



QM-C-7.1/AB/0006

Inspection Plan(Check Sheet)

Item: Slack Adjuster and Spares – for coaching stock
Specn. : 07-ABR-1992
Amd.: 4 of July 2000
Drg. No. & Alt.: SK-83063, Alt. Nil & SK-85062 Alt-05

1. Firm's name :
2. Description of Material :
3. Drawing No. :
4. Specification No. :
- 5 a) Purchase Order No. :
- b) RDSO Case No. :
6. Firm's Offered Letter No. & Date :
7. Quantity Earlier Passed :
8. Quantity Now Offered :
9. 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 Manufacturing :

Signature of Firm's Representative

Signature of RDSO



TEST RESULT OF SLACK ADJUSTER

[Offered Lot Size – 200 Nos. SAMPLE SIZE – 2 Nos. Per Lot where Not Specified]

A. VISUAL INSPECTION	1	2	3	4	5	6	7	8	9	10
1. Surface (5%)										
2. Painting (5%)										
B. DIMENSIONAL INSPECTION										
1. IRSA – 450 Length 630 ⁺² -0										
2. A-1 Dimension 89/94										
3. Length 1665										
C. FUNCTIONAL TEST										
1. Pay out – 30 mm max.										
2. Take up 100mm max.										
3. Loss of Force Sample 2% or 2 Nos. min.										

Last test done/cum Production.

3. Tension Test 2000 Nos. Or
4. Vibration Test one in six month

D. DIMENSIONAL CHECK WITH GAUGE :

01	Rubber Gasket	08	Barrel Head	14	Barrel Head
02	Traction Sleeve	09	Adjuster tube socket	15	Clutch ring
03	Actuating sleeve	10	Spring sleeve	16	Leader nut
04	Casing	11	Spindle Sleeve	17	Dust bushing
05	Safety collar	12	Control rod head	18	Guide pin
06	Adjuster ear	13	Ear bushing	19	Gulde Bush
07	Leader nut flange				

E. APPLICATION CHECK THROUGH ROLLING OF NUTS:

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

F. HARDNESS TEST :

		Specified (BHN)	Actual Hardness (BHN)
i.	Clutch nng	250-290	
ii	Leader nut flange	250-290	
iii.	Guide bush	220-260	

Signature of Firm's Representative

Signature of RDSO



G. INSPECTION OF OTHER COMPONENTS AS:

	Specified IS	Attributes	Take-up	Pay-out	Clutch	Barrel	Remarks
i) Springs (4 type)	IS 4454	a) Chemical					
		b) Load Test					
ii) Circlips (4 types)	IS 3075	a) Chemical	45x1.75 N	40x2.5H	45x2.5H	85x4H	
		b) Bend					
		c) Coniocal deformation					
		d) Permanent Set					
iii) Spring Dowel Sleeve	IS 5988	a) Chemical					
		b) Resilience Test					
		c) Recovery Test					

1. HEAT TREATMENT OF COMPONENTS :

Confirm whether the following components have been heat treated and conforms to class IV and class V material to 1875.

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

1. CONFIRM WHETHER ADJUSTER SPINDLE MANUFACTURED USING IS: 8500

SPARE PARTS TO BE SUPPLIED WITH COMPLETE UNIT:

1. Control rod wit Lock Nut M.T. Lock Washer & Control Road Head.
1. Adjuster Spindle with Safety Coller & Spring Dowel Sleeve.

Signature of Firm's Representative

Signature of RDSO



ADJUSTER SPINDLE IRSA-450

1. LAB. Test Report chemical ,physical, test of each lot (attach copy)
 Spec. IS: 8500

2. VISUAL

1	2	3	4	5

3. Dimension Check Checked by gauge where Indicated:

ADJUSTER SPINDLE					
SMP. NO.	Total length 1274 +1	Triple Trapezoidal Thread RH lead 27 mm X	1.2" BSP (parallel) Thread	Drill hole Ø 50 at 14.90/15.1 Distance	Shank dia 27.92/28
1					
2					
3					
4					
5					

4. Shadowgraph (30 times magnification)

1	2	3	4	5

DOG PIN IRSA 450 & 600

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

2. VISUAL

1	2	3	4	5

3. DIMENSION CHECK

SMPL NO	THICKNESS 8mm	O.D.- 5.04 to 5.08	HEAD 6.4 SQ.

4. HARDNESS 220-260 BHN

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Signature of Firm's Representative

Signature of RDSO



TAKE-UP, PAY-OUT, CLUTCH & BARREL SPRING IRSA-450

(Inspect any one at every purchase inspection)

1. **LAB.** Test Report chemical each lot (attach copy)
Spec. IS: 4454 Pt.II

1	2	3	4	5

2. **VISUAL**

3. **Dimension Check:**

DESCRIPTION	EFFECTIVE (Coils RH)	FREE HEIGHT	CHARACTERISTICS (ESTIMATED)		SOLID HEIGHT (ESTIMATED)	O.D.	WIRE DIA
			LOAD (KG)	HEIGHT (MM)			
Take up Spring	1.75	56	10	43	16	66.5/67.5	4.25
			25	24			
Pay out Spring	8.5	149	70	101	68	59.0/60.5	6.5
			110	73			
Clutch Spring	1.5	43	190	40	31	72/74	12
			380	37			
Barrel Spring	17.5	425	100	361	199.5	86.5/88.5	10.5
			150	329			
SMPL NO.							
1							
2							
3							
4							
5							

CONTROL ROD IRSA 450

1. **LAB** Test Report of each lot (attach copy)
Spec.: IS: 1875 Cl. II and IS: 2004.

1	2	3	4	5

2. **VISUAL**

3. **DIMENSION CHECK:** Checked by gauge where* Indicated:

SMPL No.	TOTAL LENGTH 688+1	G-7/8A (PARREL) *	THREAD LEGNTH 160	1-21 DIA DRILL AT 22 DISTANCE*	SHANK DLA 32
1					
2					
3					
4					

1	2	3	4	5

4. **STRAIGHT CHECKING :**

Signature of Firm's Representative

Signature of RDSO



Circlip-45x1, 75N, 40x2.5H, 45x2.5H & 85x4 H IRSA 450&600
(inspect any one at every purchase Inspection)

1. **LAB.** Test Report of each lot (attach copy)
 Spec. IS:30754 Pt.I&II

2. **VISUAL**

1	2	3	4	5

3. **Dimension Check:**

DESCRIPTION	DIAMETER	THICKNESS	BEND & FRACTURE TEST
45x1.75 N	O/D 48.5 + 09 -0.39	175+0.05	
40x2.5 H	I/D 36.5+0.39 -0.78	2.5+0.05	
45 x 2.5 H	I/D 415 + 0.39 -0.78	2.5+0.05	
85x4 H	O/D 90.5+1.3 -0.54	4+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 TEST:**

8. **PERMANENT SET:**

Signature of Firm's Representative

Signature of RDSO