



ANDHRA PRADESH STATE ROAD TRANSPORT CORPORATION

No : TR2/791(2)/2015-16-MED.

O/o VC&MD,
Vijayawada.

CIRCULAR NO: 08/2022-MED, Dt: 25.05.2022.

Sub: **MATERIALS** - Control of expenditure - Fixing of Norms for RC and Repairs in Tyre Retreading Shops for the year 2022-23 - Reg.

Expenditure on Tyres and its related material is one of the major constituents of Profit & Loss accounts of the corporation. The Corporation incurred Rs. 73.12 Crores for the year 2021-22 (upto Feb'2022) 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 Tyres RC cost of the respective Tyre retreading shop. The PTR requirement for RC Tyres of different sizes of Tyres is given below as per specifications.

Tyre Size	Type	EXISTING PTR SPECS			Utilized For
		Width (mm)	Length (mm)	Weight (Kgs)	TYRE MAKE
9.00R20	Radial	195±2MM	3125±5MM	10.2	For all makes
10..00R20	Radial	205±2MM	3235±5MM	11.0	JK(JUH3+)
	Radial	215±2MM		11.8	MRF(STM),MI(XZE2)
	Radial	225±2MM		12.4	MRF(S1R4), MI(Xmulti Z), CEAT (PRO R10), JK(JUH5)
295/80R22.5	Radial	238±2MM	3235±5MM	14.3	JK,MI,MRF Tubeless
	Radial	245±2MM		14.6	MRF(S1R4), MI(X Multi Z) Tubeless

The norms for consumables in Tyre Retreading Shops for 2022-23 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	2019-20		2020-21		2021-22	
	QTY	%	QTY	%	QTY	%
9.00R20	1026	1.36	98	0.27	22	0.04
10.00R20	70046	92.69	33258	92.81	50570	91.24
295/80R TL	4500	5.95	2480	6.92	4832	8.72
TOTAL PRODUCTION	75572	100	35836	100	55424	100

MATERIALS CONSUMPTION TRENDS FOR 3 YEARS

MATERIAL CONSUMPTION	2019-20		2020-21		2021-22	
	AVG/ TYRE	TOTAL CONSUMP	AVG/ TYRE	TOTAL CONSUMP	AVG/ TYRE	TOTAL CONSUMP
PTR (Kgs)	11.37	859254	11.62	416414	11.43	633496
HBG (Kgs)	1.34	101266	1.33	47662	1.30	72051
BVC (Ltrs)	0.95	71793	0.98	35119	0.90	49882

NEW, RC AND TOTAL TYRE LIFE TRENDS FOR 3 YEARS

Parameters	2019-20	2020-21	2021-22
New Tyre Life (Kms)	97411	100217	99011
RC Tyre Life (Kms)	52171	59779	62013
RT Factor	2.19	2.12	2.15
Total Tyre Life (Kms)	214365	225440	235402

From the above data, it can be seen that due to Covid19 pandemic during the year 2021-22 the RC tyres production has been dropped to 30% of the year 2019-20.

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

Even though instructions were already there to repair the injuries upto 1" on Repair Tyres with Uniseals only, Consumption of Uniseals indicate that due attention is not being given at Tyre Retreading Shops for proper classification and usage of Uniseals.

Uniseals increases the life of the tyre and avoids curing. This advantage shall be obtained with usage of Uniseals.

On the similar lines, the consumption trends of different materials are analysed at corporate level to have realistic budgeted estimates. The same are to be communicated to Accounts section in the form of Norms for the year 2022-23. 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 proper planning of material and analyzing the reasons for deviations in reality against the reference norms.

The norms fixed for the year 2022-23 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)

Copy to: ED(A), ED(O), FA&CAO for information.

Copy to: All Executive Directors(Zone) for inf. and n/a.

Copy to: OSD to VC&MD for information.

Copy to: CME(M), 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.

Annexure-A

CONSUMPTION NORMS FOR THE MATERIAL IN TRSs FOR 2022-23

Sl No	DESCRIPTION	UNIT	Corp.	VZM	VJA	KDP	NLR
I	PRECURED RC:						
	PTR (AVG of all Sizes)	Kgs/Tyre	11.35	11.50	11.32	11.32	11.24
	BVC	Ltrs/Tyre	0.89	0.92	0.99	0.81	0.83
	HBG	Kgs/Tyre	1.26	1.30	1.28	1.30	1.17
	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	0.03
	Flaps	Nos/Tyre	0.03	0.02	0.04	0.02	0.04
	Poly Propylene Cloth	Nos/Tyre	0.01	0.01	0.01	0.01	0.01
II	RADIAL PATCHES						
	CT40	%	47	55	40	38	58
	CT42	%	31	25	41	36	20
	CT44	%	4	1	1	9	4
III	UNISEALS (RADIAL)						
	6mm (1/4")	%	3	4	3	3	2
	9mm (3/8")	%	9	10	10	9	8
	13mm (1/2")	%	6	5	5	5	8
	Total no. of Patches (II + III)	%	100	100	100	100	100
IV	Rub-O-Matic per Patch	Lts	0.03	0.03	0.03	0.03	0.03
V	Chemical Vul.Fluid/ Chemical Vul.Cement/ Kwik solution per Patch	Lts	0.03	0.01	0.03	0.03	0.03
VI	BVC per Patch	Lts	0.03	0.03	0.03	0.03	0.03
VII	HBG per Patch	Kgs	0.15	0.15	0.15	0.15	0.15
Note: Item No: II, III are given in percentage for every 100 patches consumed in repair of different type of tyres.							

Ch. V. —————
24/5/22