



QM-C-8.1/CASNUB BOGIE/0001

INSPECTION CHECK SHEET FOR CASNUB-22 NLB/NLC BOGIE ASSEMBLY
(RDSO Specification No. WD-21-CASNUB-22NLB Bogie-93, Rev-2)

- 1 Name of Manufacturer :
2 Address of works :
3 Date of offer :
4 RDSO File No :
5 Drawing and Alt. No :
6 Specification :
7 P.O. No and date :
8 Total quantity Ordered :
9 Quantity Earlier passed :
10 Quantity now offered :
11 Consignee :
12 D.P :

SI No.	DM Item	Ref. DM No.
1	Side Frame	
2	Bolster	
3	Centre pivot top	
4	Friction Wedge	
5	Bolster Springs	
6	Side Bearer	
7	Spring Plank	
8	Side frame liner, Bolster liner, Centre Pivot liner	
9	Brake Beam	
10	Brake Block	
11	Modified Elastomeric Pad	
12	Centre Pivot Washer	

1. Date of inspection
2. Quantity accepted
3. Quantity rejected
4. Balance order

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Note:

These check sheets do not detail all the dimensions or technical requirements of respective Bogie assemblies/components.

These check sheets are issued only for General Guidance & assistance of inspecting officials. Notwithstanding the above, the inspecting officials are advised to refer to relevant drawings and/or relevant specifications to confirm conformity to the specified dimensions and technical details.

1. A) Offered bogies / Components details (100%)

S.No	Bogie no.	S/F No. 1	S/F No. 2	Bol.no.	S.No	Bogie no.	S/F No. 1	S/F No. 2	Bol.no.
1.					26				
2.					27				
3					28				
4					29				
5					30				
6					31				
7					32				
8					33				
9					34				
10					35				
11					36				
12					37				
13					38				
14					39				
15					40				
16					41				
17					42				
18					43				
19					44				
20					45				
21					46				
22					47				
23					48				
24					49				
25					50				

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1. B) OTHER CHECKS:

- a. Whether springs of same colour code are used in same bogie.?
- b. Marking details of side frame, bolster, center pivot top, wedge etc. are as per relevant drawing.
- c. Whether Centre pivot top and side bearer - base areas are machined?
- d. Side Bearer base & Centre Pivot Bottom Base difference will be 15 ± 2 .
- e. Centre pivot assembled height = $120 \begin{matrix} +2 \\ -0 \end{matrix}$

2. BOGIE ASSEMBLY TRAMMELING PARAMETERS AND BOGIE CLEARANCES (5%)

Total No. of Bogie Assemblies Tested :
(Separate chart to be filled for each bogie)

Bogie serial No.	
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A. Bogie Assembly trammeling parameters

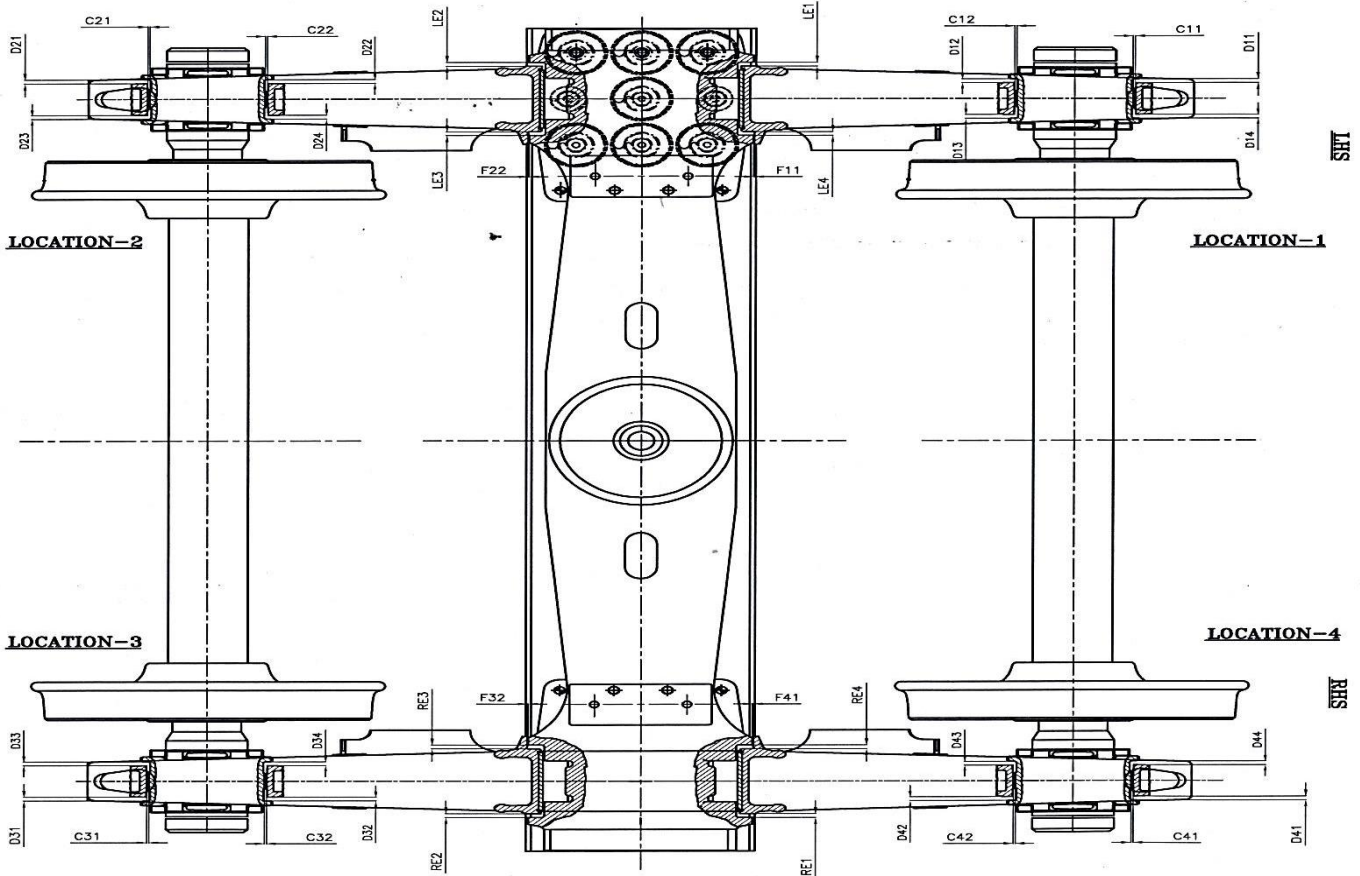
SL. NO.	DETAILS OF ITEM CHECKED	SPECIFIED (MM)	OBSERVED
1	a) Diagonal b) Max diff. Between two diagonals c) Max diff. Of half diagonals	a) 3018+/-4.5 b) 3.5 c) 4.0	
2	a) Wheel base b) Max diff. Between two wheel bases c) Button no. of assembled side frames	a) 2000+/-5 b) 2 but should be of same button. c) 1,2,3,4,&5	
3	a) Journal center b) Max diff. Between two Journal Centers	a) 2260 +/-1.5 b) 1	
4	Dis. Between Rail level to bottom of Side Frame	165+0/-5	
5	Brake beam pocket lateral distance	2048 ±1.5	
6	Distance between Side Bearer Centers	1474±5 max (737 from pivot center)	
7	Gap between Side Frame & Spring plank	0.5 max	

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B. Bogie Clearances



1. Lateral clearance between Side frame and Bolster (9 ± 1.5)							
LHS				RHS			
LE1				RE4			
LE2				RE3			
LE3				RE2			
LE4				RE1			
LE1+ LE4 = LE2 + LE3 = 18 ± 3 Difference in any of LE1, LE2, RE4, RE3 $\leq 2mm$				RE1 + RE4 = RE2 + RE3 = 18 ± 3 Difference in any of LE3, LE4, RE2, RE1 $\leq 2mm$			
2. Longitudinal clearance between side frame and bolster anti rotation lug ($2 \begin{smallmatrix} +1.5 \\ 0.0 \end{smallmatrix}$)							
F11		F22		F32		F41	
3. Lateral clearance between side frame and adapter ($8 \begin{smallmatrix} +3 \\ -0.75 \end{smallmatrix}$)							
D11		D41		D21		D31	
D12		D42		D22		D32	
D13		D43		D23		D33	
D14		D44		D24		D34	
D11+D14=D12+D13 = $16 \begin{smallmatrix} +6 \\ -1.5 \end{smallmatrix}$; D41+D44=D42+D43 = $16 \begin{smallmatrix} +6 \\ -1.5 \end{smallmatrix}$ and diff. in any of D11, D12, D44, D43 $\leq 2mm$ & D13, D14, D42, D41, $\leq 2mm$				D21+D23 = D22+D24 = $16 \begin{smallmatrix} +6 \\ -1.5 \end{smallmatrix}$ D31+D33 = D32+D34 = $16 \begin{smallmatrix} +6 \\ -1.5 \end{smallmatrix}$ D21, D22, D33, D34 $\leq 2mm$ & D23, D24, D31, D32 $\leq 2mm$			
4. Longitudinal clearance between side frame and adapter ($4.5 \begin{smallmatrix} +1.0 \\ -1.5 \end{smallmatrix}$)							
C11		C41		C21			C31
C12		C42		C22			C32
C11 + C12 = C41 + C42 = $9 \begin{smallmatrix} +2 \\ -3 \end{smallmatrix}$				C21 + C22 = C31 + C32 = $9 \begin{smallmatrix} +2 \\ -3 \end{smallmatrix}$			

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3.A) LOAD CHART REPORT FOR WD-21-CASNUB-22 NLB (6.4.2 Spring Group) 5%
Suitable fixture with proper offset between CP and side bearer should be used.

Total No. of Bogie Assemblies Load Tested :
(Separate load test chart to be filled for each bogie)

Bogie serial No.	
Wheel dia	

SL. NO.	Description Of Test	Specified value (mm)				Value Observed				
		Light Bogie	Height Under 6T	Height Under 35.2T	Height Under 53.3T	Light Bogie	Height Under 6 T	Height Under 35.2T	Height Under 53.3T	Height After Release
1	Center pivot Ht From RL	957 +3/-8	932 +3\ -8	894 +3/-8	871 + 3/- 8					
2	Side Bearer Ht From RL	---	921 +4.5/ -9.5	883 +4.5/- 9.5	860 +4.5/ -9.5					
3	Spring group height	279±3	254± 3	216±3	193± 3					

- Dimensions above are with 1000mm Wheel dia.

3.B) LOAD CHART REPORT FOR WD-21-CASNUB-22 NLB (7.5.2 Spring Group) 5%

Total No. of Bogie Assemblies Load Tested :
(Separate load test chart to be filled for each bogie)

Bogie serial No.	
Wheel dia	

SL. NO.	Description Of Test	Specified value (mm)				Value Observed				
		Light Bogie	Height Under 6T	Height Under 40.5T	Height Under 60.8T	Light Bogie	Height Under 6T	Height Under 40.5T	Height Under 60.8T	Height After Release
1	Center pivot Ht From RL	957 +3/-8	933 +3\ -8	895 +3/-8	872 +3/-8					
2	Side Bearer Ht From RL	---	922 +4.5/- 9.5	884 +4.5/- 9.5	861 +4.5/ -9.5					
3	Spring group height	279± 3	255±3	217±3	194± 3					

- Dimensions above are with 1000mm Wheel dia.

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3.C) **LOAD CHART FOR WD-21-CASNUB-22 NLB (7.7.2 Spring Group For NLC Bogie) 5%**

Total No. of Bogie Assemblies Load Tested :
(Separate load test chart to be filled for each bogie)

Bogie serial No.	
Wheel dia	

SL. NO.	Description Of Test	Specified value (mm)				Value Observed				
		Light Bogie	Height Under 6T	Height Under 40.5T	Height Under 60.8T	Light Bogie	Height Under 6T	Height Under 40.5T	Height Under 60.8T	Height After Release
1	Center pivot Ht From RL	957 +3/-8	933.5 +3\ -8	894 +3/-8	871.5 + 3/- 8					
2	Side Bearer Ht From RL	---	922.5 +4.5/ -9.5	883 +4.5/ -9.5	860.5 +4.5/ -9.5					
3	Spring group height	279± 3	255.5 ±3	216± 3	193.5 ±3					

- Dimensions above are with 1000mm Wheel dia.

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