

Annexure - I

**PROFORMA FOR CHECKING OF REQUIRED DOCUMENTS AND OTHER ITEMS
DURING INSPECTION OF GLUED INSULATED RAIL JOINTS (GIRJ)**

Name of the firm:

Purchaser Railway:

Consignee:

Drawing No.:

Sl. No. of GIRJ: From.....to.....

Date:

P.O. No.:

Lot No.:

Qty.:

S. No.	Clause No. of Manual for Glued Insulated Rail Joints-1998	Details of item (Manual for Glued Insulated Rail Joints-1998) with ACS No. 5 dated 28.08.2012	Observation/Remarks of Inspecting authority (Score out whichever not applicable)
1.	2.1.4	New rails used for fabrication of Glued Insulated Rail joints have been issued by consignee Zonal Railway? (Rail issue certificate of consignee zonal Railway be verified)	Yes/No
2.	Annexure - C C.1 (iii)	Special fish plates manufactured by current approved sources duly inspected and stamped by nominated inspecting agency have been used in fabrication of Glued insulated Rail joints? (To be verified from fish plate inspection certificate and quantity of Glued Insulated Rail joint inspected against this certificate must be endorsed on it with date)	Yes/No
3.	Annexure - C C.2 (iii)	HTS HEX Bolts and Nuts manufactured by current approved sources duly inspected by nominated inspecting agency have been used in fabrication of Glued Insulated Rail Joints? (To be verified from HTS HEX Bolts and Nuts inspection certificate and quantity of Glued Insulated Rail Joint inspected against this certificate must be endorsed on it with date)	Yes/No
4.	Annexure – C C.3	Punched washers as per IS: 2062 have been used in fabrication of Glued insulated Rail joints.	Yes/No
5.	Annexure - C C.5.1	Glass- cloth carrier reinforcement manufactured by current approved sources and conforming to specifications laid down in the manual has been used in making of insulating components viz. bushes/sleeves, liners and end-posts of glued Insulated Rail joints? (To be verified from certificate issued by approved source of Glass- cloth carrier reinforcement and quantity of Glued Insulated Rail joint inspected against	Yes/No

		this certificate must be endorsed on it with date)	
6	Annexure - C C.5.1 .2	Glue (for making insulating components) manufactured by current approved sources and conforming to specifications laid down in the manual has been used in making of insulating components of Glued Insulated Rail joints? (To be verified from certificate issued by approved source of Glass- cloth carrier reinforcement and quantity of Glued Insulated Rail joint inspected against this certificate must be endorsed on it with date)	Yes/No
7	Annexure - C C.6	Glue (for fabrication of GIRJ) manufactured by current approved sources and conforming to specifications laid down in the manual has been used in fabrication of Glued Insulated Rail joints? (To be verified from certificate issued by approved source of Glue and quantity of Glued Insulated Rail joint inspected must be endorsed on it with date)	Yes/No
8	2.4.2	Colour coding at the ends of all Glued Insulated Rail joints done?	Yes/No
9	3.7	Necessary follow up action and marking as per para 3.7 of Manual for Glued Insulated Rail Joints-(1998) has been done on pull-out tested joints?	Yes/No
10	3.8	Necessary marking on each joint of rejected lot as per Para 3.8 of Manual for Glued Insulated Rail Joints-(1998) has been done?	Yes/No
11	3.9	Records in respect of fabrication of Glued insulated Rail joints are maintained?	Yes/No

Firm's Representative

Inspecting Authority

Namr:

Name:

Designation:

Designation:

Signature:

Signature:

Stamp:

Stamp:

Note: All pages of check sheets be prepared in triplicate. (One copy each to RDSO, manufacture and inspecting agency)

Annexure-II

PROFORMA FOR DIMENSIONAL CHECK AND INSULATION RESISTANCE TEST IN DRY CONDITION OF GLUED INSULATED RAIL JOINTS

Name of the firm:

Dated:

Purchaser Railway:

P.O. No.:

Consignee:

Lot No.:

Drawing No.:

Qty.:

SI.No. of GIRJ: From.....to.....

SN	Joint no.	Date of Fabrication	Dimensional check		Insulation resistance in dry condition (Shall not be less than 25 Megaohm)								
			Vertical Aligment (on 1mt straight edge) (Permissible tolerance +1/-0 mm)	Lateral aligment (on 1mt. Straight edge) (Permissible tolerance Not more than ± 0.5 mm)	Date of Testing	Rail to Rail	Rail to fishplate	Rail to Bolts					
								1	2	3	4	5	6
1													
2													
3													
4													
5													
6													
7													
8													
9													
10													

Marking on Glued Insulated Rail Joints (manufacture):

Firm's Representative

Inspecting Authority

Name:

Name:

Designation:

Designation:

Signature:

Signature:

Stamp:

Stamp:

Annexure-III**PROFORMA FOR PULL-OUT TEST OF GLUED INSULATED RAIL JOINTS**

Name of the firm:
 Purchaser Railway:
 Consignee:
 Drawing No.:
 Specified Pu;;-Out Load (Min.):.....(T)

Date:
 P.O. No.:
 Lot No.:
 Qty.:
 Sl. No. of GIRJ: from..... to.....

SN	Joint no.	Date of fabrication	Date of Testing	Pull-out test	
				Actual load obtained (in Tonnes)	Observation/Remarks
1					
2					
3					
4					

Marking on Glued Insulated Rail Joints (manufacture):**Firm's Representative****Inspecting Authority**

Name:
 Designation:
 Signature:
 Stamp:

Name:
 Designation:
 Signature:
 Stamp:

Acceptance value: The test joint shall be considered acceptable if there is no indication of separation between end posts and rail end (s) visible to the naked eye, at the pull out load values given in the table below:

S. No.	Rail Section	Minimum pull out load in Tonnes	
		G3 (L) type joint	G3 (S) type joint
1	75R	110	70
2	90R	125	85
3	52kg	150	100
4	60 Kg (UIC)	170	110

Note: In- house calibration of pressure gauge used in pull-out strength test unit should be ensured before pull-out test of Glued joints by 200t capacity proving duly calibrated by NPL or NCCBM

Annexure-IV

PROFORMA FOR INSULATION RESISTANCE TEST IN WET CONDITION OF GLUED INSULATED RAIL JOINTS

Name of the firm:
Purchaser Railway:
Consignee:
Drawing No.:
Sl. No. of GIRJ: from..... to.....

Date:
P.O. No.:
Lot No.:
Qty.:

SN	Joint no.	Date and time of Immersion in water	Date and time of testing for wet insulation	Insulation resistance in wet condition (shall not be less than 03 Kilo-ohm)								Remarks
				Rail to Rail	Rail to fishplate	Rail to Bolts						
						1	2	3	4	5	6	
1												
2												

Marking on Glued Insulated Rail Joints (manufacture):

Firm's Representative

Name:
Designation:
Signature:
Stamp:

Inspecting Authority

Name:
Designation:
Signature:
Stamp: