ANDHRA PRADESH STATE ROAD TRANSPORT CORPORATION

O/o VC&MD,
No : TR2/791(2)/2016-17-MED. Vijayawada-13.

CIRCULAR NO:03 /2017-MED, Dt: 04.05.2017.

Sub: **MATERIALS** - Control of expenditure - Fixing of Norms for RC and Repairs in Tyre Retreading Shops for the year 2017-18 - Reg.

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Expenditure on Tyres and its related material is one of the major constituents of Profit & Loss accounts of the corporation. The Corporation incurred Rs.66.93 Cores for the year 2016-17 (upto Feb'2017) on New Tyres, Tubes & Flaps and the related material consumed in TRSs for recapping/ retreading/ repairing the Tyres.

The consumption of materials at TRS play a vital role in fixing the RC cost of the respective Tyre retreading shop. After critical analysis of cost benefit Circular No.17/2015, dated 21.11.2015 was issued regarding fitment of 9.00R20 Radial Tyres to all Telugu Velugu and City buses in place of 9.00N20 Nylon Tyres and also to provide 10.00R20 tyres to all Express, Saptagiry (Exp & Dlx), Delux & Super Luxury buses in a phased manner. Due to implementing the circular, the percentage (%) of 10.00R20 tyres increased and that of 9.00N20 decreased. The PTR requirements per RC Tyre for different sizes of Tyres is given below as per specifications.

Size of Tyre	Type	REVISED PTR SPECS		
		Width (mm)	Length (mm)	Weight (Kgs)
9.00N20	Nylon	**185 ± 2 MM**	**3125 ± 5 MM**	**9.8**
9.00R20	Radial	**195 ± 2 MM**	**3125 ± 5 MM**	**10.2**
10.00 R 20 (Two sizes)	Radial	**205 ± 2 MM**	**3235 ± 5 MM**	**11.0**
	Radial	**215 ± 2 MM**	**3235 ± 5 MM**	**11.8**
295/80R 22.5 (Two sizes)	Radial	**238 ± 2 MM**	**3235 ± 5 MM**	**13.1**
	Radial	**245 ± 2 MM**	**3235 ± 5 MM**	**13.4**

The norms for consumables in Tyre Retreading Shops for 2017-18 are worked out by considering the previous 3 years production and material consumption trends at TRSs.

SIZE WISE RC/RT PRODUCTION TRENDS FOR 3 YEARS

SIZE	2014-15		2015-16		2016-17	
	QTY	%	QTY	%	QTY	
9.00N20	30913	30	16238	17	6663	9
9.00R20	56513	54	56940	61	41732	55
10.00R20	14625	14	18466	20	23551	31
295/80R TL	2173	2	2286	2	3086	4
225/75R TL	0	0	0	0	169	1
TOTAL PRODUCTION	104224	100	93930	100	75201	100

MATERIALS CONSUMPTION TRENDS FOR 3 YEARS

MATERIAL CONSUMPTION	2014-15		2015-16		2016-17	
	AVG/ TYRE (Kgs)	TOTAL CONSUMP (Kgs)	AVG/ TYRE (Kgs)	TOTAL CONSUMP (Kgs)	AVG/ TYRE (Kgs)	TOTAL CONSUMP (Kgs)
PTR	9.90	1031818	10.41	977811	10.40	782090
HBG	1.35	140702	1.26	118352	1.32	99265
BVC	0.95	99013	0.87	81719	0.92	69185
WEDGE STOCK	1.89	3731	2.08	3998	1.80	2160

NEW, RC AND TOTAL TYRE LIFE TRENDS FOR 3 YEARS

Parameters	2014-15	2015-16	2016-17
New Tyre Life (Kms)	74268	80500	88856
RC Tyre Life (Kms)	48734	51971	57807
RT Factor	2.21	2.21	2.23
Total Tyre Life (Kms)	175568	183540	198536

From the above data, it can be seen that due to increase in RC production of 10.00R20 tyres, the consumption of PTR per Tyre is increasing from year to year, but the total quantity is decreasing due to performance improvement in Total Tyre Life with less number of RC Tyres.

The consumption trends of different sizes of Nylon, Radial patches & Uniseals are analysed and fixed norms in percentage for every 100 nos of patches consumed for repair of different type of Tyres.

On the similar lines, the consumption trends of different materials are analysed at corporate level to have realistic budgeting estimates. The same are communicated to Accounts section in the form of Norms for the year 2017-18. These norms also form a bench mark for Tyre retreading shops so as to have control over the consumptions and to assess the reasons in a realistic way on the excess or less consumptions.

Therefore the Norms are being communicated to all AMEs (T) every year for the proper planning of material and analyzing the reasons for deviations in reality against the reference norms.

The norms fixed for the year 2017-18 are enclosed at Annexure-A. Efforts are to be made to control the consumption within the limits duly exercising regular inspection of Tyre Retreading process at floor level and interacting with the Vulcanisers and other staff and also by avoiding process failures and wastage of materials in RC/Repair process.

The Works Managers are advised to monitor the consumption pattern on fortnightly basis with respect to the norms given and initiate corrective actions involving AMEs(T) and Tyre Shop supervisors.

The Executive directors of zone are requested to review this in the periodical PRC meetings and take suitable steps to control the excess consumption of materials in TRSs and there by the RC and Repairs costs.

Please acknowledge.

EXECUTIVE DIRECTOR (E & IT)

Copy to: Dir (V&S), ED(O&MIS),ED(A&P),FA&CAO for information.
Copy to: All Executive Directors(Zone) for inf. and n/a.
Copy to: CME(O), CME(C&B), CE(IT), CCOS,CM(F&A) for information.
Copy to: All Works Managers for necessary action.
Copy to: All Dy.CAOs & Controllers of Stores for necessary action.
Copy to: All Asst. Mechanical Engineer (Tyres) for necessary action.

CONSUMPTION NORMS FOR THE MATERIAL IN TRSs FOR 2017-18

Sl No	DESCRIPTION	UNIT	Corporation	VZM	VJA	KDP	NLR
I	PRECURED RC:						
	PTR (AVG of all Sizes)	Kgs/Tyre	10.57	10.50	10.80	10.50	10.50
	BVC	Ltrs/Tyre	0.93	1.00	0.90	0.90	0.90
	HBG	Kgs/Tyre	1.30	1.50	1.20	1.30	1.20
	Wedge stock (RT)	Kgs/Tyre	1.57	1.70	1.40	2.00	1.20
	Envelopes	Nos/Tyre	0.01	0.01	0.01	0.01	0.01
	Curing Bags	Nos/Tyre	0.02	0.02	0.02	0.02	0.02
	Flaps	Nos/Tyre	0.05	0.05	0.05	0.05	0.05
	Poly Propylene Cloth	Nos/Tyre	0.010	0.01	0.01	0.01	0.01
II	UNIPATCHES						
	BP4	%	1	1	1	1	1
	BP5	%	2	2	2	2	1
	BP6	%	1	1	1	2	1
	BP7	%	1	2	1	1	1
III	RADIAL PATCHES						
	CT40	%	44	48	38	40	50
	CT42	%	32	28	40	30	30
	CT44	%	6	5	4	11	3
IV	UNISEALS (RADIAL)						
	6mm (1/4")	%	3	3	3	3	3
	9mm (3/8")	%	5	5	5	5	5
	13mm (1/2")	%	5	5	5	5	5
	Total no. of Patches (II + III + IV)		100	100	100	100	100
V	Rub-O-Matic (S.B.Sprit) per Patch	Lts	0.03	0.03	0.03	0.03	0.03
VI	Chemical Vul.Fluid/ Chemical Vul.Cement/ Kwik solution per Patch	Lts	0.03	0.03	0.03	0.03	0.03
VII	BVC per Patch	Lts	0.03	0.03	0.03	0.03	0.03
VIII	HBC per Patch	Kgs	0.15	0.15	0.15	0.15	0.15

Note: Item No: II, III, IV are given in percentage for every 100 patches consumed in repair of different type of tyres.

DYCME(P)