S.N-105

**Inspection Note of Shri Ravindra Gupta, Member Rolling Stock, Railway Board on his visit to Coach MLR Workshop, Wagon Repair Workshop and Supervisors Training Centre, Jhansi on 22/12/2017**

| S. No. | Observation | Action by |
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| | **Coach Mid Life Rehabilitation Workshop, Jhansi** | |
| 1 | The present annual target of MLR of Coaches is 65. The workshop should immediately plan for turning out 300 coaches per year starting 2018 – 19. | **PCME/NCR** |
| 2 | Lifting shop has holding capacity of 02 coaches. 02 Nos. EOT Cranes of 30 T capacity each are available for lifting of coach from both end simultaneously. The lifting tackles for lifting of coach is extremely heavy & bulky. Jamalpur type jacks may be used for lifting of coaches. | **PCME/NCR** |
| 3 | The cycle time for non-AC coaches for Mid life rehabilitation is 36 days presently which should be reduced to 30 days. | **PCME/NCR** |
| 4 | A coach was found placed in the stripping shop with batteries. Railways should ensure that no coach with batteries should be booked to MLR workshop unless it is booked in working condition in train service. | **PCME/All ZRs** |
| 5 | The DPT conducted on Centre Pivot of the coach was inspected. The centre pivot is not cleaned properly to get bare metal for conducting DPT. The complete cleaning of location should be done before DPT to defect cracks/ defects if any. | **PCME/NCR**<br>**PCME/All ZRs** |
| 6 | Coaches under going MLR are being cut up invariably to height of 540mm with the help of plasma cutting machine. The movement of the plasma cutting torch should be motorized. The stripping of coaches including Plasma cutting may be considered for outsourcing that manpower saved can be used for other core activities. | **PCME/NCR** |
| 7 | The over head water tanks are replaced 100%. A large no. of released old tanks have accumulated and are occupying lot of the shop floor space. The vertical stacking of water tanks should be planned and organized. It was informed that other workshops/railway collect these old overhead tanks on requirement basis. The proper credit/debit should be ensured for proper accountal of released materials for which such transfer of material may be done through Stores department. | **PCME/NCR**<br>**PCMM/NCR** |

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| 8 | The fitment of head stock assembly was seen in Body Repair Shop. The quality of welding was found satisfactory. Side panel side wall is being cut for corrosion repair and about 70 to 80 % of the sole bar is being replaced in all coaches. Sole bar is being replaced in different segment to avoid bulging of coach body. | **PCME/NCR** |
| 9 | The primer on side panels was found peeled off from all over. The proper care of such items should be ensured in Store Depot to prevent corrosion. The lower portion of the side panel should be procured to match the profile of turn under to save forming time. | **PCME/NCR PCMM/NCR** |
| 10 | The scrap generated from MLR coaches is sent to Scrap depot for disposal. The scrap of FRP, foam and pieces of L.P.Sheet etc should be disposed off regularly to avoid piling up on the shop floor. | **PCME/NCR PCMM/NCR** |
| 11 | The new grit blasting plant was inaugurated. Optimal utilization of the same may be ensured. | **PCME/NCR** |
| 12 | The new paint booth was inaugurated. Optimal utilization of the same may be ensured. | **PCME/NCR** |
| 13 | Problems regarding fitment of Bio Tank was deliberated with the supervisors. 'P trap' arrangement should be converted into 'S type' arrangement, for which procurement of necessary material should be done on priority. | **PCME/NCR PCMM/NCR** |
| 14 | JSL has supplied 120 sets of retention tanks to workshop with 'P trap' model. Railway Board may advise JSL for supply and fitment of 'S trap items in available bio-tanks with the shop . | **EDME (Dev)** |
| 15 | The sample of Jaguar make flushing cock having two stage discharge of 6 liter and 3 liter was on display on the shops floor. Only 3 liters discharge standard make flushing cock should be used to reduce cost and wastage of water. | **PCME/NCR PCME/All ZRs** |
| 16 | 100$^{th}$ coach no. 05415 GSNR was flagged off at CMLR, JHS after inspection. Some of the items need to be given attention to improve quality of MLR such as slope in lavatory floor, fitment of upper bunk wooden batons, proper fitment and cleaning of rexine on seat, LP sheets fitment, ACP handle fitment, doorways pillars, damaged to berths/luggage rakes, inside pantry, AC chain hole. | **PCME/NCR** |

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| 17 | The toilet should be provided with epoxy flooring with slope towards lavatory pan to facilitate flow of water. The lavatory pan surface should be given fine finish to avoid deposition of fecal matter. | **PCME/NCR** |
| 18 | The sloping frosted toilet window glass pane should be removed and closed and provide suitable venturi system as per the modifications carried out by SECR. | **PCME/NCR**<br>**PCME/All ZRs** |
| 19 | The panel to the side wall should be fastened with screws properly to avoid any gap. | **PCME/All ZRs** |
| 20 | The MLR shops has constructed a staff canteen under the project. The canteen has not been in operation. The staff strength has increased to 259 recently and it was reported that about 80 staff are under training and likely to join in near future. The canteen activities may be outsourced for the time being. | **PCME/NCR**<br>**PCPO/NCR** |
| 21 | Training of "A" category welders in advance welding may be organized at reputed institutes with proper certification | **PCME/All ZRs** |
| 22 | Locally fabricated staff lockers may be avoided and staff may be provided with standard lockers in a designated locker room. | **PCME/NCR** |
| 21 | A group award of Rs. 25000/- was sanctioned to CMLR shops for excellent work and good housekeeping and cleanliness. | **PCME/NCR** |
| | **Wagon Repair Workshop, Jhansi** | |
| 22 | The Personnel Branch offices in CWM's office was inspected. Some of the office furniture was found old & broken condition. The old & broken furniture should be replaced with new modular furniture. | **PCME/NCR**<br>**PCPO/NCR** |
| 23 | The staff records were found placed in open wooden racks. The proper steel compactor drawer for record keeping should be provided for records keeping to avoid damage/loss etc. | **PCME/NCR**<br>**PCPO/NCR** |
| 24 | Service Record of staff should be digitalized and Service Record of the staff should be shown to them and acknowledged to be obtained from them to that effect. | **PCME/NCR** |
| 25 | A no. of retired staff were found in the office who had come to get issued privilege Pass/PTO. A felicitations centre should be opened to obtain request and redress their grievance etc. | **PCME/NCR**<br>**PCPO/NCR** |

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| 26 | The first 5-tier EUR Rake was flagged off. The PDC given by Jhansi Workshop for 2nd, 3rd & 4th rake are 15.01.18, 30.01.18 & 28.02.18 respectively. It was advised to expedite completion of these rakes at the earliest possible. | **PCME/NCR** |
| 27 | Wagon No. 12120758406 ECo & 12120760368 ECo. under conversion into BOXNR wagons were inspected. The quality of welding at the workshop needs substantial improvement. Proper gradation of welder should be done and weak welder should be given training to improve their grading. This should be a continual process. | **PCME/NCR** |
| 28 | Due to failure of supply of DV Kits by Stone India Ltd., interchangeability in DV Kits of Faiveley and Greysham makes should be examined by EDME/Frt and clear necessary instructions should be issued from RDSO/Rly Bd. | **EDME/Frt/Rly Bd EDME(Wagon)/RDSO** |
| 29 | A large no. of serviceable axles were available in wheel shop. The shops have reported that there has been 0.3% axles rejected in UST and overall rejection percentage of axles is about 4.5% for journal defects and other reasons. The reasons of higher rejection should be analyzed so as to take corrective action to reduce the rejection. | **PCME/NCR** |
| 30 | All wagon workshops may revisit requirement of new axles in the light of ground availability of new and serviceable axles and also condemned/under condemnation wagons | **EDME (Frt) PCME/All ZRs** |
| 31 | The axle pressed out of the old wheel sets were piled up in haphazard manpower which may damage wheel seats and render the axles unusable. The axles should be stacked on wooden batten to avoid any damage. | **PCME/NCR** |
| 32 | About 100 MT turning boring was accumulated near Wheel shop. DS-8 for disposal of turning boring was reported have handed over to Stores. The regular disposal of turning boring should be ensured to avoid accumulation. | **PCME/NCR** |
| 33 | The productivity of wheel lathes is 24 wheel sets/shift which is less and efforts should be made to increase in output to 30 wheel sets/shift. "SAFOP" wheel lathe is fully automated is outturn is 20 wheel per shift. Necessary efforts should be made to increase the output to more than 30 wheel sets per shift. | **PCME/NCR** |

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| 34 | There is a need to review the allowed times of major activities in workshops as there has been a improvement in design parameters of rolling stock (like introduction of wear adapted wheel profile), introduction of high productivity CNC machines and skill updated of the staff doing the major activities. | **PCMEs/IR** |
| 35 | The shed roof were found broken and having wide gaps resulting falling of water during rains. The floor was found broken and needs repair/replacement to provide hardened and smooth surface. | **GM/NCR** |
| 36 | The supervisors looking after the welding activities should be given proper training in welding so that they can supervision welding work of the welders effectively. | **PCME/NCR** |
| 37 | There was complete darkness at a no. of locations in the shops. Survey of the complete shop should be carried out to provide proper illuminations for which solar light pipes may be used in addition to LED lights. | **GM/NCR** |
| 38 | In CTRB section, items viz. cup, cone, spacer etc are being stacked in the bins in haphazard manners, the system of proper stacking of these items should be developed to avoid any damage. | **PCME/NCR** |
| 39 | Instructions to display various details of the M&P viz. supplier name, cost, year of sanction, year of installation/commissions, Rated Capacity etc. at conspicuous place should be strictly followed by shops. | **PCME/NCR PCMEs/All ZRs** |
| 40 | Testing of material of huck-bolts should be regularly carried out so as to ensure proper quality of the supplies. | **PCME/NCR** |
| 41 | In the air brake section, the DV test bench is under breakdown since last few months. It should be got repaired and made working at the earliest. | **PCME/NCR** |
| 42 | A dried well has been identified in the Wagon Repair Workshops premises to revise as the water body in 3 months. This will be a good efforts and should be completed in earnest. | **PCME/NCR** |
| 43 | There is huge backlog of military wagon POH. Focused Efforts should be made to clear backlog of military stock POH. | **PCME/NCR** |
| 44 | An award of Rs. 50000/- was sanctioned to give boost to moral of the staff & supervisor of Wagon Repair Workshops. | **PCME/NCR** |

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| | **Supervisors Training Centre :** | |
| 45 | Library of STC was seen. Principal STC informed that around 7500 books are available in this library. A good effort has been made in getting registered this Library with NIC hosted Software "e-granthalaya". Online access & issue of books is possible by developing this system. It was informed that STC is the first one which has made its library accredited with " e-granthalaya". | **PCME/NCR PCME/All ZRs** |
| 46 | The smart classroom no. 1 having facility of Smart Board, Electronic Lectern, PA system, Projector facility, Air Conditioning etc. was inaugurated. The smart board of bigger size should be provided to facilitate visibility to the trainee seating in the back rows. | **PCME/NCR PCME/All ZR** |
| 47 | Computer Lab was seen. There were 12 computers available in this Lab. It should be provided with at least 30 computers so that one batch of 30 trainees can be imparted training at a time. | **PCME/NCR** |
| 48 | A good effort has been made to develop a new Model Room with latest Rolling Stock Components at STC. | **PCME/NCR** |
| 49 | Welding Lab, Refrigeration & Air Conditioning Lab and Working Models in Trolley Shed also inspected and found that all the Working Models are in good order. | **PCME/NCR** |
| | **Address to Officers** | |
| 50 | MLR shops target will be 300 coaches for the year 2018-19. In case of staff shortage, judicious outsourcing of activities should be planned so as to meet the shortage of staff and to achieve the targets. | **PCME/NCR** |
| 51 | There is a need for flatter hierarchy in reporting relationships of officers. The duty list of officers should be revised in such a manner that each officer is assigned some direct duties in addition to duties of reported officer. The number of officers at Jhansi Workshop should be review and if felt necessary, some officers along with posts can be transferred to other crucial establishments. | **PCME/NCR** |
| 52 | The Wagon Repair Workshop is housed in old sheds of steam loco POH vintage. The infrastructure is overaged, roofs and floors are broken. The shop has layout of one side feeding and drawing of wagons. A project report should be made out to provide bays of proper width and height for POH wagons with provision of facilities etc required for POH wagons. The yard layout to facilitate streamlined movement of POH & Off POH wagons. | **PCME/NCR** |

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| 53 | The shops are carrying out cutting operation with acetylene gas. Lot of development has taken place in use of LPG for cutting operations, JHSW should switch over from acetylene to LPG for cutting operation by March 2017. | **CAO/IROAF PCME/NCR** |
| 54 | A detailed analysis should be carried out so as to reduce manpower ratio and manpower found surplus so should be transferred to MLR shops. | **PCME/NCR** |
| 55 | Progress of RSP works is slow. A review of RSP works should be carried out by CWE and draw up the action plan to expedite execution of RSP works. In case any RSP work is not being executed due to unavoidable reasons, it may be advised to Rly Bd. | **PCME/NCR PCMEs/All ZRs** |
| 56 | The Workshop should make a plan for right mix of in-sourcing and outsourcing so as to enhance outturn of wagon POH to atleast 700 per month from 2018 - 19. | **PCME/NCR** |
| 57 | The efforts should be made the workshop to reduce electricity consumption by 25% by using LED, light pipes, and day light from roof. | **GM/NCR** |
| 58 | Proper Accountal of released materials from condemned rolling stock must be kept and ensured. | **PCME/NCR** |
| 59 | Accountal of wagon targets and outturn in terms of 4 wheeler units should be stopped forthwith. | **PCME/NCR** |
| 60 | **Interaction with Unions/Associations** Representatives of press, different unions/associations met the undersigned and handed over their memorandum. | **PCME/NCR** |
| 61 | कारखाने द्वारा राजभाषा संबंधित नियमों की अनुपालना एवं अन्य संबंधित गतिविधियों की समीक्षा की गई तथा उन्हें संतोषप्रद पाया गया। | मु.का.प्र. झांसी |

(रवीन्द्र गुप्ता) 2/1/18
सदस्य चल स्टॉक
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1. GM/NCR, PCME/NCR/ALD, PCMM/NCR/ALD, PCPO/NCR/ALD
2. All PCMEs: IR
3. CAO/IROAF
4. EDME (Frt.)/RB, EDME (Dev)/RB,ED (Wagon)/RDSO

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