



QM-C-7.1/BOGIE LWLH25/0001/C
INSPECTION CHECK SHEET FOR LWLH25 CENTRE PIVOT TOP

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

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

Signature of firms Representative

RDSO Representative
Name Designation & Stamp



2. Chemical, Micro-examination & Mechanical Properties Test

(A) Chemical Composition (As Per M&C Heat Clearance Register)

Element\ Heat No.										
C - 0.32 (Max.)										
Mn- 1.85(Max.)										
Si - 1.50 (Max.)										
P - 0.04 (Max)										
S - 0.04 (Max)										
CE - 0.88 (Max.)										

B) Micro-examination(As Per M&C Heat Clearance Register)

Grain Size ASTM 4 or finer										
Microstructure Normalized & Tempered and should be Non- dendritic										

C) MECHANICAL PROPERTIES (AS PER THE HEAT REGISTER)

Specified Value(N/mm2/mpa)										
UTS-620 (Min)										
YS-413 (Min)										
EL%-22 (Min)										
RA%-45 (Min)										
IMP-20.3 J at -18° C (Min)										
Hardness- 179-241 BHN										

3. GAUGE FOR INDIVIDUAL CENTRE PIVOT TOP CASTING - 5%

Signature of firms Representative

RDSO Representative
Name Designation & Stamp



S. NO.	DESCRIPTION	GAUGE DRAWING NO.	OBSERVATION			
1	Outer dia check gauge for C.P.Top					
2	Inner dia check gauge for C.P.Top					
3	Rivet hole check gauge for C.P.Top					
4	Center pin hole check gauge for C.P.Top					
5	Flange check gauge for C.P.Top					
6	Height of C.P. Top check gauge					

4. LUG ANALYSIS TEST

Break one lug from any Center Pivot Top

	M&C Heat Register	RDSO Observation
Specified Value	C.P. Top Sl. No.	C.P. TopNo.
	Heat No.	Heat No.
1. Chemical		
C - 0.32 (Max.)		
Mn- 1.85(Max.)		
Si - 1.50 (Max.)		
P - 0.04 (Max)		
S - 0.04 (Max)		
CE - 0.88 (Max.) *		
2. Grain Size ASTM 4 or finer		
3. Microstructure Normalized & Tempered (should be Non-dendrites)		

Final Observation:

1. Chemical Composition is as per STR and RDSO observed values are comparable with M & C heat clearance register.
2. Checked H.T. Register & confirmed that all the serial no. offered have been properly heat treated as per H.T. register.

3. $*[Carbon\ Equivalent\ (CE) = C + \frac{Mn+Si}{6} + \frac{Cr+Mo+V}{5} + \frac{Ni+Cu}{15}]$

Signature of firms Representative

RDSO Representative
Name Designation & Stamp