



भारत सरकार - रेल मंत्रालय
अनुसंधान अभिकल्प और मानक संगठन

Government of India - Ministry of Railways
RESEARCH DESIGNS & STANDARDS ORGANISATION

DOCUMENT NO. TDG 0013, Rev. '0'

**ITEM SPECIFIC GUIDELINES
FOR
HTS HEX BOLTS AND NUTS
SIZE 24 X 140MM**

Price: Rs. 360/-

गुणवत्ता आश्वासन सिविल निदेशालय
अनुसंधान अभिकल्प और मानक संगठन
मानक नगर, लखनऊ -226011

**QUALITY ASSURANCE CIVIL DIRECTORATE
RESEARCH DESIGNS & STANDARDS ORGANISATION
MANAK NAGAR, LUCKNOW – 226011**

Schedule of Technical Requirements for manufacture of HTS HEX Bolts and Nuts Size 24 x 140 MM

1. General & Manufacturing Facilities required

- 1.1 Adequate covered and uncovered area for storage of raw and finished material
- 1.2 Source of sufficient power with at least a standby generator.
- 1.3 At least 2 nos. mechanical powers presses of 150-200 t capacity.
- 1.4 A tool room and die making facilities i.e. shaper, surface grinder, bench grinder, nose grinder and measuring instrument etc.
- 1.5 Facilities of heat treatment furnace including oil quenching and finally analyzing arrangement with automatic temperature control system

2. Testing Facilities required

- 2.1 Certified atmospheric lab for maintaining standard temperature and humidity when testing as per BIS code.
- 2.2 At least 40-ton capacity tensile testing machine capable of reading the load and elongation as per the requirement of the product duly calibrated from an approved laboratory.
- 2.3 Facilities for Dump bell preparation, bend test and full-fledged facility for chemical analysis of the product.
- 2.4 Rock well (HRC) hardness testing M/c with standard test piece.
- 2.5 The following measuring instrument in adequate number:
 - i) Vernier Caliper and Scale (Linear)
 - ii) Suitable facilities for cutting the test specimen from the product
 - iii) At least two sets of Go-No Go gauges to check the dimensional accuracy of the product – calibrated on due dates along with the calibration record. All the gauges must bear the firm's initials and set number.

3. Quality control requirements:

- 3.1 There should be a system to ensure the traceability of the product from raw material sample to finished product stage.
- 3.2 Ensure that there is a QAP for the product detailing various aspects like- Organizational chart, flow process chart and stage inspection details.
- 3.3 Ensure that the relevant specification & BIS standard are available with the firm.

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**PROFORMA FOR TECHNICAL CAPABILITY ASSESSMENT FOR
MANUFACTURE OF HTS HEX BOLTS & NUTS SIZE 24 x 140 MM TO IS: 1367
CLASS 10.9 FOR BOLTS & 12.9 FOR NUTS**

1. SECTION-I : GENERAL INFORMATION

1.1. Name of The Firm:

1.2. Address:

- (a) Head Office
- (b) Works
- (c) Location of Works

1.3. Factory Area (Sq.M):

- (a) Covered
- (b) Uncovered
- (c) Is The Factory Site In Your Name or On Rental Basis?
Support with Documents

1.4 (a) Telephone No:

- 1) Head Office
- 2) Works

(b) Telegraphic Address / Telex Address / Fax Address:

- 1) Head Office
- 2) Works
- 3) E-mail address

1.5. SSIC / NSIC Regn No.
(Copy Enclosed):

1.6 Power Availability (KVA):

- (a) General Allotted Capacity
- (b) Stand by Generator & Its Capability If Available

- (b) Name the Party / Person In
Whose Name The Power Is
Sanctioned & Your Agreement
With Party / Person (Support
Reasonable With Documents)

1.7. Name of Any Other Unit Located in the Above Premises:

1.8. Man Power Management:

- (A) Managerial Staff
- (B) Shop Floor Engineers /
Supervisors, (Their Nos., Name
Qualifications & Services Experience
- (C) Full Time or Part Time Indicate
Their Names, Qualifications & Services
- (D) Inspection & Quality Control
Staff & Their Name, Qualification
And Service Experience
- (E) Workmen
 - 1) Highly skilled
 - 2) Semi-skilled
 - 3) Un-skilled

2. **Section-II : Technical Information**

2.1 Manufacturing Facilities

2.1(i) Manufacturing Power Press (es)

- (A) Nos. as available
- (B) Make
- (C) Capacity

2.1(ii) Tools Room and Die Making
Facility E.G. Shaper, Surface
Grinder, Nose Grinder,
Measuring Instrument etc.

2.1(iii) Bench Grinders (Given Nos.
Available)

2.2 Testing Facilities,

2.2(i) Tensile Test / Testing Machine

- (a) Capacity
- (b) Make
- (c) In-House Calibration Facility
- (d) Dumbbell Preparation

2.2 (ii) Bend Test Facility

2.2 (iii) Dimensional Check Facility
Inspection Gauges (2 Sets Min.)

2.3 Laboratory Cum Inspection Room

2.3 (i) Indicate Availability in Yes or No

2.3 (ii) If Yes, Indicate Size of Room

2.4 Source of Raw Material (In-house
Rolling Mill shall be preferred)

2.5 Arrangement for Storing Raw
Material at a time (in Tonnes)

3. Section-III : Experience (For Record Purpose Only)

3.1 Indicate various types of items being manufactured in your works and the name of the agency / client for whom it is being manufactured.

3.2 Indicate important customers for the last 3 years both government and non-government, if any, for information furnished in your reply to 3.1

3.3 Give details (contract reference item and quantity manufactured and supplied) of important orders executed in the past 3 years for the following.

Indicate the inspecting agency for each :

3.3 (i) Govt. Department, General State and Govt. Undertaking other than Railway.

3.3 (ii) Directly to the Railways

3.3 (iii) Outside important firms

3.4 Specify current orders in hand on your firm (contract reference client, item, under manufacture and supply).

3.5 Whether you are already registered with RDSO for other P. way items, if so, name the item supported by documents

3.6 Whether you are already registered with RDSO for items other than P.way items, if so, name the item and department with which you are registered, support with documents.

3.7 Indicate annual turnover of your company.

4.0 Declaration

4.1 We do hereby declare that the above that the above particulars are correct and no discrepancy shall be found during actual investigation before and during execution of order on our firm.

4.2 Any change in the plant and machinery and change of place of office and of works site shall be brought to the notice of RDSO for clearance and approval.

4.3 We also declare that our concern has not been black listed by Railway, Railway Board/RDSO for business with the Railways.

4.4 We hereby undertake that all our equipments for manufacturing and testing as listed above shall be maintained in good working order at all times.

Signature

Name in full of Signing Authority

Status in the Firm,

Place

Date

Stamp of the firm.