



भारत सरकार  
रेल मंत्रालय  
Govt. of India  
Ministry of Railways

रेल पहिया कारखाना / बेला  
Rail Wheel Plant/Bela

एम.सी.डी.ओ. MCDO

अक्टूबर October 2015



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MINISTRY OF RAILWAYS

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*Ajay Kumar*  
Chief Administrative Officer

D.O.No.RWP/CAO/MCDO/15

Date: 22/11/2015

*Dear Sh. Hemant Kumar*

**Sub:- MCDO for the month of October 2015**

**1. Highlights**

**1.1 Wheel Cast:-**

1793 wheels were cast from 65 heats during Oct'15. Out of this 1769 wheels (99%) were with good chemistry. This could be achieved despite engagement of almost all staff mainly for election duty in Bihar Assembly Election'2015 & Durgapuja festival holidays. In total around 3500 man days were not available for production activity on account of election work and training.

The production of cast wheels during Oct'15 is 125% higher than that of Oct'14. Similarly the production upto Oct'15 in the current year is higher by 94% than the same period of last year as can be seen from the table below:-

Cast Wheels	Period	Ist Qtr	IInd Qtr	IIIrd Qtr (Upto Oct'15)	Cummulative	Remarks
	14-15	1692	3719	797	6208	<b>94% higher over last year</b>
	<b>15-16</b>	<b>3696</b>	<b>6554</b>	<b>1793</b>	<b>12043</b>	

**1.2 Wheel- SPG and Hub cut:-**

Out of 1769 wheels cast of good chemistry, 1286 wheels (73%) were processed for SPG & Hub cutting work during Oct'15 by special attention to break down prone SPG & Hub cutting machines.

The processing on SPG and Hub cutting upto Oct'15 in the current year is also higher than that of 14-15.

SPG and Hub Cut	Period	Ist Qtr	IInd Qtr	IIIrd Qtr (Upto Oct'15)	Cummulative	Remarks
	14-15	543	2174	607	3324	<b>73.4% higher over last year</b>
	<b>15-16</b>	<b>586</b>	<b>3892</b>	<b>1286</b>	<b>5764</b>	



### 1.3 Heat Treatment of Wheels:-

Nil wheels were heat treated during Oct'15 due to engagement of almost all staff for Election duty in Bihar Assembly Election'2015 & Durgapuja festival holidays.

The heat treatment output is higher during first half of 15-16 than 14-15.

Heat treatment	Period	Ist Qtr	IInd Qtr	IIIrd Qtr (Upto Oct'15)	Cummulative	Remarks
	14-15	0	2356	1653	4009	4% lesser over last year
	15-16	0	3845	0	3845	

### 1.4 Dispatch of wheels:-

831 finished wheels were despatched during Oct'15. The despatches upto Oct'15 of 15-16 is substantial higher than same period of last year:-

Dispatch of Wheels	Period	Ist Qtr	IInd Qtr	IIIrd Qtr (Upto Oct'15)	Cummulative	Remarks
	14-15	0	60	322	382	453% higher over last year
	15-16	849	433	831	2113	

### 1.5 Mechanical Maintenance:-

The maintenance staff of RWP/ Bela have carried out following maintenance activities during Oct'15

#### (A) Melt Shop:-

- Ventilation room- centrifugal motor fan no-01, 02 & ventilation filter cleaned.
- FES Bag house damper, gas cooler cleaned.
- Delta roof change in EAF-C.
- EOT- 12543, LT-02 coupling changed.
- LPH-01, 02, 03 all LPH MS plate top side welded and ceramic wool fitted.
- Preventive maintenance schedule of EAF, FES, EOT- Crane 40/15 Ton & 10/3 Ton, Sample cutting M/C Brick cutting M/C, Sample polishing M/C, LPH has done.

#### (B) Mould Room:-

- JMP- Air inlet valve complete set overhauled & fitted.
- Drag Tilter- Liner of DT welded to work properly.
- Cope Tilter- Liner of Cope tilter welded to work properly.
- Mould Splitter Crane- MSC lifting chain link provided & chain connected.
- Close down Crane- clamping cylinder head welded & fitted.
- Tube Press- Tube press hammer bolt replaced with new one.
- HWTC 1 & 2 – Jaw of both hot wheel transfer cranes replaced with new one.
- Modification/Innovation: - To avoid any loss of production due to non-availability of chiller unit a modification is carried out in chiller unit output. Such that one working chiller unit will be able to supply chilled water for the other SPG. This has improved the availability of SPG, which is one of the most critical machine in the production line.
- SPG- a) Ball screw of SPG-1 overhauled and fitted.  
b) Loader arm motor of SPG-3 replaced with SPG-4.
- Sand Plant- a) Maintenance work of bucket evaluator done.  
b) Vibratory screen motor replaced with new one.

- Drag Spray- Rotating table-1 - gear box bearing overhauled & new hydraulic DC valve replaced with new one.
- CTA- a) Liner of CTA welded to work properly.  
b) Bearing out from housing, new one bearing with housing provided.  
c) Clamping support plate straightened & fitted with support plate.
- Cope Spray- Spray mixing tank air motor replaced with new one.
- Stamping machine stamping head bolt replaced with new one.
- Greasing, cleaning, lubrication of all M&Ps has done.

**(C) M. Wheel Final Processing Shop:-**

- Hub boring machine No.1:- leakage hyd. hose pipe of manipulator of wheel clamp/unclamp has replaced with new one.
- CNC VTL-19:- Broken four nos. of L.N. bolt has replaced with new one.
- Ingate lathe machine of MRS:- One no. new hyd. hose pipe provided.
- CNC VTL-20:- New Damping and wheel centring hyd. cylinder provided.
- BHN-01:- Damaged PU-PAD has replaced with new one.

**(D) Utility Shop/RT Shop:-**

- Cleaning of Air filter, Y-type strainer of all compressor.
- Greasing of cold water pump for WFPS No.1,2,3; EAF No.1,3,4 and emergency water pump.
- 14 Nos. of minor repairs/breakdown vehicles are rectified by RT shop.
- V-6 FLT has fallen due to which several parts are damaged and the same has repaired at RTS.
- V-10 vehicle has repaired and ready to work with load.

**1.6 Electrical Maintenance:-**

The maintenance staff of RWP/ Bela have carried out following maintenance activities during Oct'15

**(A) Electrical Power:-**

- Emergency supply through 2.4 MVA DG set has provided in Normalizing Furnace, Draw Furnace and Rim Quenching.
- 02 nos. UPS of 20 KVA and 01 no. 15 KVA of Spectro Lab has repaired.
- Defective lighting arrangement in ventilator room and hydraulic room has rectified.
- 23 Nos. street light repaired which was damaged by hydra during excavation work by Engineering department.

**(B) Melt Shop:-**

- Vacuum bottle arrangement of 'Y' phase of VCB of B furnace has replaced from VCB of furnace 'C'. Outgoing of furnace 'B' was checked after giving supply. Both VCB are found ok.
- In south end (10/3T) festoon cable adjustment has done.
- Contactor of roof extractor panel no. 4 & 6 has burnt and the same has changed.
- In EOT 40/15T no.-03, Magnet cable socket has burnt and the same has changed.
- Electrode No. 01 of EAF 'B' not move up and down in auto mode. The same has checked and found that the voltage not shown in HMI, then the top changer has changed manually. Now Electrode has working fine.

