



QM-C-7.1/BOGIE LWLH25/0001/D
INSPECTION CHECK SHEET FOR LWLH25 FRICTION WEDGE

- 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

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) Detail of Friction Wedge castings offered

No. of Wedge Casting Offered	Heat No.	Date of Cast	Date of heat clearance by RDSO	Date of heat Treatment

B) Visual/Physical Examination

	Specified	Observations
Surface defect	Inclusion, sand fusion, blow holes, folds, cracks, misruns, surface imperfections, unfused chaplets, porosity.	
Surface finish	Surface condition check by SCRATA Comparators.	
Marking Details	As per drawing WD - 13012 - S/06	

2. Chemical & Mechanical Properties Test

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

Element\ Heat No.										
C - 1.05 - 1.35										
Mn - 11.0 - 14.0										
Si - 1.0 (Max.)										
P - 0.08 (Max)										
S - 0.025 (Max)										

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B) MECHANICAL PROPERTIES (AS PER THE HEAT REGISTER)

Specified Value (N/mm ² /mpa)										
Hardness - 229 BHN (Max.)										
Angle of bend - 150° (Min)										
Date of casting										
Date of heat clearance by RDSO										

3. LUG ANALYSIS Test

Break one lug from any Friction Wedge

	M&C Test	RDSO Observation
Specified Value	Heat No.	Heat No.
C - 1.05 - 1.35		
Mn - 11.0 - 14.0		
Si - 1.0 (Max.)		
P - 0.08 (Max)		
S - 0.025 (Max)		

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.

4. GAUGE FOR INDIVIDUAL CASTING - 5%

S. NO.	DESCRIPTION	GAUGE DRAWING NO.	OBSERVATION				
1	Squareness checking gauge						
2	Slope and location check gauge						
3	Wedge height						
4	Location of point dimension 90 mm check gauge						
5	Wing profile & R - 1500 width over wing & width check gauge						

Signature of firms Representative

RDSO Representative
Name Designation & Stamp