

ISO 9001:2015	Document No: TDG 0038	Version No: 1.0	Date Effective:00.00.2024
Document Title: Item Specific Guidelines & Schedule of Technical Requirements for Vendor Approval for manufacture and supply of Thick Web Switch , Thick Web Switch Expansion Joints & End forged Thick web Asymmetric (TWA) rails			



**RESEARCHDESIGNS&STANDARDSORGANISATION**  
**MANAKNAGAR, LUCKNOW – 226011**

**Document No.: TDG 0038, Rev.'1'**

**Document Title:** Item Specific Guidelines & Schedule of Technical Requirements for Vendor Approval for manufacture and supply of Thick Web Switch , Thick Web Switch Expansion Joints and End forged Thick web Asymmetric rails.

**1.0 Amendment History:**

S.No.	Amendment Date	Version	Reason for Amendment
1.	20.05.2022	0.0	First Issue
2.	00.05.2024	1.0	Incorporate the scope for Thick Web Switch Expansion Joints and End forged Thick web Asymmetric (TWA) rails.

**2.0 Purpose:**

This Item Specific Guidelines covers all technical requirements for manufacture and supply of Thick Web Switch, Thick Web Switch Expansion Joints (Section A & B) and End forged Thick web Asymmetric (TWA) rails (Section C & D) used for Fresh Vendor Registration/ Quality Audit of Vendors.

**3.0 Scope of Application:**

This shall be applicable for Fresh vendor registration, Quality Audit, up-gradation of Vendors and maintaining the approved list of vendors. In case of any variation between the procedure /provision given in the work instructions and that in this 'Item-Specific Guidelines', the later shall prevail. The competent authority wherever referred to in this document shall mean Executive Director Track-II. / ~~Principal Executive Director, Infra-1.~~

**4.0 Procedure/Details:** Procedure/details are given hereunder ~~annexed.~~

**5.0 Referred Document:** IRS: T-10 (latest revision), IRS: T-62 (latest revision)

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## 6.0 Referred Documents of External Origin:

None

## 7.0 Associated Records:

None

## 8.0 Responsibility and Authority:

Activity	Responsible	Approver	Supporting	Consulted	Informed
Creation, maintenance of this document	ED/Track-II, Director /Track Design-III	PED/Infra-I	DD/AIE/ADE	M&CDte.	All vendors/ concerned Through website
Compliance of directives contained in this document	DD/AIE/ADE	ED/Track-II	----	----	----
Requirement of deviation from this directive	ED/Track-II, Director/Track	PED/Infra-1	DD/AIE/ADE	M&CDte.	----

## 9.0 Abbreviations

PED/Infra-1	Principal Executive Director/Infrastructure-I
ED/Track Design-II	Executive Director/Track Design-II
RDSO	Research Designs & Standards Organization
DD	Deputy Director
AIE	Assistant Inspecting Engineer
ADE	Assistant Design Engineer
M & C Dte.	Metallurgical & Chemical Directorate

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**A. ITEM SPECIFIC GUIDELINES FOR INITIAL APPROVAL/ QUALITY AUDIT OF FIRMS FOR MANUFACTURING 1:8.5, 1:12& 1:16 THICK WEB SWITCHES &THICK WEB SWITCH EXPANSION JOINTS**

1. 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 Switches &Thick Web Switch Expansion Joints:
  - i) List of vendors shall be maintained for ~~various designs/ drawings of~~ 'Thick Web Switches' ~~i.e. of variants~~ 1: 8½, 1:12 & 1:16 by adding respective drawing numbers as per approval. ~~A separate list shall be maintained for Thick Web Switch Expansion Joints (Drawing No. RDSO/T-8822).~~
  - ii) For the purpose of approval of vendor for manufacturing of Thick web switches of particular variant, the vendor shall be required to manufacture prototype of Thick web switch for ~~any of the particular~~ 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 switch 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.~~ For the purpose of approval of vendor for manufacturing of Thick Web Switch Expansion Joints, the vendor shall be required to manufacture prototype of Thick Web Switch Expansion Joints comprising of all components as per part list of the respective drawings, forming one complete set of Thick Web Switch Expansion Joints.
  - iii) For the purpose of Quality Audit of the vendor for Thick web switches/ Thick Web Switch Expansion Joints, one sample set of Thick web switch of the design for which the firm is approved (either left hand or right hand switch)/ Thick Web Switch Expansion Joints shall be required to be offered for inspection.
  - iv) The firm shall submit inspection gauge and Jigs and Fixtures drawing for Thick web switches and/or Thick Web Switch Expansion Joints for the design offered for approval to RDSO. In case, Thick web switches / Thick Web Switch Expansion Joints 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 and Jigs and Fixtures drawing for End forged TWA rail also along with application.
  - v) Two sets of inspection gauges and one set of Jigs and Fixtures each for End forged TWA rail, Thick web switches and/or Thick Web Switch Expansion Joints 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.

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- vi) The inspection gauges, **Jigs and Fixtures** and prototype shall be required to be got approved by RDSO for each design of thick web switches & **Thick Web Switch Expansion Joints**. ~~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.
- vii) For **Thick web switches**, 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 capable of 220mm stroke (for checking/inspection of SSD with TWS of 160mm throw at ATS) is required for checking/ inspection of Thick web switches as per site conditions.
- viii) For Thick web Switch Expansion Joints, one set layout on PSC sleepers is required for checking/ inspection as per site conditions.

~~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).~~

~~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)/60E1 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.~~

## 2. Upgradation :

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 250 Thick web switches of any one variant or collectively for more than one variant / at least **250 sets of Thick web Switch Expansion Joints** and fulfills the criteria as mentioned in extant apex ISO documents.

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**B. MINIMUM FACILITIES & MACHINERIES REQUIRED FOR MANUFACTURING OF THICK WEB SWITCHES / THICK WEB SWITCH EXPANSION JOINT**  
(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	600mm stroke	3 No.
6	a) Planning machines	i) 13.0 m stroke ii) 8.5 m stroke. iii) 5.0 m stroke (for item 'Thick web Switches')	1 No. 1 No. 1 No.
	b) CNC Plano Milling Machine*	13.0 m stroke (for item 'Thick web Switches')	1 No.
		8.5m minimum stroke (for item 'Thick web SEJ')	1 No.
	c) Plano Milling Machine	5 m minimum stroke	1 No.
7	Compressor with riveting arrangement (Optional)	(for item 'Thick web Switches')	One complete set including furnace & riveting gun etc.
8	CO2 / Mig welding equipment	-	One complete set with approved brand of welding wires.
9	Jigs & fixtures for drilling of stock & tongue rails for Thick web switches/Thick web SEJ	-	At least one set for each item separately as per Drawings
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
11	i) Universal Testing Machine ii) Charpy impact testing machine	100T (minimum) -	1 No. 1 No.
12	Hardness testers		

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	a) BHN/Rockwell	BHN hardness tester with ball size 2.5 to 10 mm dia.	1 No.
	b) Poldi	-	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.
15	Surface Roughness Tester	<del>3-7 micron</del> 3 - 20 micron	1 No.
16	Assembly & Inspection bay	A separate area to be dedicated with proper leveled flooring.	500 Sq. meter
17	Dedicated covered area with all above machineries installed in house properly	-	2000 Sq. meter
18	Coordinate Measuring Machine (CMM) Electronic Dimensional measurements with auto recording facility(Optional)	Adequate for measurement of Tongue rail machining from ATS to JOH/ critical points (as per drawing)	1 No.

\* 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 13 m for Thick web Switch & minimum table length of 8.5 m for Thick web Switch Expansion Joints) 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 with surface roughness of 3-7 micron. The firm shall furnish complete details of this machine such as performance characteristics, machine length, number of milling heads, make & photographs etc.

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**C. ITEM SPECIFIC GUIDELINES FOR FRESH VENDOR REGISTRATION / QUALITY AUDIT OF FIRMS FOR MANUFACTURE AND SUPPLY OF END FORGED THICK WEB ASYMMETRICAL (TWA) RAILS:**

In addition to the "ISO Apex Documents of RDSO (Latest version)" the following shall also be applicable for fresh Vendor Registration/Quality Audit of the firms for manufacture and supply of End Forged Thick Web Asymmetrical (TWA) rails.

- i) The list shall be maintained for particular combination of rail source and rail section/grade of End Forged Thick Web Asymmetrical (TWA) rails.
- ii) The approval to End Forging units shall be granted for particular combination of rail source and rail section/grade of End Forged Thick Web Asymmetrical (TWA) rails.
- iii) In case of any change in above combination, the entire process of sample testing shall be carried out.
- iv) Two sets of inspection gauges and one set of Jigs and Fixtures for End forged TWA rail shall be approved/ revalidated at the time of inspection/ verification of infrastructural facilities during initial approval / Quality Audit of the firm.
- v) Thick web Asymmetric (TWA) rails shall be sourced as per "Qualifying requirements of tenderers for manufacturing and supply of thick web switches with firms own Asymmetrical End Forged Rails"(Annexure-I).
- vi) The firm shall submit internal test results (ITR) for 03 sample forgings as per drawing for end forged rail (containing at least one sample for LH & one for RH) as per IRS: T-62 (latest) and offer for sample testing. After scrutiny of ITR, RDSO shall carry out sample testing at the works of firm. In this regard, 03 sample forgings as per drawing for end forged rail (containing at least one sample for LH & one for RH) shall be prepared in presence of RDSO officials and necessary tests as per IRS: T-62 (with latest amendments) shall be conducted.
- vii) On successful testing on 03 samples, the firm shall be advised 03 critical locations from hardness considerations as per IRS: T-62 (latest) and firm shall be permitted for End Forging of Thick Web Asymmetrical 60E1A1 profile rails to symmetrical 60E1 profile rails for particular combination of rail source and rail section/grade.
- viii) For easy identification, each End forging shall have legible unique identification, punched at the flange of end forged length.
- ix) The firm shall be considered for upgradation from "Developmental Vendor" category to "Approved Vendors" category subject to the condition that it has supplied at least 500 End Forged Thick Web Asymmetrical Rails and the rejection rate for last 500 End Forgings should be less than 2% (combining internal and external inspection). The firm shall also be required to fulfill the criteria as mentioned in extant apex ISO documents.
- x) For the purpose of Quality Audit of the vendor for 60E1A1 profile TWA rails End Forged to 60E1 profile rails, one sample End Forged Rail (either left hand or right-hand) as per drawing for end forged rail and combination of rail source and rail section/grade of End Forged Thick Web Asymmetrical (TWA) rails for which the firm is approved shall be required to be offered for inspection.

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**D. MINIMUM FACILITIES & MACHINERIES REQUIRED FOR MANUFACTURING OF END FORGED THICK WEB ASYMMETRICAL RAILS:**

S. No.	Description	Minimum Capacity	Minimum Quantity
1.	Forging Press with automatic closed die forging process	--	One No.
2.	Induction Heating Furnace with controlled atmosphere	1100 °C to 1200°C	One No.
3.	Gantry Crane facilities	4T	One No.
4.	Circular saw / Circular band saw	900 mm diameter	One No.
5.	Hydraulic horizontal bending/ straightening machines	350-500T	One No.
7.	CNC Plano Milling Machine*	3.0 m stroke*	One No.
8.	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	1 Unit installed in house for wet chemical analysis  OR One No. Spectrometer
9.	Universal Testing Machine	40 T (minimum)	One No.
10.	Charpy impact testing machine		One No.
11.	Hardness testers a) BHN/Rockwell	BHN hardness tester with ball size 2.5 to 10 mm dia.	One No.
	b) Poldi	-	One No.
12.	Non-destructive testing facilities i) Ultrasonic Flaw Detection Machine ii) Dye Penetration Test Kit iii) Magnaflux (M.P. test Kit) iv) Metallurgical Microscope	Digital type - - 500X with digital recording & printing facilities	1 No. 1 No. 1 No. 1 No.
	v) Polishing Machine	-	1 No.
13.	Surface Roughness Tester	<del>3-7 micron</del> 3 - 20 micron	1 No.
14.	Assembly & Inspection Bay	A separate area to be dedicated with proper levelled flooring.	500 sq. meter

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15.	Dedicated covered area with all above machineries installed in house properly	--	2000 sq. meter

\* The CNC Plano milling machine shall be installed and shall be in working order at the firm's premises in India for milling operation along all x, y & z axes with surface roughness of 3-7 micron. The machine should have sufficient arrangement for supporting & clamping the rail along its length. The firm shall furnish complete details of this machine such as performance characteristics, machining length, number of milling heads, make & photographs etc.

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**E. PROFORMA FOR TECHNICAL CAPABILITY / CAPACITY ASSESSMENT OF FIRMS FOR MANUFACTURE AND SUPPLY OF THICK WEB SWITCH/ **THICK WEB SWITCH EXPANSION JOINTS/ END FORGED TWA RAILS****

(To be prepared by the firm in duplicate – Attach extra sheets wherever necessary)

**SECTION-IGENERAL INFORMATION(FOR RECORD PURPOSE ONLY)**

1. Name of the firm:
2. Postal Address of–
  - (a) Head Office:
  - (b) Works:
3. Telephone No .(with STD Code)/**Mobile No. cum Whatsapp number**–
  - (a) Head office:
  - (b) Works:
4. **Fax** &E-mail Address of–
  - (a) Head Office:
  - (b) Works:
5. **GST Identification Number of Firm:**
6. Description of Works
  - 6.1 Total Land area (insq.meters)
  - 6.2 Total Covered area (insq.meters)
  - 6.3 Different sub-units
  - 6.4 A fully dimensioned plan of the works showing covered area and different shed shall be enclosed:
  - 6.5 Special features, if any.
7. Number of personnel employed (category-wise)
  - 7.1 Managerial
  - 7.2 Supervisory (Enclose list of Managers/Technical Supervisors)
  - 7.3 Skilled/Artisans
  - 7.4 Un- skilled
8. Hours of working
9. Weekly off days

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10. State whether the firm is already in the ~~list of~~ Vendor directory on IREPS portal for supply of Over-riding Curved Switches / Thick Web Switches/ Thick Web Switch Expansion Joints/End Forged TWA Rails. If so please give details of last approval:

10.1 Letter date and issued by-

10.2 Date of expiry of validity of approval/Next Quality Audit due-

11. Details of important orders executed in the past, in reference to the supplies made.

11.1 To other important firms/companies/undertakings.-

11.2 Directly to the railways.

## SECTION-II: TECHNICAL INFORMATION.

1. Production Capacity

(i) Per month

(ii) Per year

2. Type of ~~Stores~~/Items which the firm is capable of manufacturing.

3. Details of Items for which Fresh Vendor Registration / Quality Audit is sought (please indicate complete description and drawing nos.)

4. Crane facility                      No. of Cranes                      Make of crane                      Capacity

(a) EOT Crane

(b) Chain – pulley block

(c) Mobile Crane

(d) Jib Crane

5. Total Power availability (In kVA/kW)

(a) From the State Electricity Board or other regular source

(Enclose a copy of current Electricity Bill)

(b) From own stand-by Power Generating sets

(Also give make, capacity & other details of each generating set).

6. Machines, As per Schedule of Technical Requirement (STR) given at page 5 & 6 in this document (For manufacturing & supply of Thick web switch/ Thick web switch Expansion Joints ) & given at page 8 in this document (For manufacturing & supply of End forged Thick web Asymmetric (TWA) rails

7. Handling facilities:

It should be mentioned whether there is proper facilities for handling for finished Thick Web Switch / Thick Web Switch Expansion Joints/End Forged TWA Rails.

8. A fully dimensioned plan of the works showing locations of various equipment and facilities for manufacture of Thick Web Switch / Thick Web Switch Expansion Joints/ End Forged TWA Rails, flow line indicating locations of various operations during manufacture in proper sequence and storage facilities for finished products may please be enclosed.

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### SECTION-III: QUALITY ASSURANCE PROGRAMME

- Does the factory have any established Quality Assurance Programme as per ISO: 9001 series? If yes, please enclose a copy of the write-up in sequential order.
- DetailsofQualityAssuranceOrganization.Nameofkeypersonnel,theirqualification, designations and positions in overall management structure (enclose organizational chart for quality control).
- Quality Control testing facilities and laboratory equipment available to be listed along with the make, year of procurement and commissioning.
- Calibration of laboratory test equipment / inspection gauges/ Jigs and Fixtures, as indicated in Para 3 above (Enclose a copy of calibration certificates):  
How the calibrations done:  
Frequency of calibration of each instrument (Yearly/Half yearly except for inspection gauge/ jigs and fixtures: Frequency of calibration is yearly )
- Sourceofprocurementofrawmaterials/boughtoutitemsandstepstakentoensuretheirquality.
- Briefdetailsofmanufacturingprocessasrelevanttotheitemsforwhichregistrationissought.
- Details of inspection / checks done on material during various stages of the above manufacturing process (enclose a copy of approved QAP).
- Has the acceptable the value for the parameters inspected during above stage checks been laid down? If yes, the action taken against values of the parameters inspected does not meet the desired laid-down value.
- System for documentation of the results of the above stage checks.
- Whether the firm is possessing officially issued prints of relevant Drawings and Specifications?

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#### SECTION-IV DECLARATION:

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.
2. Any change in the Plant & Machinery, change of place of office and place of works premises shall be brought to the notice of RDSO for clearance and approval.
3. We also declare that our concern has not been black listed by Railway, Railway Board/RDSO for business with the Railways.
4. We hereby undertake that all our equipment for manufacture and testing as listed above shall be maintained in good working order at all times.
5. We hereby declare that the contents and instructions of ISO Apex Documents of RDSO have been ready by us and our firm shall agree to abide by all the stipulations laid therein.
6. We hereby undertake to maintain the record of the following in proper format:
  - a) Procurement of raw material for production of Thick Web Switch / Thick Web Switch Expansion Joints / End Forged TWA Rails
  - b) Supply of Thick Web Switch / Thick Web Switch Expansion Joints / End Forged TWA Rails against various P.Os
  - c) Disposal of rejected Thick Web Switch / Thick Web Switch Expansion Joints / End Forged TWA Rails.

Place:

Signature

Date:

Name in full of Signing Authority  
Designation in the Firm

Stamp of the firm

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## Annexure-1

### QUALIFYING REQUIREMENTS OF TENDERERS FOR MANUFACTURING AND SUPPLY OF THICK WEB SWITCHES & **THICK WEB SWITCH EXPANSION JOINTS** WITH FIRM'S OWN ASYMMETRICAL END FORGED RAILS

1.0 Asymmetrical rail of ZU-1-60/60E1A1 Rail profile shall be sourced from rail manufacturer(s):

- (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 regards should be submitted by the tenderer.

OR

- (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.

OR

- (c) Domestic asymmetric rail manufacturers qualified as eligible, (Provisionally approved vender 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

2.0 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-1-60/60E1A1 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 Rails or shall submit MoU mentioned above with supporting documents.

ADE/Track/P&C	Director/Track-III	Printed:00.00.2024
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