



QM-C-7.1/AB/0001/H

Inspection Plan(Check Sheet)

Item: Hose Coupling Assembly for Brake Pipe & Feed Pipe
Specn. : 02-ARB-02, Appendix-F
Amd.: 3 of April 2010
Drg. No. & Alt.: SK-73547, Alt.12 & WD-81027-S-01, Alt. 10

1. Firm's Name
2. Date (Period) of inspection
3. Contracts details:
 - a) Contract No.
 - b) Order placing authority
 - c) Specification no.
(as mentioned in the contract)
 - d) Drawing No.
(as mentioned in the contract)
4. Quantity on order
5. Quantity offered for inspection
6. Consignee

Signature of firms Representative

RDSO Representative

Name Designation & Stamp



7. Acceptance criteria

Item ready

Yes / No

Visual Check :

Marking

OK/Not OK Yes / No

Opening plugged with PVC plugs / End caps

Yes / No

Visual Defects

Yes / No

Performance Tests & Dimensional Check :

Sl. No	Test Description	Mode	Sample Size	Specified Parameters	Observed Value										Remarks						
					1	2	3	4	5	6	7	8	9	10							
					11	12	13	14	15	16	17	18	19	20							
7.2.1	Dimensional Checks	Gauge & Instruments	2%																		
a)	Length (mm)	Scale		660±6 790±6																	
b)	Outer Dia	Vernier		53+1-.6																	Hose Pipe
	Inner Dia	Vernier		35+1.5-0.1																	
7.2.2	Tensile Strength	Tensile testing mc.	1 out of 1000			1	2		3		4		5								
	Lining			84.4kg/cm ²																	
	Cover			84.4kg/cm ²																	
7.2.3	Elongation																				
	Lining			250%																	
	Cover			300%																	
7.2.4	Adhesion test	Unbinding device & weight	1out of 1000	Unbinding																	
a)	Between lining & Braids (with a load of 7.3 kg)		101.6mm Max. in 4-minutes																		
b)	Between Braids (9.1kg)																				
c)	Between cover & braids (7.3 kg)																				

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Sl. No.	Test Description	Mode	Sample Size	Specified Parameters	Observed Value					Remarks
					1	2	3	4	5	
7.2.5 a)	Oil immersion Test in ASTM-3 for 70 hrs. at 100C	Oven & weighing balance	1 out of 1000	% age of volume increase						
	Lining			100% max						
	Cover			100% max						
7.2.6	In reference Fuel B at Room Temp for 70 hrs.	Weighing balance	1 out of 1000	% age of volume increase						
a)	Lining			80% max						
b)	Cover			80% max						
7.2.7	Coupling Pull of test	Coupling Pull of test Fixture	1 in 10000	On 2800 l/b						
7.2.8	Twist test at 140 Psi hydrostatic pressure	Device	1 out of 1000	As per para 4.8 AAR-M-601						
7.2.9	Hydrostatic pressure	Testing device	1 out of 1000	As per para 407						
a)	Increase in circumference at 14.08 kg/cm			12.7 (max)						
b)	Leakage at 35.2 kg/cm			No leakage or other defects						
c)	Bursting test (pressure)			70.4 kg/cm (1000 psi min.)						
7.2.10	Flexibility test	Testing device	1 out of 1000	Draw graph for room temp test as per para 4.10.4 of specn						
7.2.11	Leakage test of complete hose assy.	Testing Rig	10%	No leakage at 10 kg/cm						
7.2.12	Ozone test	Ozone chamber	1 out of 1000	No crake after 50 hrs at 100 pphm & 20% stretch						
7.2.13	Cold test Aging	Cold chamber	1 out of 10000							
a)	Tube			No crake after 24 hrs ageing at -40 F						
b)	Cover									
7.2.14	Cold chamber leakage test at 10 kg/cm ² & -40 °F for 48 hrs & further 2 hrs	Cold chamber & test fixture	1 out of 10000	No leakage for 2 hrs after completion of 48 hrs						

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8. Hose Clamp: Hose clamp confirming to, Stainless Steel 10A IS:304:

Test certificate issued by NTH Laboratory or from reputed Lab approved by Zonal Director of RDSO
Enclosed. Details are verified and as per the test report, results are conforming to the Specifications.

Signature of firms Representative

RDSO Representative

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