



QM-C-7.1/Coupler/0008/N
Inspection Plan(Check Sheet)

Item : Clevis for modified transition Screw Couplings
Specn. : AARM-201 Grade-C
Amd. :
Drg. No. & Alt. : SKDL-2496, Alt.7

1	NAME OF MANUFACTURE	
2	DATE OF OFFER	
3	RDSO FILE NO.	
4	DESCRIPTION OF MATERIAL	
5	DRAWING & ALT. NO.	
6	SPECIFICATION & GRADE	
7	PURCHASE ORDER NO.	
8	TOTAL QUANTITY ORDERED	
9	QUANTITY EARLIER PASSED	
10	QUANTITY NOW OFFERED	
11	CONSIGNEE	
12	DELIVERY PERIOD	

1	DATE OF INSPECTION	
2	QTY. ACCEPTED	
3	QTY. REJECTED	
4	BALANCE ORDER	

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LAB: - Test report of Chemical & Physical properties of each lot (Copy Attached)
Specification AARM-201, Grade-C

Visual: - 5%

1	2	3	4	5	6	7	8	9	10

DIMENSION CHECK: 5% Checked by gauge (All Dimension in mm)

Sample No.	TOTAL HEIGHT FROM HOLE CENTRE (GO GAUGE)	THICKNESS GAUGE (GO & NO GO)	PINHOLE GAUGE (GO)	PULLING LUG (GO)
1				
2				
3				
4				
5				

MARKING: - Manufacturer initial, year of manufacture, as cast as per drawing.

REMARKS:-

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Metallurgical Report of Modified Clevis, Specification AARM-201, Grade-C

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

Heat No.									Annealing Lug Test
SL No.									
									A.Heat No.
Qty. Cast									B.Sample No.
Qty. Passed Earlier									Break one lug or 1 % which ever is higher and conduct following Test in Spectro
Qty. Offered									
Qty. balance									
% age specified									As per LUG Report.
C:0.32%									C:
Mn:1.85 max									Mn:
Si:1.50% max									Si:
S: 0.040% max									S:
P:0.040% max									P:

B. Mechanical Properties (As per M & C Register)

Specified (Min)									1.Heat treatment:- Normalising 2. Hardness (BHN) :-179-241 3.Confirm that all material bear manufacturer's initial as per drg. 4.Checked H. T. register & confirm that all the material offered have been properly heat treated as per register
YS:42.18 kg/mm ²									
UTS:63.2 kg/mm ²									
EL: min 22									
RA: min 45									
Hardness:179- 241									
Heat Clear Date									
Impact Test at -40°C, 27.1 Joule									

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PROOF AND DESTRUCTION LOAD OF CLEVIS

Description	SL.No.	Heat No.	Type of Load	Specified	Actual	Deflection	Permanent Set	Remarks
Clevis (BG)			Proof Load	50t				
			Destruction Load	100t				
Clevis Mod.			Proof Load	75 t				

Accepted/Rejected

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