



Govt. of India
Ministry of Railways
Research Designs & Standards Organisation
Manak Nagar, Lucknow-226 012

QM-C-7.1/COUPLER/00011/E (Rev.-02)
Inspection plan(Check Sheets)

Item : Knuckle Pivot Pin.
Spec. : WD-70-BD-10 (Rev.3) or latest
Drg. No. & Alt : SK-62724, Alt. – 28, Item-4

1. **Firm Name :**
2. **Date of Inspection :**
3. **Contact Details :**
 - a. **PO. No. & date :**
 - b. **Order placing Authority:**
 - c. **Specification No. :**
 - d. **Drawing No. :**
4. **Order quantity :**
5. **Quantity passed earliest :**
6. **Quantity offered now :**
7. **Quantity passed now :**
8. **Quantity rejected :**
9. **Date of offer :**
10. **Consignee :**
11. **Delivery period :**
12. **Case file No. :**

SANJAI
JAUHRI

Digitally signed by SANJAI JAUHRI
DN: cn=SANJAI JAUHRI, c=IN,
o=UTTAR PRADESH,
ou=MINISTRY OF RAILWAYS,
serialNumber=BF5A8ACB6284358
9C066D112792EE235F60B991037
26C1558BCA8FD2762E0FD4
Date: 2024.03.13 13:39:17 +05'30'

Signature of Firm's Representative

Inspecting Official of RDSO



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Inspection Check Sheet for Knuckle Pivot Pin.

Spec. WD-70-BD-10 (Rev.3) or latest

1. **Visual Check:** sample size- 10% of the lot.

1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20

2. **Dimension Check:** 10% checked by gauge (all dimension in mm)

SAMPLE NO	HEAD DIA 52.4	PIN DIA 41.28	TOTAL LEGHTH 342	HEAD THK 12.5	DIA OF WASHER 51.0	THK. OF WASHER 5.0

3. **Chemical Composition: each lot (attach copy)**
 (Chemical Test as per IS: 5517 42 CR4 MO2)

	%C	%Mn	%Si	%S	%P	%Cr	%Mo
Specified Value	0.38-0.45	0.60-0.90	0.10-0.35	0.035 max	0.035 max	0.90-1.20	0.15-0.30
Observed Value							

4. **Physical Test:** as per WD-70-BD-10 for Knuckle. Pin

	U.T.S (Kgf/mm ²)	Y.S (Kgf/mm ²)	% EL	% RA
Specified Value	91.77-107.07 Kgf/mm ² (min) or 900-1050 Mpa	66.28 Kgf/mm ² (min) or 650 Mpa	11 % (min)	46.20 (min)
Observed Value				

5. **Hardness check:** 5% As per para 4.2.1.2 of WD-70-BD-10(Rev.3) or latest
Specified Value: 229-428 BHN

1	2	3	4	5	6	7	8	9	10

Note: Take hardness on Top, Bottom & Center as specified in WD-70-BD-10

a) Marking: Manufacture's initial and month/ year of manufacture stamped on head . OK/Not OK
b) Packing: Material in loose sealed in gunny bag. OK/Not OK

Signature of Firm's Representative

Inspecting Official of RDSO