



सत्यमेव जयते

Govt. of India
Ministry of Railway
Research Design & Standard Organization
Manak Nagar- Lucknow-226011

QM-C-8.1/Air Spring/001/RDPL/406

Inspection Plan (Check Sheet)

Item: Air Spring 180 KN for High Capacity EMU/DMUs
Specn.: CK-406, Rev.-3
Amd.: 1 of May 2019
Drg. No. & Alt.:

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Name of manufacture	M/s Resistoflex Dynamics Pvt. Ltd
Date of offer	
RDSO File No.	
Purchase Order No.	
Total Quantity Ordered	
Quantity earlier passed	
Quantity now offered	
Quantity Passed	
Consignee	
D.P. Date	
Date of Inspection	
Qty. accepted	
Qty. rejected	
Balance order	

Lot Size	10	25	50	75	100	Above 100
No of sample	2	3	4	5	6	6%

Signature of Firm's Rep.

Signature of RDSO Inspecting Authority



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1. Visual Inspection			Observed					Remarks
SN	Particulars	Specified	Sample No.					
1.	Finish	Smooth						
2.	Cut	Nil						
3.	Burrs/Flash	Nil						
4.	Rust/Corrosion	Not Allowed						
5.	Weld/Paint Marks	Not Allowed						
6.	Flatness/ Parallelism	OK/Not OK						
7.	Identification	As per STR						
8.	“O” Ring	OK/Not OK						
2. Dimensional Inspection (Dimensions in mm)								
SN	Particulars	Specified in Firm's Drawing approved by RDSO						
1.	Base Plate	L: 600 ± 2 W: 400 ± 1.2 t: $12 \pm .2$						
2.	Fixing hole dia.	22 ± 0.2						
3.	Spigot Dia.	$85^{+0.036}_{-0.071}$						
4.	Spigot Height	35.0 ± 0.5						
5.	Top plate dia. skirt	720 ± 0.8						
6.	Fixing hole centre distance PCD	L: 250 ± 0.5 W: 478.64 ± 0.8 540 ± 0.8						
7.	Diameter of Air bellow at 6 bar under design height of 255^{+5}_{-0} mm	$\varnothing 740$ mm (Max.)						
Status: Accepted/ Not Accepted								

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PRESSURE vs LOAD TEST REPORT

SPECIFIED VALUE (As per approved type- test report)

Pressure in Kg/cm ²	Load in KN.	
	Min	Max
1.0	29.1	32.1
2.0	57.9	63.9
3.0	86.2	95.2
4.0	114.9	126.9
5.0	144.0	159.2
6.0	172.3	190.5

ACTUAL VALUES OBSERVED

Values as per Pressure Gauge	Load (KN.)	Load (KN.)	Load (KN.)	Load (KN.)	Load (KN.)
	Sample No.				
1.0 Kg/Cm ²					
2.0 Kg/Cm ²					
3.0 Kg/Cm ²					
4.0 Kg/Cm ²					
5.0 Kg/Cm ²					
6.0 Kg/Cm ²					
Status: Accepted/ Not Accepted					

BUMPER LOAD VS DEFLECTION TEST REPORT

SPECIFIED VALUE

SPECIFIED VALUE(As per approved type-test report)

SN	Load (KN)	Force (KN)	
		Min.	Max.
1	4.0	50	67
2	8.0	102	135
3	12.0	157	208
4	14.6	205	271

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ACTUAL VALUES OBSERVED

S No.	Deflection (mm)	Force (KN)					Remark
		Emergency spring S. No.					
1							
2							
3							
4							
5							
6							
Status : Accepted/ Not Accepted							

AIR SPRING ASSEMBLY LEAK TEST REPORT

1. Parameter : Inflate the Air Spring at 9 kg/cm² and hold for 60 minutes. Repeat the same at 6 kg/cm² for 15 mins. Pressure drop upto 1% is allowed. As per STR-C-K406 Rev-3 clause number 10.3

2. Sample Quantity:

3.

SL. No.	Air Spring Number	Remarks
1		
2		
3		
4		
5		

Status: Accepted/ Not Accepted

Signature of Firm's Rep.

Signature of RDSO Inspecting Authority