ANDHRA PRADESH STATE ROAD TRANSPORT CORPORATION

O/o VC&MD,
No : TR2/791(2)/2015-16-MED. Vijayawada-13.

CIRCULAR NO:9/2018-MED, Dt: 05.06.2018.

Sub: **MATERIALS** – Control of expenditure – Fixing of Norms for RC and Repairs in Tyre Retreading Shops for the year 2018-19 - 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.64.93 Cores for the year 2017-18 (upto Feb'2018) 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. After critical examination of cost benefit analysis, 10.00R20 Tyres were standardized for Telugu Velugu, City Ordinary, Express, Ultra Deluxe, Super Luxury & Indra buses and reduced Tyre CPK to 60 Ps(2017-18) from 72 Paisa tyre CPK (2014-15). Thus percentage of 10.00R20 radial tyres is increased gradually duly phasing out the 9.00R20 Tyres. 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
9.00N20	Nylon	185±2MM	3125±5MM	9.8	For all makes
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	3235±5MM	11.8	MRF(STM),MI(XZE2)
	Radial	225±2MM	3235±5MM	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	3235±5MM	14.6	MRF(S1R4), MI(X Multi Z) Tubeless
225/75R17.5	Radial	200±2MM	2400±5MM	8.1	APOLLO (MIDI)

The norms for consumables in Tyre Retreading Shops for 2018-19 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	2015-16		2016-17		2017-18	
	QTY	%	QTY	%	QTY	%
9.00N20	**16238**	**17**	**6663**	**9**	**1987**	**3**
9.00R20	**56940**	**61**	**41732**	**55**	**21794**	**30**
10.00R20	**18466**	**20**	**23551**	**31**	**46735**	**63**
295/80R TL	**2286**	**2**	**3086**	**4**	**3027**	**4**
225/75R TL	**0**	**0**	**169**	**0**	**155**	**0**
TOTAL PRODUCTION	**93930**	**100**	**75201**	**100**	**73698**	**100**

MATERIALS CONSUMPTION TRENDS FOR 3 YEARS

MATERIAL CONSUMPTION	2015-16		2016-17		2017-18	
	AVG/ TYRE	TOTAL CONSUMP (Kgs)	AVG/ TYRE	TOTAL CONSUMP (Kgs)	AVG/ TYRE	TOTAL CONSUMP (Kgs)
PTR	**10.41**	**977811**	**10.40**	**782090**	**10.61**	**781936**
HBG	**1.26**	**118352**	**1.32**	**99265**	**1.36**	**100229**
BVC	**0.87**	**81719**	**0.92**	**69185**	**0.97**	**71487**
WEDGE STOCK	**2.08**	**3998**	**1.80**	**2160**	**1.80**	**2160**

NEW, RC AND TOTAL TYRE LIFE TRENDS FOR 3 YEARS

Parameters	2015-16	2016-17	2017-18
New Tyre Life (Kms)	80500	88856	97876
RC Tyre Life (Kms)	51971	57807	54106
RT Factor	2.21	2.23	2.14
Total Tyre Life (Kms)	183540	198536	200565

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 2018-19.

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 2018-19 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: ED(A&P), ED(O&M),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 2018-19

Sl No	DESCRIPTION	UNIT	Corp.	VZM	VJA	KDP	NLR
I	PRECURED RC:						
	PTR (AVG of all Sizes)	Kgs/Tyre	10.84	10.90	11.00	10.80	10.90
	BVC	Ltrs/Tyre	1.04	1.15	1.00	1.00	1.00
	HBG	Kgs/Tyre	1.37	1.50	1.30	1.40	1.30
	Wedge stock (RT)	Kgs/Tyre	1.51	1.70	1.40	1.50	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	0.01	0.01	0.01	0.01	0.01
II	UNIPATCHES						
	BP4	%	0	1	0	1	0
	BP5	%	1	1	0	1	0
	BP6	%	1	1	1	1	0
	BP7	%	1	1	1	1	0
III	RADIAL PATCHES						
	CT40	%	44	41	40	40	55
	CT42	%	35	39	43	31	30
	CT44	%	5	3	2	12	2
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 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.

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