

## WHEEL SHOP

Click on Production Module > Click on Wheel Shop > Select

Following menu option available for Wheel Shop users:

- Wheel Shop Production
- SIP for Wheel & Axle Assembly and SIP for CTRB
- Issue Quality Clearance
- Wheel Quality clearance report
- Wheel dispatch list
- reports

### Wheel Shop Production

In wheel shop production there are basic two functionalities

1. Add a new record
2. Exit/turnout of the wheel shop production

Modern Coach Factory, Raebareli  
Production Monitoring System

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Add + Dash-Board Production Module Maintenance Manpower Utilization Furnishing Stage Clearance Account

Wheel Shop Production

Add Activity For: Wheel Production Exit/Turnout Add new record

SNo	Wheel RBL No.	Mounting Date	Axle Make	Axle No.	Right Wheel Disc No.	Right Wheel Disc Make	Left Wheel Disc No.	Left Wheel Disc Make	Right Brake Disc Make	Left Brake Disc Make	Right CTRB No.	Right CTRB Make	Left CTRB No.	Left CTRB Make
1	DJN742424	08-04-2020	RWT	MKB76	F11567	ZD	GDS453	TZ	IV	IV	Timken	FG464	SKT	11FRYR55
2	VYD576	09-03-2020	RWF	BUYEQ65	TGED566	TZ	TUW576	ZB	KNORR	PV	Timken	UIIDW867	Timken	DWTYE546

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The icon encircled in black is through which we can **edit** our required wheel specification.

### Add new record

One can add new wheel record in Wheel Shop Production.

To add new record > Click on new record. > Fill all the details.

**Add new record**

Wheel RBL No.  
Enter Wheel RBL no.

Mounting Date  
Enter Mounting Date

Axle Make.  
select

Axle No.  
Enter Axle No.

Right Wheel Disc No.  
Enter right Wheeldisc

Right Wheeldisc Make  
select

Left Wheel Disc No.  
Enter right Wheeldisc

Left Wheeldisc Make  
select

Right Brake Disc Make  
select

Left Brake Disc Make  
select

Right CTRB Make  
select

Right CTRB No.  
Enter right CTRB No.

Left CTRB Make  
select

Left CTRB No.  
Enter left CTRB No.

Cancel Save

## Exit/Turnout

If the user wants to Dispatch the Wheel.

Select row > Click on **Exit/Turnout**. > Fill the details.

**Exit for Wheel No. VYD576fro...**

Enter Dispatch Date:  
10-04-2020

Dispatch To: Select

Customer/ R: Bogie Shop, RSP

Remarks:  
Enter Remark

Submit Close

## Note:

In Exit/Turnout, **Dispatch To** has two option **Bogie Shop** and **RSP**.

On selecting **Bogie Shop**, Wheels are available to be receipt in Bogie Shop.

On selecting **RSP**, customer select option gets enabled.

**Exit for Wheel No. DJNF42424...**

Enter Dispatch Date:  
10-04-2020

Dispatch To: RSP

Customer/ Railways: Select

Remarks:  
Enter Remark

Close

## Quality module for Wheel Shop

### SIP for Wheel & Axle Assembly and SIP for CTRB

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Set Mounting Date From Date: 10-03-2020 To Date: 09-04-2020 Load records

**Wheel Shop Production**

SNo	Mounting Date	Axle Make	Axle No.	Right Wheel Disc No.	Right Wheel Disc Make	Left Wheel Disc No.	Left Wheel Disc Make	Right Brake Disc Make	Left Brake Disc Make	Right CTRB No.	Right CTRB Make	Left CTRB No.	Left CTRB Make	SIP for Wheel & Axle Assembly	SIP for CTRB
1	01-04-2020	RWF	RW45RF	4F4TF	TZ	FF444	SAIL	FV	FV	SKF	DW2331		DD3VF3	Completed	Completed
2	08-04-2020	RWF	MK876	FH567	ZB	GD5453	TZ	FV	FV	Timken	F6464	SKF	HFRYR55	Not Completed	Not Completed
3	13-03-2020	others	1342	342	SAIL	33	SAIL	KBI	KBI	Timken	G424F	Timken	R3R2F44	Not Completed	Not Completed

Mounting Date has to be selected to show the required result.

Here in this we have two SIP test on Wheel: 1) SIP for Axle, 2) SIP for CTRB

#### 1. SIP for Axle Assembly

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Set Mounting Date From Date: 10-03-2020 To Date: 09-04-2020 Load records

**Wheel Shop Production**

SNo	Mounting Date	Axle Make	Axle No.	Right Wheel Disc No.	Right Wheel Disc Make	Left Wheel Disc No.	Left Wheel Disc Make	Right Brake Disc Make	Left Brake Disc Make	Right CTRB No.	Right CTRB Make	Left CTRB No.	Left CTRB Make	SIP for Wheel & Axle Assembly	SIP for CTRB
1	01-04-2020	RWF	RW45RF	4F4TF	TZ	FF444	SAIL	FV	FV	SKF	DW2331		DD3VF3	Completed	Completed
2	08-04-2020	RWF	MK876	FH567	ZB	GD5453	TZ	FV	FV	Timken	F6464	SKF	HFRYR55	Not Completed	Not Completed
3	13-03-2020	others	1342	342	SAIL	33	SAIL	KBI	KBI	Timken	G424F	Timken	R3R2F44	Not Completed	Not Completed

**Testing for Wheel and Axle Assembly**

**SELF INSPECTION REPORT OF WHEEL & AXLE ASSEMBLY**

DOC No.: RCE/RBL/QME-4002 Ver: 01 Date: 08-04-2020 Shift: Shift-I

Applicable drawing: LW02001, GC-K6016, T021 Applicable WI (If any): PLW4701 Heat No.: 7675

Wheel Disc No(left): FF444 Wheel Disc No(right): 4F4TF Wheel Disc Type: CAST

Axle No: RW45RF Axle Type: RWF Wheel Set Type: LHB

**OBSERVATION**

A. Dimension

Journal dia		Collar dia		Wheel dia		Distance between wheel face to disc face	
Left Side	Right Side	Left Side	Right Side	Left Side	Right Side	Left Side	Right Side
130+0.068/+0.043 mm	160+0.174/+0.134 mm	915+4/0 mm	1600+/-1.175+/-0.5 mm				
656.09	657.08	74.32	33.32	75.43	56.88	76	9

B. Pressing Pressure:

Pressing pressure of brake disc				Pressing pressure of wheel disc			
LHB-240-420 KN for Knorr & 139.63-498.71 KN for favelly (ref: SME/B&D letter no MD24171 dtd 30.09.11)				LHB-680-1072 KN			
Pressure (Left side)	Brake disc make	Pressure (Right side)	Brake disc make	Pressure (Left side)	Wheel disc make	Pressure (Right side)	Wheel disc make
65	FV	76	FV	65	SAIL	43	TZ

#### 2. SIP for CTRB

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Set Mounting Date From Date: 10-03-2020 To Date: 09-04-2020 Load records

**Wheel Shop Production**

SNo	Mounting Date	Axle Make	Axle No.	Right Wheel Disc No.	Right Wheel Disc Make	Left Wheel Disc No.	Left Wheel Disc Make	Right Brake Disc Make	Left Brake Disc Make	Right CTRB No.	Right CTRB Make	Left CTRB No.	Left CTRB Make	SIP for Wheel & Axle Assembly	SIP for CTRB
1	01-04-2020	RWF	RW45RF	4F4TF	TZ	FF444	SAIL	FV	FV	SKF	DW2331		DD3VF3	Completed	Completed
2	08-04-2020	RWF	MK876	FH567	ZB	GD5453	TZ	FV	FV	Timken	F6464	SKF	HFRYR55	Not Completed	Not Completed
3	13-03-2020	others	1342	342	SAIL	33	SAIL	KBI	KBI	Timken	G424F	Timken	R3R2F44	Not Completed	Not Completed

**Testing for CTRB Section**

**SELF INSPECTION REPORT OF CTRB Stage**

DOC No.: RCE/RBL/QME-4001 01/201 Date: 08-04-2020 Shift: Shift-I

Applicable drawing: E-48999/PART No. H12774 Applicable WI (If any): PLW 4705 Heat No.: 7675

Axle No: RW45RF Axle Make: RWF Wheel Set Type: LHB

**OBSERVATION**

A. Dimension

S. No	Description	Observed value
1	Items fitted as per Drawing	OK
2	Compliance of applicable W.I	NOT OK
3	Filling of grease in Axle box (1.75 kg/Housing)	OK
4	Difference of wheel Dia. in same axle (with in 0.5mm)	OK
5	Check the journal & CTRB for any damage/crack	OK
6	Journal dia left (130+0.043/+0.068mm)	656.09
7	Journal dia right (130+0.043/+0.068mm)	657.08
8	Wheel dia left (915+4/0 mm)	75.43
9	Wheel dia right (915+4/0 mm)	56.88
10	Distance between wheel (1600+/-1 mm)	76.00
11	Tightening of Hexagonal head screws (210 Nm for LHB type Wheel)	OK
12	Lateral clearance Left Side(20-389 μ for TIMKEN) (ref. as per Timken manual) and (28-32 T for SKF) (ref. SKF Letter no. PD/MCF/2017/001 dtd. 19.05.17)	65
13	Lateral clearance Right Side(20-389 μ for TIMKEN) (ref. as per Timken manual) and (28-32 T for SKF) (ref. SKF Letter no. PD/MCF/2017/001 dtd. 19.05.17)	87

After performing these two testing in Wheel shop, the Wheel is listed for for Quality Clearance.

## Issue Quality Clearance

In Issue Quality Clearance, we clear the wheel from Quality test under wheel shop, this option is only for Wheel which is clear SIP for Wheel Assembly and CTRB. Here you can also see the report for Wheel & Axle SIP and CTRB SIP.

Select row > Click **Quality Control Clearance Memo for Wheelset.** > Fill the details.

## Wheel Quality clearance report




It shows all the Wheel that has been cleared.

SNo	Mounting Date	Axle Make	Axle No.	Right Wheel Disc No.	Left Wheel Disc No.	Right CTRB No.	Left CTRB No.	Wheel & Axle SIP	CTRB SIP	Quality Clearance
1	01-04-2020	RWF	RW45RF	4F4TF	FF444	DW2331	DD3VF3			

All the icon marked shows report of Wheel Axel SIP, CTRB SIP and Quality Clearance memo.

## Wheel dispatch list

Here all the Wheel Dispatched from the Wheel Shop Production is Visible.

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SNo	Wheel RBL No.	Right Wheel No.	Left Wheel No.	Axle No.	Dispatched Date	Dispatch To	Railway/Customer	Remarks
1	192137	09064/8WQ3	02949/8W13	19L6243	02-04-2019	Bogie Shop	Not Applicable	
2	192136	09641/8WK4	03888/8WH3	19L5298	02-04-2019	Bogie Shop	Not Applicable	
3	192139	12880/8WS1	09065/8WQ3	19L8382	02-04-2019	Bogie Shop	Not Applicable	
4	192140	03964/8WL8	00217/8W10	19L8296	02-04-2019	Bogie Shop	Not Applicable	
5	192143	02954/8W13	12873/8WS1	19L8343	02-04-2019	Bogie Shop	Not Applicable	
6	192142	02948/8W13	03887/8WH3	19L8383	02-04-2019	Bogie Shop	Not Applicable	
7	192141	08880/8WN3	09640/8WK4	19L8361	02-04-2019	Bogie Shop	Not Applicable	
8	192138	08883/8WQ3	06383/8WT0	19L6246	02-04-2019	Bogie Shop	Not Applicable	
9	192146	08885/8WM0	08884/8WL7	19L5814	02-04-2019	Bogie Shop	Not Applicable	
10	192148	02309/8WH4	04833/8W18	19L8941	02-04-2019	Bogie Shop	Not Applicable	

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# Reports

Click on Production Module > click on Wheel Shop > Click on Reports.

These are all the result option Shown.

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Wheel Shop Production  
 SIP for Wheel & Axle Assembly  
 Issue Quality Clearance  
 Wheel Quality Clearance Report  
 Wheel Dispatch List  
 Reports

SNo	Wheel RBL No.	Right Wheel No.	Left Wheel No.	Axle No.	Dispatched Date	Dispatch To	Railway/Customer	Remarks
1	192137	09064/8WQ3	02949/8W13	19L6243	02-04-2019	Bogie Shop	Not Applicable	
2	192136	09641/8WK4	03888/8WH3	19L5298	02-04-2019	Bogie Shop	Not Applicable	
3	192139	12880/8WS1	09065/8WQ3	19L8382	02-04-2019	Bogie Shop	Not Applicable	
4	192140	03964/8WL8	00217/8W10	19L8296	02-04-2019	Bogie Shop	Not Applicable	
5	192143	02954/8W13	12873/8WS1	19L8343	02-04-2019	Bogie Shop	Not Applicable	
6	192142	02948/8W13	03887/8WH3	19L8383	02-04-2019	Bogie Shop	Not Applicable	
7	192141	08880/8WN3	09640/8WK4	19L8361	02-04-2019	Bogie Shop	Not Applicable	
8	192138	08883/8WQ3	06383/8WT0	19L6246	02-04-2019	Bogie Shop	Not Applicable	
9	192146	08885/8WM0	08884/8WL7	19L5814	02-04-2019	Bogie Shop	Not Applicable	
10	192148	02309/8WH4	04833/8W18	19L8941	02-04-2019	Bogie Shop	Not Applicable	

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List of Wheel set for Bogie  
 List of Wheel set for RSP  
 Missing Data Entry Wheel  
 Wheel Quality Control Clearance Memo  
 Wheel Self Inspection Report  
 Avg Duration for Wheel Assembly  
 SIP REPORT OF Wheel & AXLE ASSEMBLY  
 SIP REPORT OF CTRB  
 Wheel shop Gantt Chart  
 Daily staff position of Wheel shop  
 Monthly Production Position stage wise of Wheel Shop and Bogie Shop  
 Annual Production Status of Wheel Shop  
 Monthly Production Wheel

localhost:8080/MCFRBL/wheel-dispatch-production# Designed & Developed by CRIS