

# **Inspection Check Sheet for GFN-66 Liners**

## Inspection Check Sheet for GFN-66 Liners

**Specification:** Indian Railway Standard Specification for GFN-66 Liners: T-44-1995

Name of the firm :

Purchaser Railway :

Quantity:

Call Letter no. :

S.N	Clause/Para No.	Description of Item	Observation/Remarks ( Yes/No)
	<b>Contract details</b>		
1.		Original copy of Purchase Order.	
2.		Delivery Period available or not.	
3.		Consignee details.	
	<b>Inspection Gauges</b>		
4		Working gauges approved by RDSO is available.	
5		Approval certificate for inspection gauges issued by RDSO is available and valid.	
	<b>Quality Assurance Plan</b>		
6		Approved copy of Quality Assurance Programme (QAP) is available.	
7		Firm is following approved QAP ( To be verified from the records ).	
8	Para no. 4.2 of T-44-199	Verification of following documents. (To be verified from the record of QAP). (i) Liners manufactured by automatic screw type injection moulding machine (ii) Liners conditioned properly by immersing in boiling water ( for nearly 20 hrs )	
	<b>Measuring Instruments</b>		
9		Measuring & testing instruments/machines have valid calibration.	

10		Following instruments are required to be cross checked with test pieces, have been checked : Hardness Tester Cross breaking load machine	
11		For Cross Breaking Load <ul style="list-style-type: none"> <li>• Is the radius of support points and of loading point is 1.5 mm.</li> <li>• Is the distance between the support point is as per Appendix II of specs</li> </ul>	
	<b>Internal Test Report</b>		
12		Vendor's Internal Test Report is satisfactory.	
13		Samples used in preparation of Internal Test Report are available.	
	<b>Drawing availability</b>		
14	Para no. 3.3 of T-44-1995	RDSO's drawing of relevant liner is available.	
	<b>Raw material</b>		
15		Is raw material has been procured from sources as identified by vendor & appearing in QAP	
16	Corr. no. 4.0 of T-44-1995	Is original invoice of raw material have following details: <ul style="list-style-type: none"> <li>• Name &amp; Address of supplier</li> <li>• Name &amp; Address of purchaser</li> <li>• Date</li> <li>• Weight / Quantity</li> <li>• Certified UV stabilisation</li> </ul>	
17		Is test certificate issued by raw material supplier have test results as per specification : <ul style="list-style-type: none"> <li>(i) Melting point- 258-268 degree C</li> <li>(ii) Specific gravity- (1.38–1.43)</li> <li>(iii) Glass filler- (33±2 %)</li> </ul>	
18		Is raw material stacked separately	
19		Is opening and closing/ balance of raw material with regard to incoming and used material for day to day/monthly production verified (To be verified from record of implementation of QAP )	

20		Is manufacturer carried out all the required tests on raw material as per laid down frequency/sample size to verify the required properties. ( To be verified from record of implementation of QAP )	
<b>Finished GFN-66 liners</b>			
21	Para no. 9.0 of T-44-1995	<p>Is manufacturer carried out required tests as listed below on finished GFN-66 liners as per laid down frequency/sample size to verify the required properties before offering for inspection.</p> <ul style="list-style-type: none"> <li>(iv) Melting point- 258-268 degree C</li> <li>(v) Specific gravity- .(1.38–1.43)</li> <li>(vi) Cross breaking load ( kg )- RT-3702-480 RT-3706-390 RT-3707-720 RT-3708-960</li> <li>(vii) Glass filler- (33±2 %)</li> <li>(viii) % water absorption- 3% (min)</li> <li>(ix) Hardness Rockwell 'R' - 100 (min)</li> <li>(x) Internal cavity - Free from moulding defects such as bubbles, splash marks, burn marks, voids, surface sinking, crazing and blistering of surface, warping, laminations, cracks etc.</li> <li>(xi) Dimension – As per gauges ( To be verified from record of implementation of QAP )</li> </ul>	
22	Para no. 6.0 of T-44-1995	All the required tests as per laid down frequency/sample size to verify the required properties has been conducted by inspecting authority and result are within permissible limit as mentioned in para 21 above & recorded ( Observations to be filled in Annexure I to II )	

23	Para no. 4.3 of T-44-1995	Is marking proper	
24	Para no. 10.1 of T-44-1995	Is packing proper	
25	Para no. 13 of T-44-1995	Is rejected GFN-66 liners cut into pieces and made un-usable.	
	<b>Re test</b>		
26	Para no. 8.1 of T-44-1995	If, any of the test specimen failed in test for either melting point or specific gravity or glass filler percent, no retesting . Is lot rejected.	
27	Para no. 8.2 of T-44-1995	Is, any one test sample failed in Hardness or internal cavity or cross breaking load. If yes, is twice the number of samples drawn earlier for testing tested for that particular test in which the earlier sample failed. In retesting, is all the samples passed in that test. If no, is lot rejected.	
28	Para no. 8.3 of T-44-1995	Is, any one sample failed in dimensions. If yes, is manufacturer has reoffered the liners lot-wise after sorting out the defectives. Is reoffered lot has been inspected for all tests in terms of acceptance test clause as mentioned in para 21 above. In retesting, is all the samples passed in all tests. If no, is lot rejected.	
29	Para no. 8.4 of T-44-1995	Is the liners failed in percent water absorption. If yes, is manufacturer re-conditioned the liners and re-offered for inspection. Is reoffered lot has been inspected for all tests in terms of acceptance test clause as mentioned in para 21 above. In retesting, is all the samples passed in all tests.	

		If no, is lot rejected.	
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Inspecting Authority

Name:

Designation:

Signature:

Stamp:

### Check sheet about receipt of material by consignee

P.O No. –

Consignee –

Delivery Period -

S. No.	Item	Observation/Remarks (Yes/No)
1.	Whether material has been received within D.P. ?	
2.	Whether material is accompanied with Despatch Memo/Inspection Certificate ?	
3.	Whether no. of packets/bags are as per Despatch Memo/ Inspection Certificate ?	
4.	Whether packet/bags are not torn out and are in proper condition ?	
5.	Whether packing slip along with hologram is available with each packet/bag ?	
6.	Whether hologram details are matching with details mentioned in Despatch Memo/Inspection certificate ?	
7.	Whether quantity is as per Despatch Memo/Inspection Certificate ?	
8.	Whether condition of material is satisfactory ?	
9.	Whether Despatch Memo/inspection Certificate is duly signed and stamped by inspecting agency ?	
10.	Whether Despatch Memo/ inspection Certificate is valid ?	
11.	Whether marking on material is matching with marking mentioned in Despatch Memo/Inspection Certificate ?	
12.	Whether unloading of material done properly ?	
13.	Whether material stacked properly ?	

Authority receiving material

Name:

Designation:

Signature:

Stamp: