

**Reasoned document for the comments received on Draft of
“Item Specific Guideline for Thick WebSwitches, TDG-0038”**

S. No.	Proposed Clause as given in draft Item specific guidelines uploaded on RDSO's website for comments	Comments/ Suggestions by vendors/ stake holders	Changes made in Final Draft as uploaded on RDSO's website with reason for acceptance/ rejection of suggestion
1.	<p>ITEM SPECIFIC GUIDELINES FOR INITIAL APPROVAL/ QUALITY AUDIT OF FIRMS FOR MANUFACTURING 1:8.5, 1:12 & 1:16 FABRICATED THICK WEB CURVED SWITCHES</p> <p>A. In addition to the "ISO Apex Documents of RDSO", the following specific guidelines shall also be applicable for Initial approval / Quality Audit of vendors for manufacturing of 1: 8.5, 1:12 & 1:16 Fabricated Thick Web Curved Switches:</p> <p>i) List of vendors shall be maintained as and when approval is granted to the firm for various designs/ drawings of Thick Web Curved Switches i.e. for 1: 8½, 1:12 & 1:16 by adding respective drawing numbers as per approval granted.</p> <p>ii) For the purpose of approval of vendor for manufacturing of Thick web switches, the vendor shall be required to manufacture prototype of the design for which the firm has to be approved comprising of two sets - one set of left hand and one set of right-hand Thick web switch complete. One set of switch shall consist of two thick web tongue rails, two stock rails and all components as per Part List of the respective drawing/design.</p> <p>iii) For the purpose of Quality Audit of the vendor for thick web curved switches, one sample set of switch (either left hand or right hand switch) of the design for which the firm is approved shall be required to be offered for inspection.</p> <p>iv) The firm shall submit inspection gauge drawing for thick web curved switches (TWS) for the design offered for approval to RDSO. In case, fabricated thick web curved switches are to be manufactured by vendors using thick web asymmetric rails arranged by thick web switch manufacturers, the firm shall submit drawings for End forged thick web asymmetrical (TWA) rail to be used for manufacturing of TWS, inspection gauge drawing for End forged TWA rail also along with application.</p> <p>v) Two sets of inspection gauges each for End forged TWA rail, Thick web switches for the design offered for approval, shall be approved/ revalidated at the time of inspection/ verification of infrastructural facilities during initial approval / quality audit of the firm.</p> <p>vi) The inspection gauges and prototype shall be required to be approved by RDSO for each design of fabricated thick web curved switches before approval of firm for “List of vendors for development orders”. The firm shall be upgraded to list of “Approved vendors” after fulfillment of criteria given in apex ISO documents of RDSO.</p>	<p>1. Proposed modification from M/s Veera Techno Trec Pvt. Ltd. Sampla is given as under:</p> <p>i) List of vendors shall be maintained as and when approval is granted to the firm for various designs/ drawings of Fabricated Thick Web Curved Switches i.e. for 1: 8½, 1:12 & 1:16 by adding respective drawing numbers as per approval granted.</p> <p>2. Review by RDSO in reference to letter no. QAC/Vendor/Policy dt. 17.09.2021.</p>	<p>1. The comments suggested by the vendor are not acceptable as word ‘Fabricated’ is already pre-fixed in the drawings of TWS and is not considered to be added in documents. The word ‘curved’ is also included in the title in the drawings for Thick web switches. Accordingly, words ‘fabricated’ and ‘curved’ are being deleted from the document.</p> <p>2. The document has been reviewed in reference to letter no. QAC/Vendor/ Policy dt. 17.09.2021 and changes have been made in Para A accordingly, as shown below:</p> <p>A. In addition to the "ISO Apex Documents of RDSO", the following specific guidelines shall also be applicable for Initial approval / Quality Audit of vendors for manufacturing of 1:8½, 1:12 & 1:16 Thick Web Switches:</p> <p>i) List of vendors shall be maintained for various designs/ drawings of Thick Web Switches i.e., for variants 1: 8½, 1:12 & 1:16 by adding respective drawing numbers as per approval granted.</p> <p>ii) For the purpose of approval of vendor for manufacturing of Thick Web Switches, the vendor shall be required to manufacture prototype of Thick Web Switch for any of the design/ drawing(variant) comprising of two sets - one set of left hand and one set of right-hand Thick Web Switch complete. One set of switches shall consist of two thick web tongue rails, two stock rails and all components as per Part List of the respective drawing/design. Prototype approval for the other variants shall be carried out subsequently as and when offered by the firm.</p> <p>iii) For the purpose of Quality Audit of the vendor for thick web switches, one sample set of switches (either left hand or right-hand switch) of the designs for which the firm is approved shall be required to be offered for inspection.</p> <p>iv) The firm shall submit inspection gauge drawing for thick web switches (TWS) for the design offered for approval to RDSO. In case, thick web switches are to be manufactured by vendors using thick web asymmetric rails arranged by thick web switch manufacturers, the firm shall submit drawings for End forged thick web asymmetrical (TWA) rail to be used for manufacturing of TWS, inspection gauge drawing for End forged TWA rail also along with application.</p> <p>v) Two sets of inspection gauges each for End forged TWA rail, Thick web switches for the design offered for approval, shall be approved/ revalidated at the time of inspection/ verification of infrastructural facilities during initial approval / quality audit of the firm.</p> <p>vi) The inspection gauges and prototype shall be required to be got approved by RDSO for each design of thick web switches before approval of firm for “List of vendors for development orders”. The firm shall be upgraded to list of “Approved vendors” after fulfillment of criteria given in apex ISO documents of RDSO & Para C. below.</p> <p>vii) One set layout on PSC sleepers for switch portion for the design offered for approval to RDSO i.e. 1 :8.5, 1:12 & 1:16 turnout along with electrical motor operated Point Machine of 220mm stroke (Capable for checking/inspection of SSD with TWS of 160mm throw at ATS) required for checking/ inspection of TWS as per site conditions.</p>

<p>One set layout on PSC sleepers for switch portion for the design offered for approval to RDSO i.e. 1 :8.5, 1:12 & 1:16 turnout along with electrical motor operated Point Machine of 220mm stroke (Capable for checking/inspection of SSD with TWS of 160mm throw at ATS) required for checking/ inspection of TWS as per site conditions.</p>	<p>Comments of stakeholders; 15 days after uploading of Final draft:</p> <p>(i) M/s RV Rail Products Pvt. Ltd.:</p> <p>TWSEJ (Thick Web Switch Expansion Joint) may also be included in the same policy of the Thick Web Switch. This is because, from the manufacturing stand point, both the products are one and the same in nature and will need the same machinery and expertise.</p> <p>(ii) M/s Ganpati Industries Pvt. Ltd.:</p> <p>Proposed changes may take some time before a full list of approved suppliers is prepared. There is a possibility that some Railways may float tenders in the meantime linking the eligibility requirement to Curved Switches as in the past. In such a case we GIPL having sufficient experience of supplying Thick Web Switches (TWS) will be denied the right to participate in those tenders in full capacity. We being a regular supplier of Thick Web Switches will not be able to participate in the tenders for Thick Web Switch because of the present policy. This will be injustice to us.</p> <p>We request that Railways may be asked not to float tenders till the time the full list is drawn and in case of any emergency requirement it at all, an interim policy should be drawn based on</p>	<p>Not agreed. Thick web SEJ (TWSEJ) and Thick web switch are different items from their usage point of view. Though the machineries/ infrastructure required for fabrication of switches & SEJ may have similarity (but are not exactly the same), the items were being dealt under different STRs earlier too.</p> <p>As the item TWSEJ is still under development & under trial, the same has not been adopted on Indian Railways yet. The policy regarding preparation of STR/ Specification for the item shall be decided in due course.</p> <p>The development of vendors for any item is being undertaken as per the guidelines laid down in apex ISO documents of RDSO and item specific guidelines which take care of development of sufficient number of resources for healthy competition during bidding. The minimum quantity of supply for upgradation is being kept for all the items keeping in view the expertise involved in its fabrication. As TWS is safety related item which require highly skill, understanding of its fabrication & till stabilisation of the product so as to achieve consistency on sustained basis, the minimum quantity of 500 TWS was specified in the Final draft version. Presently too, the firms are being upgraded only after supply of minimum specified quantity for the item however, till such time the firms shall be eligible participate in the tenders as 'Developmental vendors'.</p> <p>However, keeping in view the minimum quantity specified for other similar items and considering the overall issues, the Minimum quantity is being reduced as 250 nos.</p>
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		capability and past experience of supply of Thick Web Switches alone without linking it to supply of curved Switches.	
2.	<p>B. In case, Fabricated thick web curved switches are to be manufactured by vendors using thick web asymmetric rails arranged by thick web switch manufacturers, the thick web end forged rails shall be procured by them as per “Qualifying requirements of tenderers for manufacturing and supply of thick web switches with firms own Asymmetrical End Forged Rails” (Annexure-I).</p> <p>First stage inspection of End forged Thick web asymmetrical rails procured by switch manufacturer shall be carried out by inspecting official of RDSO/ nominated inspecting agency at the works of vendors as per inspection regime for end forged thick web Asymmetrical TWA Rails of Zu-1-60/60E1A1 rail profile (Grade 880). After satisfactory inspection of 60Kg (UIC) End forged TWA Rails of Zu-1-60/60E1A1 rail profile (Grade 880), thick web switches shall be required to be manufactured using passed rails and offered for final inspection of RDSO/ nominated inspecting agency as per extant norms.</p>	Review by RDSO in reference to Rly. Bd.’s letter dt.,21.10.2016 & 25.05.2018 & IRST-12-2009 (latest)	<p>B. In case, Thick Web Switches are to be manufactured by vendors using their own thick web asymmetric rails, the thick web end forged rails shall be sourced by them as per “Qualifying requirements of tenderers for manufacturing and supply of Thick Web Switches with firms own Asymmetrical End Forged Rails” (Annexure-I).</p> <p>First stage inspection of End forged Thick web asymmetrical rails procured by switch manufacturer shall be carried out by inspecting official of RDSO/ nominated inspecting agency at the works of vendors as per inspection regime for end forged thick web Asymmetrical TWA Rails of ZU-1-60/60E1A1 rail profile (Grade 880/R260). After satisfactory inspection of 60kg (UIC) End forged TWA Rails of ZU-1-60/60E1A1 rail profile (Grade 880/R260), thick web switches shall be required to be manufactured using passed rails and offered for final inspection of RDSO/ nominated inspecting agency as per extant norms.</p>
3.	<p>C. The firm shall be considered for upgradation from “Vendors for Developmental order” to “Approved vendors” subject to the condition that it has supplied at least 500 Thick web curved switches of that particular design and fulfils the criteria as mentioned in apex ISO documents</p>	Review by RDSO in reference to letter no. QAC/Vendor/Policy dt. 17.09.2021.	<p>C. The firm shall be considered for upgradation from “Vendors for Developmental order” to “Approved vendors” subject to the condition that it has supplied at least 500 Thick Web Switches of any one variant or collectively for more than one variant, and fulfils the criteria as mentioned in extant apex ISO documents.</p> <p>However, keeping in view the minimum quantity specified for other similar items and considering the overall issues, the Minimum quantity is being reduced as 250 nos.</p>
		<p>Comments of stakeholders; 15 days after uploading of Final draft:</p> <p>(i)M/s Eastern Track Udyog Pvt. Ltd. (Two letters dt. 10.01.2022):</p> <p>a)The extant rule prevailing states that if any firm is Approved Vendor for fabricated switch, then that firm is automatically Approved Vendor for Thick Web Switch for that category.</p> <p>The change proposed by your good office will result in hardly few vendors being qualified as Approved</p>	<p>(i) & (ii) There is no such rule that if any firm is Approved vendor for fabricated switch then that firm is automatically Approved vendor for Thick web switch in that category. It is to mention that CNC machine, arranging TWA rails from eligible suppliers, MoU with forging agency etc. some of the additional requirements to be eligible for TWS fabrication besides being OR switch manufacturer. Therefore, all fabricated OR curved switch manufacturer are not considered to be well equipped to manufacture TWS unless they qualify the other specified requirements. Further, the use of CNC machine to fabricate TWS requires additional expertise which is not available with O.R. switch manufacturers. After implementation of STR for TWS, the firms shall have to comply the requirements specified in STR which is different from existing STR for OR switches. However, keeping in view the minimum quantity specified for other similar items and considering the overall issues, the Minimum quantity is being reduced as 250 nos.</p>

Vendors and clearly this will result in a planned Monopoly with formation of Cartels which is MOST ILLEGAL AND AGAINST ALL LAWS.

The entire objective of changing any rule is if it prevents wastage of Public Money or leads to better securing of quality.

In this case both these objectives are failed. Any firm who is an Approved Vendor for fabricated curved switch is well equipped to manufacture thick web switch and should be given an equal chance to supply.

b) The extant rule that any Approved Vendor for fabricated switch, then that firm is automatically Approved Vendor for Thick Web Switch for that category SHOULD BE KEPT VALID. In addition, ANY FIRM WHO HAS SUPPLIED 500 nos of TWS will be an approved vendor ALSO for that category. However, NO RULE CAN SUBSTITUTE AN EXISTING RULE PLACING OTHER FIRMS AT A DISADVANTAGE WITH A MOTIVE TO ONLY PLACE 1-2 FIRMS AT AN ADVANATGE.

This will lead to unhealthy completion with no real basis for change. Sir we urge you to please maintain the extant rule only for this clause.

(ii) M/s Aanjaney Rail Pvt.

The development of vendors for any item is being undertaken as per guidelines laid

		<p>Ltd.</p> <p>a) Vide letter dt. 09.01.2022 has provided their comments as given under:</p> <p><i>“The Clause 3 states in effect “The firm shall be considered for up gradation from “Vendors for Developmental order” to “Approved vendors” subject to the condition that it has supplied at least 500 Thick Web Curved Switches of any one variant or collectively for more than one variants, of that particular design and fulfils the criteria as mentioned in extant apex ISO documents”.</i></p> <p><i>As per our knowledge, the main aim of such rules and guidelines is to prevent formation of cartels or organisations so that the Railways can benefit with healthy competition and save useful money of the public. However, this kind of rule will make sure that effectively and practically only 2-3 firms will become eligible to participate in tenders as Approved vendors. If 80% of quantity goes to only these 2-3 firms, clearly there will be cartels wherein prices will be pre-decided leading to unimaginable loss of public money.</i></p> <p><i>As responsible citizen of this country, we strongly against this proposed change and we pray to your good office that please keep the old prevailing rule that if any firm is Approved Vendor for fabricated switch, then that</i></p>	<p>down in apex ISO documents of RDSO and item specific guidelines which take care of development of sufficient number of resources for healthy competition during bidding. The minimum quantity of supply for upgradation is being kept for all the items keeping in view the expertise involved in its fabrication. As TWS is safety related item which require highly skill, understanding of its fabrication & till stabilisation of the product so as to achieve consistency on sustained basis, the minimum quantity of 500 TWS was specified in the Final draft version. Presently too, the firms are being upgraded only after supply of minimum specified quantity for the item however, till such time the firms shall be eligible participate in the tenders as ‘Developmental vendors’.</p> <p>However, keeping in view the minimum quantity specified for other similar items and considering the overall issues, the Minimum quantity is being reduced as 250 nos.</p>
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firm is automatically Approved Vendor for Thick Web Switch for that category.”

b) Vide letter dt. 10.01.2022 has provided their comments as given under:

As per our knowledge, the main aim of such rules and guidelines is to prevent formation of cartels or organisations so that the Railways can benefit with healthy competition and save useful money of the public. However, this kind of rule will make sure that effectively and practically only 2-3 firms will become eligible to participate in tenders as Approved vendors. If 80% of quantity goes to only these 2-3 firms, clearly there will be cartels wherein prices will be pre-decided leading to unimaginable loss of public money.

As responsible citizen of this country, we feel strongly against this proposed change and we pray to your good office that please keep the old prevailing rule that if any firm is Approved Vendor for fabricated switch, then that firm is automatically Approved Vendor for Thick Web Switch for that category.

Sir, like in an earlier case for fish plate approval, change of inclusion of rolling mill was IMPLEMENTED with prospective effect for new Approvals. This did NOT mean that earlier approvals

		<p>were invalid. However, if a rule is brought wherein ONLY THOSE who have supplied 500 Nos. TWS can be approved vendor for that TWS, then clearly it favours HARDLY 2-3 vendors and it seems that such a rule is made to ONLY AND ONLY HELP THEM. Other forms, despite having all infrastructure, quality checks, experience, being MSME and NSIC registered will NEVER FOR ATLEAST 5-10 years BE ABLE TO MEET THIS REQUIREMENT.</p> <p>iii) Railway Board vide letter no. 2021/Track-I/16/TWS Specification/T-62 dated 15.02.2022 has forwarded M/s Hindusthan Engineering & Industries Ltd. (HEIL) letter dt. 18.01.2022 wherein M/s HEIL has submitted their proposal pertaining to classification of vendors for TWS, which are given as under:</p> <p><i>“We request Railway Board to introduce classification of TWS manufacturers on a priority basis. The classification should be as follows:</i></p> <p><i>a) <u>Approved Vendors</u></i> <i>The TWS manufacturers who have manufactured and supplied at least 500 TWS should be classified as Approved Vendors.</i></p> <p><i>b) <u>Development Source</u></i> <i>All vendors other than Approved Vendors should be</i></p>	<p>iii) The development of vendors for any item is being undertaken as per guidelines laid down in apex ISO documents of RDSO and item specific guidelines which take care of development of sufficient number of resources for healthy competition during bidding. The minimum quantity of supply for upgradation is being kept for all the items keeping in view the expertise involved in its fabrication. The proposed suggestions have been already considered in proposed procedure sent to Railway Board vide letter dt. 03.01.2022. Keeping in view the minimum quantity specified for other similar items and considering the significance of item on safety, the Minimum quantity is being kept as 250 nos.</p>
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classified as Development Source.

Proper classification of vendors will achieve dual objectives of Indian Railways:

i) Healthy competition among level playing vendors

ii) Encouragement to new entrant to manufacture TWS.”

4. D. MINIMUM FACILITIES & MACHINERIES REQUIRED FOR MANUFACTURING OFFABRICATED THICK WEB CURVED SWITCHES

(Schedule of Technical Requirements)

SN	Description of requirements	Minimum Capacity	Min. Quantity
1	Gantry Crane facilities	4 T	1 No
2	Circular saw / Circular band saw	900 mm dia.	1 No
3	Hydraulic horizontal bending/straightening machines	350-500T	1 No
4	Radial drill	32 mm dia.	1 No
5	Shapers	600 stroke	3 No
6	a) Planning machines	i) 13.0 m stroke ii) 8.5 m stroke. iii) 5.0 m stroke	1 No. 1 No 1 No
	b) CNC Plano Milling Machine	13.0 m stroke	1 No
7	Compressor with riveting	-	One complete set including furnace

1. Proposed modification from M/s Rahee Track Technologies Pvt. Ltd., Kolkata:

In regard to point No. D.10 (page 4) of Document No. TDG 00038, Rev. '0' for Item Specific Guidelines of Fabricated Thick Web curved switches where chemical lab is indicated in the list of minimum facilities & machineries required for chemical Analysis of MS, Medium & Low alloy steel in the manufacturing process, we would like to inform you that this traditional wet chemical method is labor-intensive, time consuming and also involves human error. Whereas dry lab is precise for testing all composition at once. Spectroscopy is an essential analytical tool in the modern chemical lab and with presence of the same, wet apparatus is not required. So in view of the above, we request you to remove the wet chemical apparatus from the STR.

1. The issue was referred to M&C Dte. for examining & providing comments. M&C Directorate vide letter dated 14.07.2021 suggested that 'Any method for chemical analysis i.e. Spectrometer/ wet analysis may be kept'. Accordingly, modifications are being made:

2. The suggestions of M/s Jekay are not acceptable as every unit should have Spectrometer, Metallurgical Microscope (500X with Digital recording & printing facilities) & Surface Roughness tester as these are related to routine internal as well as external quality control of raw material, Parts & Finished product pertaining to the unit.

3. Now comprehensive document of Item Specific Guidelines for Thick Web Switches & STR are prepared by RDSO based on Qualifying Requirements issued by Railway Board. Therefore, Para 2.0 of Qualifying Requirements at Annexure -1 has been deleted and details of CNC Plano Milling Machine added in STR.

D. MINIMUM FACILITIES & MACHINERIES REQUIRED FOR MANUFACTURING OFTHICK WEB SWITCHES

(Schedule of Technical Requirements)

SN	Description of requirements	Minimum Capacity	Min. Quantity
1	Gantry Crane facilities	4 T	1 No.
2	Circular saw / Circular band saw	900 mm dia.	1 No.
3	Hydraulic horizontal bending/straightening machines	350-500T	1 No.
4	Radial drill	32 mm dia.	1 No.
5	Shapers	600 mm stroke	3 No.
6	c) Planning machines	i) 13.0 m stroke	1 No.
		ii) 8.5 m stroke.	1 No
		iii) 5.0 m stroke	1 No

		arrangement (Optional)		& riveting gun etc.	<p>2. M/s Jekay International Track (P) ltd. has sent their comments as under: “If one Spectrometer, Metallurgical Microscope (500X with Digital recording & printing facilities) & Surface Roughness tester is available with any company, the said instruments should also be allowed to be used in the case of sister concern of the said company, if both companies are located in the same city. 3. RDSO review in reference to Rly. Bd’s letter dt. 25.05.2018 4. Proposed modification from M/s Veera Techno Trec Pvt. Ltd. Sampla is given as under: Shapers: i) Minimum capacity 600mm stroke ii) Minimum Qty.1 No.</p>		d) CNC Plano Milling Machine*	13.0 m stroke	1 No.
8	CO2 / Mig welding equipment	-	One complete set with approved brand of welding wires.			7	Compressor with riveting arrangement (Optional)	-	One complete set including furnace & riveting gun etc.
9	Jigs & fixtures for drilling of stock & tongue rails for Thick web switches	-	At least one set for each design separately			8	CO2 / Mig welding equipment	-	One complete set with approved brand of welding wires.
10	Chemical lab	For Chemical Analysis of MS, Medium & Low alloy steel	1 Unit installed in house for wet chemical analysis			9	Jigs & fixtures for drilling of stock & tongue rails for Thick web switches	-	At least one set for each design separately
11	Spectrometer	One spectrometer having vacuum emission CCD/PMT with printing facilities should be available for carrying out chemical analysis	1 No.			10	Chemical lab OR Spectrometer	For Chemical Analysis of MS, Medium & Low alloy steel OR One spectrometer having vacuum emission CCD/PMT with printing facilities should be available for carrying out chemical analysis	1 Unit installed in house for wet chemical analysis OR 1 No. Spectrometer
12	i) Universal Testing Machine ii) Charpy impact testing machine	40 T (minimum) -	1 No. 1 No.			11	i) Universal Testing Machine ii) Charpy impact testing machine	40 T (minimum) -	1 No. 1 No.
13	Hardness testers a) BHN/Rockwell b) Poldi	BHN hardness tester with ball size 2.5 to 10 mm dia. -	1 No. 1 No.			12	Hardness testers a) BHN/Rockwell b) Poldi	BHN hardness tester with ball size 2.5 to 10 mm dia. -	1 No. 1 No.
						13	Non-destructive testing facilities i) USFD Machine ii) D.P. test Kit iii) Magnaflux (M.P. test Kit) iv) Metallurgical	Digital type - - 500X with digital recording	1 No. 1 No. 1 No. 1 No.

		14	Non-destructive testing facilities i) USFD Machine ii) D.P. test Kit iii) Magnaflux (M.P. test Kit) iv) Metallurgical Microscope v) Polishing Machine	Digital type - - 500X with digital recording & printing facilities -	1 No. 1 No. 1 No. 1 No. 1 No.			Microscope v) Polishing Machine	& printing facilities -	1 No.
		15	Surface Roughness Tester	3 - 7 micron	1 No.		14	Surface Roughness Tester	3 - 7 micron	1 No.
		16	Assembly & Inspection bay	A separate area to be dedicated with proper levelled flooring.	500 Sq. meter		15	Assembly & Inspection bay	A separate area to be dedicated with proper levelled flooring.	500 sq. meter
		17	Dedicated covered area with all above machineries installed in house properly	-	2000 Sq. meter		16	Dedicated covered area with all above machineries installed in house properly	-	2000 sq. meter
5.	<p>E. PROFORMA FOR TECHNICAL CAPABILITY ASSESSMENT OF FIRMS FOR MANUFACTURE AND SUPPLY OF THICK WEB SWITCHES</p> <p>(To be filled in by the firm in triplicate. Attach extra sheets wherever necessary)</p> <p>SECTION – I: GENERAL INFORMATION (For record purpose only)</p> <ol style="list-style-type: none"> 1. Name of the Firm 2. Postal Address of <ol style="list-style-type: none"> (a) Head Office (b) Works 3. Telephone No. (with STD code) <ol style="list-style-type: none"> (a) Head Office (b) Works 						<p>* The CNC Plano milling machine shall be installed and shall be in working order at the firm's premises in India to handle thick web and stock rails in the required length (minimum table length of 13m) in one setup for milling operation along all x, y & z axes without handling/re-handling of rails involved in fabrication of tongue and stock rails. The firm shall furnish complete details of this machine such as performance characteristics, machining length, number of milling heads, make & photographs etc.</p> <p>4. The proposed change in quantity of shapers to 1 no. is not agreed to as the quantity of shapers is given as 3 nos. in STR for O.R. curved switches also.</p>			

<p>4. e-mail address (a) Head Office (b) Works</p> <p>5. Description of works 5.1 Total Land Area (in sqm) 5.2 Total covered area (in sqm) 5.3 Different sub-units 5.4 A fully dimensioned plan of the works showing covered area and different shall be enclosed 5.5 Special features, if any.</p> <p>6. Number of personnel employed (category wise) 6.1 Managerial 6.2 Supervisory (Enclose list of Managers / technical supervisors) 6.3 Skilled/ Artisan 6.4 Un-skilled</p> <p>7. Hours of Working</p> <p>8. Weekly off day</p> <p>9. State whether the firm is already in approved list with RDSO for supply of Over-riding Curved Switches. If so, please give details of last approval. 9.1 Letter date and issued by 9.2 Date of expiry of validity of approval</p> <p>10. Details of important orders executed in the past, in reference to the supplies made: 10.1 To other important firms/companies/undertakings 10.2 Directly to the Railways</p> <p>SECTION-II: TECHNICAL INFORMATION</p> <p>1. Production capacity i) Per month ii) Per year</p> <p>2. Type of stores /items/which firm is capable of manufacturing</p> <p>3. Crane facilities No. Of cranes Make of crane Capacity</p> <p>3.1 EOT Crane/Chain-pully block 3.2 Mobile crane 3.3 Jib Crane</p>	<p>1. Proposed modification from M/s Veera Techno Trec Pvt. Ltd. Sampla is given as under:</p> <p><i>“5.4 A fully dimensioned plan of the works showing covered area and different shed shall be enclosed.</i></p> <p>Clause 3.1 be read as: 3.1 EOT Crane 3.2 Chain-pully block 3.3 Mobile crane 3.4 Jib Crane</p>	<p>The modification suggested is accepted as the word ‘shed’ missed from the sentence inadvertently. Clause 5.4 is modified as under:</p> <p>5.4 A fully dimensioned plan of the works showing covered area and different shed shall be enclosed.</p> <p>The modification suggested is accepted because EOT Crane and Chain – pully block is separate item. Clause has been modified as under: 3.1 EOT Crane 3.2 Chain-pully block 3.3 Mobile crane 3.4 Jib Crane</p>
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	<p>4. Total Power Availability (in KVA/KW)</p> <p>(a) From the State Electricity Board or other regular source (Enclose a copy of current electricity bill)</p> <p>(b) From own stand by generating sets (Also give make, capacity, and other details of each generating set)</p> <p>5. Machines; As per Standard Technical Requirement (STR) given at page 4 & 5 in this document (For manufacturing of Thick web switches and related components).</p> <p>6. Handling facilities: It should be mentioned whether there is proper facilities for handling for finished Thick Web Switches.</p> <p>7. A fully dimensioned plan of the works showing locations of various equipment's and facilities for manufacture of thick web curved switches, flow line indicating locations of various operations during manufacture in proper sequence and storage facilities for finished products and dispatch may please be enclosed.</p>	<p><i>Clause 4 be read as:</i></p> <p>(a) From the State Electricity Board or other regular source (Enclose a copy of current electricity bill)</p> <p>2. <i>By RDSO</i></p>	<p>The suggestion is acceptable, however the word 'current' shall be replaced by word 'latest' in 4(a). Accordingly, para 4 (a) is modified as under:</p> <p>4(a) From the State Electricity Board or other regular source (Enclose a copy of latest electricity bill)</p> <p>2. <i>Sub-clause 5 & 7 Corrected as under:</i></p> <p>"5. Machines; As per Schedule of Technical Requirement (STR) given at page 4 & 5 in this document (For manufacturing of Thick web switches and related components)."</p> <p>"7. A fully dimensioned plan of the works showing locations of various equipment's and facilities for manufacture of thick web switches, flow line indicating locations of various operations during manufacture in proper sequence and storage facilities for finished products and dispatch may please be enclosed."</p>
<p>6.</p>	<p>QUALITY ASSURANCE:</p> <p>1. Does the factory have any established quality assurance programme as per ISO: 9000 Series. If yes, please enclose a copy of the relevant ISO certificate.</p> <p>2. Details of Quality Assurance organization. Name of key personnel, their qualification, designations and positions in overall management structure (enclose organizational chart for quality control).</p> <p>3. Testing facilities and laboratory equipment's available to be listed along with the make, year of procurement and commissioning.</p> <p>4. Calibration of laboratory/ test equipment/ gauges, indicated in Para 3 above. (Enclose a copy of calibration certificates).</p> <p>5. Frequency of calibration (Yearly/Half yearly).</p> <p>6. Source of procurement of raw materials/bought out components and steps taken to ensure their quality.</p> <p>7. Brief details of manufacturing process as relevant to the items/ thick web switch for which registration is sought.</p> <p>8. Details of inspection/checks done on material during various stages of the above manufacturing process (enclose a copy of QAP).</p> <p>9. Has the acceptable the value of the parameters inspected during above stage checks been laid down? If yes, the action taken if value of the parameters inspected does not meet the desire laid down value.</p> <p>10. System for documentations of the results of the above stage checks.</p> <p>11. Whether one sample set of thick web switch is ready for inspection during reassessment/ quality audit (Report to be submitted by concerned inspecting officials).</p> <p>12. Whether the firm is possessing officially issued prints of relevant</p>	<p>Proposed modification from M/s Veera Techno Trec Pvt. Ltd. Sampla is given as under</p> <p>4. Calibration of laboratory/ test equipment/ gauges, (Enclose a copy of calibration certificates).</p>	<p>Not accepted. The suggestion is not acceptable as Para 3 given above pertains to laboratory/ test equipment/ gauges.</p>

	drawings and specifications.										
7.	<p>SECTION – III: DECLARATION</p> <p>1. We do hereby declare that the above particulars are correct and no discrepancy shall be found during actual investigation before and during execution of order on our firm.</p> <p>2. Any change in the plant and machinery and change of place of office and of Works site shall be brought to the notice of RDSO for clearance and approval.</p> <p>3. We also declare that our concern has not been black listed by a Zonal Railway or Railway Board or RDSO for business with the Railways.</p> <p>4. We hereby undertake that all our equipment’s for manufacture and testing as listed above shall be maintained in good working order at all time.</p> <p>Signature of Inspecting Engineer Signature of Firm’s Rep. with stamp</p>	<p>Proposed modification from M/s Veera Techno Trec Pvt. Ltd. Sampla is given as under</p> <p>4. We hereby undertake that all our equipment’s for manufacturing and testing as listed above shall be maintained in good working order at all times</p>	<p>The suggestion is acceptable. Accordingly, para 4 is modified as under: “4. We hereby undertake that all our equipment’s for manufacturing and testing as listed above shall be maintained in good working order at all times.”</p>								
8.	<p style="text-align: right;">Annexure-1</p> <p>QUALIFYING REQUIREMENTS OF TENDERERS FOR MANUFACTURING AND SUPPLY OF THICK WEB SWITCHES WITH FIRM’S OWN ASYMMETRICAL END FORGED RAILS</p> <p>1.0 The tenderer must be RDSO approved firm for following types/drawings of over-riding switches on the date of opening of tender:</p> <table border="1" style="width: 100%; border-collapse: collapse;"> <thead> <tr> <th style="text-align: center;">Type & Drawing No. of Thick Web Switch</th> <th style="text-align: center;">Firm needs to be approved in vendor list of RDSO for following type/drawing of over-riding switch</th> </tr> </thead> <tbody> <tr> <td style="text-align: center;">60Kg 1 in 12 (RDSO/T-6155)</td> <td style="text-align: center;">60Kg 1 in 12 (RDSO/T- 4219)</td> </tr> <tr> <td style="text-align: center;">60Kg 1 in 16 (RDSO/T-7076)</td> <td style="text-align: center;">60Kg 1 in 12 (RDSO/T-4219) 60Kg 1 in 16 (RDSO/T-5692)</td> </tr> <tr> <td style="text-align: center;">60Kg 1 in 8.5 (RDSO/T-6280)</td> <td style="text-align: center;">60Kg 1 in 8.5 (RDSO/T-4966)</td> </tr> </tbody> </table> <p>Eligibility of tenderer for participating in the tender will be considered only for that particular category (type/drawing) in which he is approved in Vendor List of RDSO.</p> <p>2.0 The tenderer must have at least one CNC Plano milling machine installed and in working order at its premises in India to handle thick web and stock rails in the required length (minimum table length of 13m) in one setup for milling operation along all x, y & z axes without handling/re-handling of rails involved in fabrication of tongue and stock rails. Tenderer should furnish complete details of this machine</p>	Type & Drawing No. of Thick Web Switch	Firm needs to be approved in vendor list of RDSO for following type/drawing of over-riding switch	60Kg 1 in 12 (RDSO/T-6155)	60Kg 1 in 12 (RDSO/T- 4219)	60Kg 1 in 16 (RDSO/T-7076)	60Kg 1 in 12 (RDSO/T-4219) 60Kg 1 in 16 (RDSO/T-5692)	60Kg 1 in 8.5 (RDSO/T-6280)	60Kg 1 in 8.5 (RDSO/T-4966)	<p>1. Review by RDSO in reference to Rly. Bd.’s letter dt., 21.10.2016 & 25.05.2018 & IRST-12-2009 (latest).</p>	<p>(a) Now Item Specific Guidelines for Thick Web switches & STR are prepared by RDSO. Therefore Para 1.0 & 2.0 has been deleted and remaining para renumbered.</p> <p>(b) In para 3.0 (a) & (b) “i.e. from 01.01.2011” has been deleted as the current year.</p> <p>(c) As per IRST-12, The 60kg (UIC) rail section has been changed to 60 E1 rail section and ZU-1-60 rail section has been changed to 60E1A1 rail section. Accordingly, changes have been made.</p> <p>(d) The qualifying criteria has been further modified w.r.t. Thick web Asymmetric rails vide Railway Bd.’s letter No. 2021/Track-I (P)/Grades Policy dt. 12.01.2022 and “Policy for procurement of TWA rails issued vide Policy No. CT/Policy/02 dt. 28.01.2022. Accordingly, Annexure-1 has been revised & the modified Qualifying requirements are given as under:</p> <p style="text-align: right;">Annexure-1</p> <p>QUALIFYING REQUIREMENTS OF TENDERERS FOR MANUFACTURING AND SUPPLY OF THICK WEB SWITCHES WITH FIRM’S OWN ASYMMETRICAL END FORGED RAILS</p> <p>1.0 Asymmetrical rail of ZU-1-60/60E1A1 Rail profile shall be sourced from rail manufacturer(s):</p> <p>(a) Who have supplied asymmetrical rails as per IRS-T-12 / 2009, during last 7 (seven) years and current year upto the date of tender opening, for use in thick web switches on Indian Railways or KRCL or RVNL or any state/Central Government owned Metro Railways in India. Certificate from user Railways Network about satisfactory performance of asymmetrical rails supplied in this regard should be submitted by the tenderer.</p> <p style="text-align: center;">OR</p> <p>(b) If manufacturing facilities of Asymmetrical Rails are not located in India, then Rail manufacturer should have supplied 60 kg rails in India as per IRS-T-12 / 2009 during last 7 (seven) years and current year up to the date of tender opening and these rails should have been used on Indian Railways or KRCL or RVNL or any</p>
Type & Drawing No. of Thick Web Switch	Firm needs to be approved in vendor list of RDSO for following type/drawing of over-riding switch										
60Kg 1 in 12 (RDSO/T-6155)	60Kg 1 in 12 (RDSO/T- 4219)										
60Kg 1 in 16 (RDSO/T-7076)	60Kg 1 in 12 (RDSO/T-4219) 60Kg 1 in 16 (RDSO/T-5692)										
60Kg 1 in 8.5 (RDSO/T-6280)	60Kg 1 in 8.5 (RDSO/T-4966)										

<p>such as performance characteristics, machining length, number of milling heads, make & photographs etc., along with his offer.</p> <p>3.0 Asymmetrical rail of ZU-1-60 Rail profile shall be sourced from rail manufacturer(s):</p> <p>(a) Who have supplied asymmetrical rails as per IRS-T-12 / 2009 as amended from time to time, during last 7 (seven) years and current year i.e. from 01.01.2011 upto the date of tender opening for use in thick web switches on Indian Railways or KRCL or RVNL or any state/Central Government owned Metro Railways in India. Certificate from user Railways Network about satisfactory performance of asymmetrical rails supplied in this regard should be submitted by the tenderer.</p> <p style="text-align: center;">Or</p> <p>(b) If manufacturing facilities of Asymmetrical Rails are not located in India, then Rail manufacturer should have supplied 60 Kg rails in India as per IRS-T-12 / 2009 as amended from time to time during last 7 (seven) years and current year i.e. from 01.01.2011 up to the date of tender opening and these rails should have been used on Indian Railways or KRCL or RVNL or any State/Central Government owned Metro Railways in India; AND should have supplied asymmetrical rails, during last 7 (seven) years and current year i.e. from 01.01.2011 up to the date of tender opening, for fabrication of thick web switches to/ for passenger/ mixed traffic carrying Railways networks in minimum 3 (Three) countries and which should have been used on such railway networks. Certificates from the user Railway networks of these countries about satisfactory performance of Thick Web Switches manufactured from these rails should be submitted by the tenderer.</p> <p>4.0 The tenderer should have facilities with them or Memorandum of understanding (MoU) valid on date of tender opening with agency having facilities for end forging of asymmetrical rail of ZU-1-60 profile into 60Kg UIC rail section conforming to Indian Railways specification for supply of end forged Asymmetrical rail of ZU-1-60 rail profile for manufacturing tongue rail. The tenderer shall submit a certificate of having facilities of End Forging of Asymmetrical Rails of ZU-1-60 profile in to 60Kg Rails or submit MoU mentioned above with supporting documents.</p>	<p style="text-align: center;">Comments of stakeholders; 15 days after uploading of Final draft:</p> <p>(i) M/s RV Rail Products Pvt. Ltd. has requested that the policy for 'MOU with forging agency' should be revisited. At the moment one is required to simply enter into a MOU with any purported forged rail manufacturer. There is simply no connection to any credentials or past experience of forging rails by that proposed MOU vendor. In the current situation a MOU can be shown with any 'X' Company located in any 'Y' Country which may not have any expertise to Forging of Rails at all. It is impossible for the railway to do any verification about the credibility of the so-called forged rail manufacturer</p>	<p>State/Central Government owned Metro Railways in India; AND should have supplied asymmetrical rails, during last 7 (seven) years and current up to the date of tender opening, for fabrication of thick web switches to/ for passenger/ mixed traffic carrying Railway networks in minimum 3 (Three) countries and which should have been used on such railway networks. Certificates from the user Railway networks of these countries about satisfactory performance of Thick Web Switches manufactured from these rails should be submitted by the tenderer.</p> <p style="text-align: center;">OR</p> <p>(c) Domestic asymmetric rail manufacturers qualified as eligible, (Provisionally approved vendor or Approved vendor both) in accordance with the policy as detailed in Para I. B. (iii) of Policy issued vide No. CT/Policy/02 dated 28.01.2022.</p> <p>2.0 The tenderer should have facilities with them or Memorandum of understanding (MoU) valid on date of tender opening, with the agency having facilities for end forging of asymmetrical rail of ZU-1-60/60E1A1 profile into 60kg UIC/60E1 rail section conforming to Indian Railways specification for supply of end forged Asymmetrical rail of ZU-1-60/60E1A1 rail profile for manufacturing tongue rail. The tenderer shall submit a certificate of having facilities of End Forging of Asymmetrical Rails of ZU-1-60/60E1A1 profile in to 60kg/60E1 Rails or shall submit aMoU mentioned above with supporting documents.</p> <p>Not agreed. The criteria of 'MoU with Forging agency' was contained in the qualifying criteria issued by Railway Board vide their letter No. 2013/Track-I/16/2 dt. 21.10.2016 and modification issued vide letter No. 2013/Track-I/16/2 dt. 25.05.2018. Further, sufficient checks & tests have been laid down in 'Inspection regime' issued vide above mentioned Railway Board's letter dt. 21.10.2016 to monitor the quality of End forging produced by any agency.</p>
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		<p>which is entering into a MOU with a potential Thick Web Switch supplier.</p> <p>Forging of Rail is something which is highly technical in and of an extreme safety in nature. We must connect the MOU with the past performance / credentials of the company with whom the MOU is entered into. Reference of credentials may be taken as done in the case of Weldable CMS.</p>	
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