



**QM-C-7.1/AB/0002**

**Inspection Plan(Check Sheet)**

**Item:** Brake slack adjuster type IRSA-750 for freight stock & spares  
**Specn. :** 19-ABR-07  
**Amd.:** 2 of Mar'08  
**Drg. No. & Alt.:** WD-93061-S-01 Alt-01

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01. FIRM'S NAME
02. DESCRIPTION OF THE MATERIAL
03. DRG. NO
04. SPECIFICATION NO
05. a) PURCHASE ORDER NO  
b) RDSO CASE NO.
06. FIRM'S OFFERED LETTER NO & DATE
07. QUANTITY EARLIAR PASSED
08. QUANTITY NOW OFFERED
09. QUANTITY CONSUMED IN TESTING
10. QUANTITY ACCEPTED
11. QUANTITY REJECTED
12. DATE OF INSPECTION AND TESTING
13. D.P
14. SERIAL NO.OF SAB OFFERED
15. DATE OF MANUFATURING

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## TEST RESULT

[OFFERED LOT SIZE 200 Nos SAMPLE SIZE -2 Nos per lot where not specified]

<b>A.VISUAL INSPECTION</b>	1	2	3	4	5	6	7	8	9	10
1. Surface (5%)										
2. Painting (5%)										
<b>B. DIMENSIONAL INSPECTION</b>										
1. IRSA -750 Length -774 +2.0 / -0.0										
2. A-1Dimention 244/249										
3. Length 2565										
<b>C.FUNCTIONAL TEST</b>										
1. Pay- out -30 mm max 2. Take – up – 100 mm max 3. Loss of Force Sample 2 % or 2 Nos min										

Last test done / cum. Production

3. Tension test : one in six months  
4. Vibration test : one in six months

### D. DIMENSIONAL CHECK WITH GAUGE :

- |                       |                          |                  |
|-----------------------|--------------------------|------------------|
| 01. Rubber gasket     | 08. Barrel Head.         | 14. Barrel       |
| 02. Traction sleeve   | 09. Adjuster tube socket | 15. Clutch ring  |
| 03. Actuating sleeve  | 10. Spring sleeve        | 16. Leader nut   |
| 04. Casting           | 11. Spindle sleeve       | 17. Dust bushing |
| 05. Safety Collar     | 12. Control rod head     | 18. Guide pin    |
| 06. Adjuster ear      | 13. Ear bushing          | 19. Guide bush   |
| 07. Leader nut flange |                          |                  |

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**E. APPLICATION CHECK THROUGH ROLLING OF NUTS:**

- i) Adjuster Spindle
- ii) Adjuster Nut
- iii) Leader Nut

**F. HARDNESS TEST:**

	<u>Specified (BHN)</u>	<u>Actual Hardness (BHN)</u>
i) Clutch ring	250-290	
ii) Leader nut flange	250-290	
iii) Guide Bush	250-290	

**G. INSPECTION OF OTHER COMPONENTS AS:**

	<b>Specified IS</b>	<b>Attributes</b>	<b>Take -Up</b>	<b>Pay -Out</b>	<b>Clutch</b>	<b>Barrel</b>	<b>Remarks</b>
Springs (4 types)	IS 4454	a) Chemical					
		b) Load Test					
			<u>45x1.75 N</u>	<u>40x2.5H</u>	<u>45x2.5H</u>	<u>85x4H</u>	
2. Circlips (4 types)	IS 3075	a) Chemical					
		b) Bend					
		c) Permanent set					
3. Spring Dowel sleeve	IS 5988	a) Chemical					
		b) Resilience test					
		c) Recovery					

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## H. HEAT TREATMENT OF COMPONENTS:

Confirm whether the following components has been heat treated and conforms ton class IV and Class V material to 1875

	HT	CHEMICAL (Test certificate no.)
1. Traction Sleeve		
2. Control Rod Head		
3. Adjuster Ear		
4. Leader Nut Flange		
5. Clutch Ring		

## I. CONFIRM WHETHER ADJUSTER SPINDLE MANUFACTURED USING IS :2062

### SPARE PARTS TO BE SUPPLIED WITH COMPLETE UNIT:

1. Control rod with luck Nut M.T. Lock washer & Control Rod Head.
2. Adjuster Spindle with Safety Coller & Spring Dowel Sleeve.

### Adjuster Spindle-750

1. LAB .Test Reports Chemical, Physical, test of each lot (attach copy)  
Spec. IS: 8500 Gr.Fe540

1      2      3      4      5

2. Visual:


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3. Dimension Check : Checked by gauge where indicated.

<b>Adjuster Spindle</b>					
SMPL NO	TOTAL LENGTH 1723-1725	TRIPLE TRAPEZOIDAL THREAD R.H LEAD -27 MM x 9P *	1.2" BSP PARALLELED THREAD *	DRILL 1-Φ5.0 AT14.90/15.1 DISTANCE *	SHANK DIA 27.92/28.00 *
1.					
2.					
3.					
4.					
5.					

4. Shadowgraph (30 times magnification)

1	2	3	4	5

**Dog Pin IRSA 750**

1. LAB .Test Reports Chemical of each lot procure (attach copy)  
Spec. IS: 1875 CI IV and IS 2004

2. Visual:

1	2	3	4	5

3. Dimension Check

SMPL NO:	THICKNESS 8 mm	OD 5.04- 5.08	HEAD 6.4 SQ
1.			
2.			
3.			
4.			
5.			

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4. Hardness 220-260 BHN

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**Take-up, Pay –Out, Clutch & Barrel Spring IRSA 750**

(Inspect any one at every purchase Inspection)

AB Test Report of chemical each lot (attach copy)

Spec IS: 4454 Pt. II

1. Visual:            1        2        3        4        5


2. Dimension Check

DESCRIPTION	EFFECTIVE COILS (R.H)	FREE HEIGHT	CHARACTERISTICS (ESTIMATED)		SOLID HEIGHT (ESTIMATED)	O/D	WIRE DIA
			LOAD (KG)	HEIGHT (MM)			
Take up spring	1.75	56	10 25	43 24	16	66.5/67.5	4.25
Pay Out Spring	8.5	149	70 110	101 73	68	59.0/60.5	6.5
Clutch Spring	1.5	43	190 380	40 37	31	72.74	12
Barrel Spring	25.5	62.5	175 350	463 301	290	86.5/88.5	10.5
SMPL. NO.							
1.							
2.							
3.							
4.							
5.							

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### Control Rod IRSA 750

1. LAB Test Report of each lot (attach copy)

Spec. IS :1875 CI II

2. Visual:

1	2	3	4	5

3. Dimension Check: Checked by gauge where \* indicated

SMPL NO:	TOTAL LENGTH	G 7/8A (PARREL) *	THREAD LENGTH 160	1-21 DIA DRILL AT 22 DISTANCE *	SHANK DIA 32
1.					
2.					
3.					
4.					
5.					

4. Straightness Checking\*

1	2	3	4	5

### Circlip -45x 1.75 N, 40 x2.5H, 45x 2.5H & 85x4H IRSA 750

(Inspect any one at every purchase inspection)

1. LAB Test Report of each lot (attach copy) :

Spec. IS: 3075 Pt I & Pt II

2. Visual:

1	2	3	4	5

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3. Dimension Check

DESCRIPTION	DIAMETER	THICKNESS	BEND & FRACTURE TEST
45x1.75 N	O/D 48.5 +0.9 - 0.39	1.75 +0.05 -	
40x 2.5H	I/D 36.5 +0.39 - 0.78	2.51 +0.05 -	
45x 2.5 H	I/D 41.5 +0.39 - 0.78	2.5 +0.05 -	
85x 4H	O/D 90.5 +1.3 - 0.54	4.0 +0.08 -	
SMPL.No			
1.			
2.			
3.			
4.			
5.			

4. Spiral Flatness Test:

5. Hardness :47-54 RC

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6. Bend and Fracture test:

7. Conical Deformation

8. Permanent set:

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