

Reasoned document on comments received from stack holder regarding DRAFT specification no. WD-01-

BLCS (A&B-Car)-2018

<u>S. No.</u>	<u>Original Clause</u>	<u>Comments</u> M/s Texmaco Rail & Engineering Ltd Agarpara Works (S. No. 201)	<u>RDSO Remarks</u>
1.	<p>Clause-1.1 This specification covers the particular requirements for the manufacture and supply of Broad Gauge Flat Wagon type 'BLCS (A&B-CAR) for transportation of ISO Container and other permitted Containers, strictly to the relevant drawings outlined in RDSO index drawings no. WD-15011--S-01(with latest alteration) for A-Car and WD-15012--S-01(with latest alteration) for B-Car. This wagon shall conform to the requirements of General Standard specification No. G-72 with latest revision/amendments, which can be had from Director General, RDSO (Wagon), Manak Nagar, Lucknow-226011. These wagons shall be supplied complete in all respects.</p> <p>Class - 7.2 Bogies & Wheels</p> <p>7.2.1 The wagon shall be equipped with Cast Steel Bogies (LWLH25), to Latest RDSO STR with latest amendments as per relevant drawing of the relevant wagon outlined in RDSO index drawings no. WD-15011--S-01 (with latest alteration) for A-Car and WD-15012--S-01 (with latest alteration) for B-Car.</p> <p>7.2.2 Bogie shall be fitted with wheel set to relevant drawing of the relevant wagon outlined in RDSO index drawings no. WD-15011--S-01 (with latest alteration) for A-Car and WD-15012--S-01 (with latest alteration) for B-Car.</p>	Firm's suggestion of key drawings / specification for wagon and bogies to be attached in this specification for easy reference.	Not agreed, Specification is a guiding document. The manufacture to refer drawings referred in specification.

	<p>Clause-1.3 The Contractor shall prepare his own working drawings based on the aforesaid key design drawings and submit them to the 'Engineers' for approval before undertaking production. The Contractor shall ensure that working drawings submitted for approval of the 'Engineers' are fully in accordance with key design drawings and deviations, if any, are specially pointed out. Approval of the 'Engineers' will only pertain to the design features, important controlling dimensions and the deviations from the design drawings specially pointed out by the Contractor. Corrections of the details in drawings will not be checked by the 'Engineers' and the responsibility for the same will be that of Contractor.</p>	<p>Firm's suggestion of contractor need not prepared own working drawings, as RDSO have all details drawings as per index drawings no. WD-15011--S-01(with latest alteration) for A-Car and WD-15012--S-01(with latest alteration) for B-Car. However, contractor may submit Splice Joint Drawing of longer section, I required, due to non-availability of required length as per RDSO drawing or approval. Equivalent Material specification may also be permitted with prior approval of RDSO.</p>	<p>Clause – 1.3 deleted.</p>
	<p>Clause-2.3 'Inspecting Officer'- means the person, firm or department nominated by the purchaser to inspect the work on his behalf and the deputies of the Inspecting Officer so nominated.</p>	<p>Firm's suggestion, Inspection of wagon is to be carried out by RDSO wagon Inspection Directorate as mentioned in Clause No. 8.1</p>	<p>Not agreed, Clause 8.1 is sufficient to describe the same.</p>
	<p>Clause-3.1 General requirements and comprehensive guidance with regard to edge preparation, fit up for welding, welding procedure and inspection of welded joints are contained in clause 8 of General Standard Specification No. G-72) with latest revision/amendments. This should be strictly followed.</p> <p>Clause-3.2 Wherever welding is specified or adopted in the manufacture of the wagons or in the fabrication of sub- assemblies and components, the manufacturer shall obtain the approval of his proposed welding procedure in format and sequence from the Engineer. An exception statement to down hand welding shall be provided by the contractor while submitting along with WPS for approval. This however, will not in any way reduce the Contractor's responsibility for satisfactory execution of the contract in all respects as stipulated in Clause 4 of General Standard Specification No. G-72 with latest revision/amendments.</p>	<p>Firm's suggestion Welding procedure (WPS) may please be prepared & issued by RDSO in line with other IR Wagon like BRN22.9, BTPN, BOXNHL, BCNAHSM1 etc.</p>	<p>Agreed and Welding procedure (WPS) shall be prepared later.</p>

	<p>Clause-4.1 One 'Pattern Wagon' shall be manufactured by the supplier, manufacturing this wagon first time, for carrying different tests. This wagon will be squeeze load tested at the premises of the manufacturer in presence of engineers to establish manufacturing quality. Required test rig for squeeze load test shall be provided by the manufacturer and therefore, the wagon builders having this facility already available with them should be preferred.</p>	<p>Firm's suggestion for proto approval purpose, one pattern wagon may be treated as one wagon each of A-Car & B-Car.</p>	<p>Agreed, Clause-4.1 One 'Pattern Wagon' shall be manufactured by the supplier, manufacturing this wagon first time, and Pattern Wagon may be treated as one wagon each of BLCS A-Car & BLCS B-Car for carrying different tests. This wagon will be squeeze load tested at the premises of the manufacturer in presence of engineers to establish manufacturing quality. Required test rig for squeeze load test shall be provided by the manufacturer and therefore, the wagon builders having this facility already available with them should be preferred.</p>
	<p>Clause-10.1 The Contractor shall also submit an itemized list of recommended maintenance spares for two years requirement and of any special tools and gauges required for maintenance along with quotations for each item, indicating name and address of the manufacturer. The Purchaser will finalize this list after the detailed design has been approved by RDSO/ Lucknow. The delivery of such spares and tools as the Purchaser elects to purchase will be effected by the Contractor along with the first consignment of wagons.</p>	<p>Firm's suggestion, RDSO may please recommend list of standard spares as required or maintenance of wagon/Bogie. Purchaser may procure the same separately.</p>	<p>Not agreed</p>

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2.		Dy. CME/HQ, Headquarter Office, Mech. Engg. Dept., Southern Railway, Chennai – 600003 (S. No. 202)	
	<p>Clause 7.3 COUPLER AND DRAFT GEAR:</p> <p>7.3.1 'BLCS (A&B-CAR)' wagon shall be equipped with:</p> <p>7.3.2 High Tensile Center Buffer Coupler (NT) to RDSO STR with latest revision/amendment as mentioned in the relevant drawing of the relevant wagon outlined in RDSO index drawings no. WD-15011--S-01 (with latest alteration) for A-Car and WD-15012--S-01 (with latest alteration) for B-Car.</p> <p>7.3.3 High capacity draft gear to RDSO STR with latest revision/amendments as mentioned in relevant drawing of the relevant wagon outlined in RDSO index drawings no. WD-15011--S-01 (with latest alteration) for A-Car and WD-15012--S-01 (with latest alteration) for B-Car.</p> <p>7.3.4 Coupler operating mechanism for center buffer coupler shall be positioned as shown in the relevant drawing of the relevant wagon outlined in RDSO index drawings no. WD-15011--S-01 (with latest alteration) for A-Car and WD-15012--S-01 (with latest alteration) for B-Car. The fitment of coupler, high capacity draft gear, striker casting, yoke pin support, and yoke and back stop etc. shall conform to the relevant drawing of the relevant wagon outlined in RDSO index drawings no. WD-15011--S-01 (with latest alteration) for A-Car and WD-15012--S-01 (with latest alteration) for B-Car.</p>	<p>Clause 7.3 of the above-mentioned Draft specification only High Tensile Center Buffer Coupler (NT) is mentioned for BLCS wagons the reference drawings given there in (WD-15011-S-01 for A-Car and WD-15012-S-01 for B Car) indicate that.</p> <p>For A Car (Reference Drawing No. WD-15011-S-03) one end is to be provided with High Tensile Center Buffer Coupler (NT) & other end is provided with Slack less drawbar.</p> <p>For B Car (Reference Drawing No. WD-15012-S-03) both ends are to be provide with Slackless drawbar.</p> <p>Hence the reference drawings mentioned in the specification are to be modified in line with specification</p>	All concerned drawings modified & submitted to record.

	<p>Clause 7.4 Air Brake:</p> <p>7.4.1 The wagon shall be equipped with graduated release air brake equipment to RDSO STR with latest amendments to the relevant drawing of the relevant wagon outlined in RDSO index drawings no. WD-15011--S-01 (with latest alteration) and WD-15012--S-01 (with latest alteration) for B-Car. The layout of the complete air brake equipment shall be in accordance with the arrangement shown in to the relevant drawing of the relevant wagon outlined in RDSO index drawings no. WD-15011--S-01 (with latest alteration) and for A-Car WD-15012--S-01 (with latest alteration) for B-Car.</p> <p>7.4.2 The pipes and joints consisting of brake pipe, branch pipes & pipe joint as specified in RDSO specification as mentioned in the relevant drawing of the relevant wagon outlined in RDSO index drawings no. WD-15011--S-01 (with latest alteration) for A-Car and WD-15012--S-01 (with latest alteration) for B-Car.</p> <p>7.4.3 The complete air brake equipment including the pipes and joints shall be fitted on pattern wagon in accordance with the relevant drawing of the relevant wagon outlined in RDSO index drawings no. WD-15011--S-01 (with latest alteration) for A-Car and WD-15012--S-01 (with latest alteration) for B-Car and offered to the Engineers for approval. The Contractor shall be obliged to carry out any modifications on the layout of the air brake equipment if found necessary by the Engineers.</p> <p>7.4.4 Brake block force shall be checked at the time of prototype testing, with the necessary facilities, equipments, etc. being provided by the manufacturer. The manufacturer shall carry out any modification required after testing.</p> <p>7.4.5 Contractor shall proceed with the bulk production of the pipes and joints only after the final approval of the layout of complete air brake equipment, on the pattern wagon.</p>	<p>Clause 7.4 (Reference Drawing Nos. WD-15011-S-14 & WD-15012-S-9) the referred drawings for graduated release air brake equipment & pipings didn't include the modification related with the fitment of high capacity draft gears & CBC in lieu of Quick Draw Draft Gears and Slackless Draw Bar. The referred pipe drawings need to be modified.</p>	<p>All concerned drawings modified & submitted to record.</p>
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	<p>7.4.6 During the bulk production of wagons, the Contractor shall ensure that the complete air brake equipment is fitted on the wagon correctly as per the dimensions shown in the layout drawing. Special care must be taken with regard to the clamping arrangement of pipes to under frames besides securing of clamps with pipe and tack welding of nuts with bolts.</p>		
	<p>Clause 7. 5 Painting & Markings: The surface preparation and painting of wagon under frame, fixed ends, and floor plate shall be as follows.</p> <p>(i) Degrease with petroleum hydrocarbon solvent to IS: 1745-78 (or latest), low aromatic grade 145/205 or any other degreaser (which is suitable for IS 2062:2006 E410Cu)</p> <p>(ii) Surface preparation: Shot blast, parts made of IS 2062:2006 E410Cu to get a surface finish of minimum Sa2.5 as per ISO: 8501-1. Clean the surface by using compressed air or any other suitable means like brush etc.</p> <p>(iii) Within 02 hours of cleaning the surface, apply 2 coats of Epoxy zinc phosphate primer (Two pack) to RDSO spec No. M&C/PCN/102/2005 (or latest) to minimum DFT of 120 microns.</p> <p>(iv) Apply 2 coats of ready mix Red Oxide (ISC: 446), to RDSO Spec. No. M&C/PCN/122/06 (or latest) to minimum DFT of 80 microns.</p>	<p>Clause 7. 5 (Reference Drawing Nos. WD-15011-S-06 & WD-15012-S-05)</p> <p>Surface preparation for floor plates & fixed end are stated, it is noted that there is no such floor plates & fixed end in BLCS wagons. Material specification is given as IS:2062 2006 E410Cu whereas in drawings under reference it is mentioned as IS:2062 E450 BR with Cu.</p>	<p>Agreed, Clause 7. 5 Painting & Markings:</p> <p>The surface preparation and painting of wagon under frame shall be as follows.</p> <p>(i) Degrease with petroleum hydrocarbon solvent to IS: 1745-78 (or latest), low aromatic grade 145/205 or any other degreaser (which is suitable for IS 2062 E450 BR with Cu)</p> <p>(ii) Surface preparation: Shot blast, parts made of IS 2062 E450 BR with Cu to get a surface finish of minimum Sa2.5 as per ISO: 8501-1. Clean the surface by using compressed air or any other suitable means like brush etc.</p> <p>(iii) Within 02 hours of cleaning the surface, apply 2 coats of Epoxy zinc phosphate primer (Two pack) to RDSO spec No. M&C/PCN/102/2005 (or latest) to minimum DFT of 120 microns.</p> <p>(iv) Apply 2 coats of ready mix Red Oxide (ISC: 446), to RDSO Spec. No. M&C/PCN/122/06 (or latest) to minimum DFT of 80 microns.</p>
	<p>Marking Diagram</p>	<p>Provision of R FID Tags not mentioned.</p>	<p>Concerned drawing modified & submitted to record.</p>

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3.		Dy. CME/Freight, Office of the Chief Mechanical Engineer East Coast Railway Bhubaneswar – 751017 (S. No. 203)	
	Clause 10: SPARE PARTS 10.1 The Contractor shall also submit an itemized list of recommended maintenance spares for two years requirement and of any special tools and gauges required for maintenance along with quotations for each item, indicating name and address of the manufacturer. The Purchaser will finalize this list after the detailed design has been approved by RDSO/ Lucknow. The delivery of such spares and tools as the Purchaser elects to purchase will be effected by the Contractor along with the first consignment of wagons. 10.2 The Contractor shall be responsible for ensuring subsequent availability of the spare parts for efficient working of the wagons.	Spare parts: The manufacturer shall be responsible for ensuring budgetary offer/rate quotation of spare parts to the concerned division/Railways for procuring of spare parts for maintenance of the wagons.	Not agreed, Budgetary offer/rate quotation of spare parts shall not be part of specification as rate vary over a period of time.
	Clause 11: Service Manuals and Spare Parts Catalogue 11.1 Detailed maintenance and operation manual of CBC, Draft Gear, K-Class CTRB and other uncommon (with BOXNHS) sub-assemblies procured by the manufacturer shall be supplied in 10 copies (in both hard and soft format). 11.2 Detailed spare parts catalogue of the sub-assemblies mentioned in para 11.1 above shall also be included in this maintenance and operation manual. 11.3 One set of all the above mentioned manuals shall be sent to Engineers in advance for approval.	Service manuals and spare parts catalogue:- Detailed maintenance and operation manual of CBC, Draft Gear, K-Class CTRB and other uncommon (with BOXNS) sub-assemblies procured by the manufacturer shall also be made available to the maintenance depots/divisions.	Not agreed, Operation and maintenance manual required by maintenance depots/divisions may be collected from RDSO, Lucknow.