Sub: Marking of overhauling particulars of CTRB

Ref: 1) This office letters of even no. dated 11.9.15, 5.10.15 & 2.11.15
2) Minutes of CME Conference Nov 2016 vide Ir. No. 2016/M(N)/951/30 dt.9.12.16
3) RDSO letter No. MW/RB/Genl dated 14/12/2016

The problem of non availability of last overhauling particulars being legible on CTRBs backing ring has been a cause of concern, which has led to a no. of cases in the past where bearings even after becoming due continue in operation leading to their failures in some cases.

As a result of these difficulties vide letter u/r (1), it was advised that the overhaul date would be estimated based on the manufacturing date on grease seal and action taken accordingly.

As had been decided during CME conference, the experimental basis use of laser engraving machine by RYPS Workshop/SCR is to be standardized for etch marking, using laser, of the overhaul particulars of the CTRB on the grease seal. Detailed specifications and other particulars of the laser engraving machine has been circulated vide RDSO letter u/r (3).

It is advised that all railways ensure that the CTRB overhaul shops/facilities immediately arrange for laser engraving of overhaul particulars on the grease seal. It is to be ensured that laser engraving of all overhaul particulars on all CTRBs overhauled be implemented latest by 30.4.2017. CTRBs without laser engraving on grease seal shall be treated as NTXR rejectable defect after 30.04.2017 for all POH shops.

Necessary action may please be taken accordingly.

(AJAY NANDAN)
Exec. Director Mech. Engg. (Freight)
Railway Board

CC:
NCO/IRCA
No. MW/IRB/Genl.

As per enclosed list

Sub: Laser Engraving Machine for marking on Grease Seal of CTRB Class ‘E’ (6” X11”)


In reference to above, it was decided in the meeting that Laser Engraving Machine shall be installed in every Cartridge Tapered Roller Bearing overhauling Workshop for marking of overhauling particulars on Grease Seal of the bearing.

In this regard, S.C.Railway has already installed Laser Engraving Machine in Rayanapadu, Guntupalli Workshop and doing Laser etching marking of overhauling particulars on Grease Seal. Copy of Purchase Order along with Specification of Laser Engraving Machine as procured by Rayanapadu Workshop is enclosed herewith for your reference.

In view of above, it is requested that every Cartridge Tapered Roller Bearings Overhauling Workshop shall procure & install Laser Engraving Machine at the earliest for marking of overhauling particulars on Grease Seal for proper identification & traceability of bearings.

DA: As above (04 page)

(M.K.Pandey)
Director (Wagon)
For Director General (Wagon)
Circulation:

   Railway Board, Rail Bhawan,
   New Delhi -110 001
2. Executive Director, CAMTECH: for kind information please.
   Maharajpur, Gwalior (M.P.) - 474 005
3. The Chief Mechanical Engineer:
   1. Central Railway, C.S.T., Mumbai — 400 001
   2. Eastern Railway, Fairlie Place, Kolkata — 700 001
   3. East Central Railway, Hajipur — 844 101
   4. East Coast Railway, Rail Vihar, B-2, Chandrashekherpur, Bhubaneswar — 751 023
   5. Nothern Railway, Baroda House, New Delhi —110 001
   6. North Central Railway, Subedargunj, Allahabad -211 015
   7. North Eastern Railway, Gorakhpur-281 001
   8. Northeast Frontier Railway, Maligaon, Guwahati -781 001
   9. North Western Railway, Near Jawahar Circle, Jaipur — 302 017
   10. Southern Railway, NGO Annexe, Park Town, Chennai — 600 003
   11. South Central Railway, Rail Nilayam, Secunderabad — 500 371
   12. South Eastern Railway, Garden Reach, Kolkata — 700 043
   13. South East Central Railway, RE Office Complex, Bilaspur — 495 004
   14. South Western Railway, Club Road, Keshwapur, Hubli — 560 023
   15. West Central Railway, Opposite Indira Market, Jabalpur — 482 001
   16. Western Railway, Churchgate, Maharishi Karve Marg, Mumbai — 400 020
4. The Chief Works Manager:
   1. Eastern Railway Workshop, Lilua, District: Howrah (West Bengal) — 711 204
   2. Eastern Railway Workshop, Jamalpur, District: Munger (Bihar) — 811 214
   3. Mechanical Workshop, East Central Railway, Samastipur (Bihar)-848 101
   4. Mechanical Workshop, Northern Railway, Civil Albert Road, Amritsar (Punjab)-143 001
   5. Mechanical Workshop, Northern Railway, Jagadhari, District : Yamunanagar (Haryana)-135 002
   6. Wagon Repair workshop, North central Railway, Jhansi (U.P.)-248 003
   7. Loco workshop, North Western Railway, Lal Phatak, Ajmer (Rajasthan)-305 001
   8. Carriage & Wagon Workshop, Southern Railway, Perumbur (Tamil Nadu)-600 023
   9. Central workshop, Golden Rock (Ponmalai), Tiruchirappalli (Tamil Nadu)-620 004
   10. Wagon Workshop, South Eastern Railway, Kharagpur (West Bengal) - 721 301
   11. Wagon Repair Workshop, South East Central Railway, Raipur (Chhattisgarh) -490 015
   12. Wagon Repair Workshop, West Central Railway, Kota (Rajasthan)-324 002
   13. Wagon Repair Workshop, South Central Railway, Guntupalli (A.P.)-521 241
   14. Western Railway Workshop, Freelandganj, Dahod, District: Panchmahal (Gujarat)- 389 160
   15. Western Railway Workshop, Pratap Nagar, Vadodara (Gujarat)-390 004
   16. Carriage & Wagon Workshop, North East Frontier Railway, New Bongaigaon (Assam)-798 381
GOVERNMENT OF INDIA
MINISTRY OF RAILWAYS

No. 2016/M(N)/951/30


Chief Mechanical Engineers,
All Zonal Railways & PUs
CME, COFMOW, New Delhi
CME/KRCL/Navi Mumbai
CME/RWP/Bela

ED(UTHS), ED(MP)
ED(Carriage), ED(Testing)
ED(QA), ED(Wagon),
ED(PS & EMU) RDSO, Lucknow
ED(CAMTECH), Gwalior

CME, Workshop Project, Patna
CME, MCF, Raebareli
CAO/IROAF, New Delhi

Sr. Professor (Mech.), NAIR, Vadodara
Director/IRIMEE, Jamalpur


The minutes of the CME Conference held on 4th & 5th November in Mysuru, South Western Railway has been issued and can be downloaded from Railway Board’s website www.indianrailways.gov.in by following the path “About Indian Railways—Railway Board Directorates—Mechanical Engineering—Circulars—Mechanical(Freight) —I. Meeting & Conference.

This is for your kind information and necessary action please.

(Rajesh Kumar)
Dir. Mech. Engg. (Frt.)
Railway Board

Copy to: PSO/MRS for kind information of MRS.
AM (ME), AM (PU)
EDME(Chg.), EDME(W), EDME(Frt.), EDME(Proj.), EDME(EnHM),
EDME(Dev.), EDEE(G), DEE(G) for kind information and necessary action please.
<table>
<thead>
<tr>
<th>S. No.</th>
<th>Action</th>
<th>BY</th>
<th>Time Schedule</th>
</tr>
</thead>
<tbody>
<tr>
<td>1.15.</td>
<td>Concept of integrated maintenance should be implemented. There should be a single agency for giving fitness of coach, AC attention/linen distribution.</td>
<td>CME</td>
<td>Immediate</td>
</tr>
<tr>
<td>1.16.</td>
<td>There is a need to review the specifications of linen items like blankets, face towel and pillows. Introduction of moulded foam pillows which are washable and disposable face towels may be evaluated.</td>
<td>ED/EnHM</td>
<td>Immediate</td>
</tr>
<tr>
<td>1.17.</td>
<td>Proper facilities should be developed for fuelling of power cars &amp; DEMU. Oil company should design dispensing units with higher flow rate for power cars so as to reduce the fuelling time.</td>
<td>EDME/Tr</td>
<td>31.12.2016</td>
</tr>
<tr>
<td>1.18.</td>
<td>Specification for silicon foam seat cushions should be referred to RDSO for finalization &amp; modification if needed.</td>
<td>EDME/Chg, ED/Carr/RDSO</td>
<td>Immediate</td>
</tr>
<tr>
<td>1.19.</td>
<td>NFTC boards for flooring to be tried out.</td>
<td>EDME/Chg</td>
<td>Immediate</td>
</tr>
<tr>
<td>1.20.</td>
<td>Problem of bulging of sidewalls and other design related issues of BOXNHL wagons needs to be addressed on priority. To prevent bulging of side walls, buttress support provision can be considered during POH as a modification.</td>
<td>ED/Wag</td>
<td>31.12.2016</td>
</tr>
<tr>
<td>1.22.</td>
<td>BOXNHL wagons fitted with BMBS will now come to Workshops for POH. Zonal Railways must develop capability for repair, maintenance and testing of BMBS in Workshops and open line depots.</td>
<td>CME</td>
<td>31.12.2016</td>
</tr>
<tr>
<td>1.23.</td>
<td>Occurrence of hot axle in rolling stock while on run remains a cause of concern. Proper marking after overhauling must be ensured. Possibility of Laser etching for marking on grease seal as tried out by RYPS may be explored.</td>
<td>CME</td>
<td>31.12.2016</td>
</tr>
<tr>
<td>1.24.</td>
<td>All cases of cold breakage of axles need to be investigated in detail by Zonal Railways and RDSO.</td>
<td>CME, ED/W/RDSO</td>
<td>Immediate</td>
</tr>
<tr>
<td>1.25.</td>
<td>Efforts should be made to upgrade the fire safety features of all the coaches. Railways should use infra red cameras to identify the hot spots in electrical panels. RDSO should upgrade the specifications of cables and conduits so that they can block transmission of heat and fire.</td>
<td>All CMEs, ED/PS&amp;EMU</td>
<td>31.3.2017</td>
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**[NON-STOCK]**

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<thead>
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<th>Railway Zone</th>
<th>South Central Railway</th>
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<tr>
<td>Khandesh</td>
<td>Stores Department</td>
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<tr>
<td>Purchase Order</td>
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</table>

**Dispatched On:**

**P.O. No.:** LP-16-5222-1-50228

**Consignment No:** P.O. Date: 19/09/16

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**Mode of dispatch:**
- By Road Transport.
- Free at Destination.

**Delivery Terms:**
- Within 6 weeks.
- MILL WRIGHTSHOP/RYP

**Dispatch to:**
- 80 percent on receipt/acceptance and 20 percent on installation.

**Total Order Value:** Rs. 866250.00 (Rupees Eight Lakh Sixty Six Thousand Two Hundred Fifty Only)

**Laser Engraving Machine as per enclosed specification.**

---

**Special Conditions of Contract:**
- 2 years warranty.

---

**Copy to:**
- 1) Black copy
- 2) Supplier copy
- 3) Receipt Branch copy
- 4) CWM/WVS/GTPL 5) WAO/WVS/GTPL 6) CWM/WVS/GTPL 7) MILL WRIGHTSHOP/RYP 8) RITES

---

**Check:** 191126, 
**Letter No:** DD/28/ADM2

**For & On Behalf of the President of India**

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**Website:** https://ireps.gov.in/fgii/runfrm

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**Details:**

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<td>MILL WRIGHTSHOP/RYP</td>
<td>039012</td>
<td>98012/M/H/P/16-17/LS-13</td>
<td>25/08/16</td>
<td>05/11/16</td>
</tr>
</tbody>
</table>

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**Note:**

- **Price Break-Up:**
  - S.Tax/VAT
  - Basic Rate
  - Total Rs. 825000.00
  - S.Tax/VAT 5.00

---

**Signatures:**

- Ch. Ramachandra Rao

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**Date:** 9/19/2016
SPECIFICATION FOR LASER ENGRAVING MACHINE

1. DESCRIPTION:


2. SCOPE:

The Contract Covers supply and commissioning of Laser Engraving Machine to the entire satisfaction of the purchaser.

3. TECHNICAL SPECIFICATIONS:

1. Wave length : 1064 mm
2. Laser Power : 30 W
3. Marking Range : 145 x 145 mm
4. Single Pulse Energy : 1 to 30 KHz
5. Repetition Frequency Range : 30 – 80 KHz
6. Min. Line Width : Min. 0.03 mm
7. Max. Speed : Max. 10000 mm/s (Linear speed)
8. Marking Depth : 0.01~0.3 mm
9. Power Adjustment Range : 0~100%
10. Cooling : Air Cooled
11. Min. Character Height : 0.5 mm
12. Output Power Stability : <3%
13. Power consumption : 250 Watt

4. SPARES:

List of recommended spares for two years maintenance should be provided with details of prices and quantities along with the machine.

5. COMMISSIONING AND PROVING OUT:

The successful tenderer shall have to install and commission the Laser Engraving machine immediately on receipt of equipment at Wagon Workshop/ Guntupalli.

6. One copy of the printed illustrative catalogue showing features of the machine and its elements must be enclosed with the bid.

7. The successful tenderer will have to furnish 2 copies of spare parts Catalogue giving the part list number of each component with exploded views and Assembly drawing, maintenance manual, trouble shooting guide, operational manual of the machine and electrical circuit diagrams.

8. Special features incorporated in the machine, if any, shall be indicated separately by the tenderer, clearly indicating the advantages of these features.