

**ANDHRA PRADESH STATE ROAD TRANSPORT CORPORATION**

**Office of the VC & MD,  
MSRD:HYDERABAD-20.  
Dated : 14.06.2000.**

**No.TRI/807(I)/2000-MED**

**CIRCULAR No.22/2000-MED, Dated 14.06.2000**

**SUB: TOOLS - Standardization of tools to be used in Tyreshops for different kinds of jobs involved in repairing and recapping of tyres -Reg.**

**1.0 Tyreshops have been using different kinds of tools in various stages of production Viz. gousing, trimming, rasping, patch buffing, wire cutting etc. by procuring them from local market or from the sources identified by Zonal stores since past 10-15 years. On detailed study of the tools used to carry out various jobs in Tyreshops, the following aspects were noticed.**

**1.1 For a particular kind of operation, tools used are varying in shape, size, grit etc. from Tyreshop to Tyreshop. Some of the tools used by Tyreshops are not giving required finish on the rubber texture and nylon fabric.**

**1.2 Due to non-standardization of tools by Corporate office. Zonal stores have been procuring tools as per the opinion of AME (T) and Supervisors of Tyreshop. Some of the tools used in Tyreshops are found developing rupture on nylon fabric & un-evenness on rubber which may lead to patch failure, loose tread defect etc.**

**1.3 Zonal stores have been procuring tools from different sources which vary widely in respect of quality, durability. Some of the tools having equal/similar physical dimensions are found varying in functional values/utilities.**

**2.0 Service Engineers of M/s.Vikrant, M/s.Unipatch, M/s.Pang & M/s.Elgi have studied repairing & recapping practices in our Tyreshops from Nov '99 to Jan. 2000. The need for standardisation of tools was expressed by them in order to minimize patch failure and loose tread complaints.**

**2.1 The committee constituted by the VC & MD to study the facilities of tyreshops and suggest upgradations has examined this problem in detail. The committee examined the tools being used in various Tyreshops, finish obtained on fabric and rubber by using different kinds of tools, influence of tools on patch failures & loose treads etc. and obtained suggestions from supervisors and AMEs (T) on standardization of tools. After detailed study, the Committee finalized the standard list of tools to be used in Tyreshops for different kinds of jobs.**

**2.2 Proposed list of tools was given to all AME (Tyres) for study and to offer comments. AMEs (Tyres) have agreed 'unanimously' to standardise the tools as per the committee's recommendations.**

**2.3 Therefore it is now decided to standardise the following tools for regular use in Tyreshops to carry out different kinds of jobs connected to repairing and recapping of tyres.**

<b>SI. No.</b>	<b>CATELOGE No.</b>	<b>DESCRIPTION OF TOOL (OMNI)</b>	<b>BUFFER/RASPING MACHINE TO BE USED WITH TOOL</b>	<b>REQUIREMENT PER MONTH (EACH TRS)</b>
<b>I. RUBBER SURFACE PREPARATION:</b>				
1.	S2003 (OMNI)	Round faced rasp 36 Grit	4000 RPM rasp	6
2.	S2022 (OMNI)	Countour cups 36 Grit	4000 RPM rasp	6
3.	S2011 (OMNI)	Tapered cone rasp	4000 RPM rasp	6
4.	S897 (OMNI)	Rubber encapsulated brush	4000 RPM rasp	6
<b>II. PREPARATION OF INJURY:</b>				
5.	S280 (OMNI)	Mini-pointed carbide burr	22000 RPM buffer for S/W repair	3
6.	S283 * (OMNI)	Mini-Router carbide burr	22000 RPM buffer for S/W repair	3
7.	S282 (OMNI)	Pointed end carbide burr Repair	22000 RPM buffer for S/W and Crown	3
8.	S284 (OMNI)	Routes carbide burr	22000 RPM buffer for S/W and Crown repair	3
<b>III. PREPARATION &amp; FINAL FINISH OF INJURY:</b>				
9.	S875 (OMNI)	Conical stone	22000 RPM buffer	6
10.	S873 (OMNI)	Mushroom stone	22000 RPM buffer	24
<b>IV. REMOVAL OF SCORCH AND RUST:</b>				
11.	S892 (OMNI)	Wire brush	4000 RPM buffer	6
<b>V. RASPING TOOLS:</b>				
12.	SI 039 (APT)	High RPM, rear exhaust, Air buffer (2200 RPM)		2
13.	SI 038	Low RPM, rear exhaust. Air		2

	(APT)	buffer (4000 RPM)	
14.	SI 049 (APT)	Drill chuck long adopter	12
15.	SI 048 (APT)	Drill chuck short adopter	12

2.4 Though tools of OMNI and APT brands are proposed for standardisation at initial stage, equivalent tools of other makes will be tested and standardised by MED in due course of time. Evaluation of equivalent tools of other brands require adequate time to study suitability, performance, endurance etc. Therefore, it is decided to use OMNI/APT brand tools only at all Tyreshops till alternate brands are examined and standardised.

3.0 The following instructions are therefore issued.

- a) Tools of different types and brands already stocked in J ward and being used in different stages of production Viz. Gousing, trimming, rasping etc., shall be made NTR with immediate effect.
- b) Purchase orders and delivery schedules pending on the firms for the tools proposed for NTR shall be cancelled.
- c) Tools furnished in the above table shall be stocked and purchase orders be placed immediately.
- d) Stocks of tools already available in bins shall be consumed regularly till they are exhausted. Mean while, tools now standardised shall be procured from M/s. OMNI and APT.
- e) Stores shall not procure locally available tools for regular consumption in Tyreshops.
- f) If any firm approaches Zonal Stores/TRS with a proposal to supply tools which are similar to the tools now standardised they shall be directed to CME (O).
- g) CME (O) shall examine and evaluate the quality of tools of other brands, develop alternate sources and inform to Zonal Stores/ Tyreshops.

4.0 These instructions are issued to prevent Zonal Stores/ Tyreshops from procuring/using tools which cause damages to tyres. Standardised list of tools would help to minimise process and service failures. Controllers of Stores, Works Managers, AMEs (Tyres) are advised to take steps immediately as detailed above and submit compliance within a month. These instructions come into force with immediate effect.

4.1 For any clarification on the above, CME (O) and CCOS may be contacted.

Sd/-  
(P.ARJUNA)  
EXECUTIVE DIRECTOR(Engg)