A water level gauge, glass tube type, shall be installed with a stop valve to check for water level and there shall be drainage to a proper place. There shall be protection equipment for glass tube as well.

1.3 A pressure gauge shall be installed with a diameter of at least 100 millimeters with scale range up to 1.5- 2 times of maximum operating pressure. There should be sign showing dangerous level as well.

1.4 A feed water pump shall be installed with capacity of at least 1.5 times of maximum operating pressure. The pumping capacity must be greater than rate of steam generation.

1.5 A check valve, with the same size to water inlet, shall be installed at water inlet to a boiler at the position as close to a boiler as possible.

1.6 A main steam valve shall be installed at a boiler.

1.7 A factory with two boilers or more sharing one steam pipe shall install a check valve at a pipe after a main steam valve of each boiler.

1.8 A pressure control and a water level control shall be installed in a boiler using liquid fuel such as oil, gas.

1.9 An automatic alarm shall be installed and working when the water level in a boiler lower than normal operating level.

1.10 There shall be insulation through out the length of steam pipe.

1.11 Water pipe, steam pipe, valves and other equipment of a boiler shall be the type for specific use in a boiler only and appropriate for operating pressure as well.

1.12 A step and walkway shall be available near a boiler having 3-meter height from the ground.

1.13 A blow down valve shall be installed to drain water from the bottom part of a boiler to a proper and safe place.

Article 2 All types of factory that make use of a boiler or similar equipment (the type using higher pressure than atmospheric pressure and having similar feature to a boiler) in its business shall arrange to have safety inspection for a boiler or similar equipment every year, at least once a year. An inspection shall be conducted by a professional or senior professional mechanical engineer or a special inspector for boiler inspection under the Engineering Professions Act B.E. 2505 (1962). An inspector shall submit a document endorsing safety in boiler use to Department of Industrial Works using the form prescribed by Department of Industrial Works within 30 days of the inspection date.

In case there is a restoration or reposition of a boiler or similar equipment, there shall be an inspection by the previously mentioned personnel after doing so. An inspector shall submit a document endorsing safety in boiler use to Department of Industrial Works using the form prescribed by Department of Industrial Works prior to operating such boiler.

Article 3 All types of factory that make use of a boiler or similar equipment (the type using higher pressure than atmospheric pressure and having similar feature to a boiler) in its business shall arrange to have operator for a boiler or such equipment with academic background of high vocational certificate in industrial mechanics, technician, or skilled person passing training course for boiler operator conducted by Department of Industrial Works or other institutes endorsed by Department of Industrial Works.

For a factory using a boiler with capacity of 20 tons per hour or more, other than that prescribed in paragraph one, there shall be arrangement of a mechanical engineer with an engineering license under the Engineering Professions Act B.E. 2505 (1962) working as supervise engineer for boiler.

Article 4 A factory engaging in a business relating to assembly or restoration of boiler or similar equipment shall arrange to have a mechanical engineer with an engineering license under the Engineering Professions Act B.E. 2505 (1962) working as supervisor for such assembly or restoration.

Article 5 Inspection engineer for a boiler, boiler operator, supervise engineer for a boiler, supervisor of boiler assembly or restoration as prescribed in Articles 2, 3 and 4 shall be registered with Department of Industrial Works according to criteria and procedure prescribed by Department of Industrial Works.

Article 6 In case personnel, that are supervise engineer for a boiler, supervisor of boiler assembly or restoration and boiler operator, being registered with Department of Industrial Works have resigned, are no longer in duty, have expired registration, are rejected from registration renewal or are revoked its registration, a factory entrepreneur shall notify Department of Industrial Works immediately and shall arrange substitution within 30 days from such event.

Article 7 This notification shall, thus, enter into force after the expiration of 90 days from the date of its publication in the Government Gazette.

Announced on the 20<sup>th</sup> day of February B.E. 2528 (1985)

(signed)

Aob Wasurat  
(Mr. Aob wasurat)  
Minister of Industry