



QM-C-7.1/AB/0007
Inspection Plan(Check Sheet)

Item : 'L' type non-asbestos Composition Brake Blocks of container flat Wagons for 840 mm dia wheel
Specn. : WD-13-ABR-2006
Amd. : 1 of May 07
Drg. No. & Alt. : CONTR.9404-S/11, Alt.6

1. Firm's Name:

2. Date (period) of Inspection :

3. Contract Details:

- a. Contract no. and date.
- b. Order placing authority.
- c. Specification no.
(As mentioned in contract)
- d. Drawing no. (as mentioned in contract)
2. Quantity on order
3. Quantity offered for inspection
4. Date of offering for inspection.
5. Consignee
6. Delivery Period

These check sheets do not detail all the dimensions or technical requirements of respective 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.

Quality Control Incharge of M/s

Inspecting official of RDSO



SUMMARY OF RESULT
Lot size 2000 nos.

(A) Periodical / Intermediate check :

S.No.	Name of Test	Specified	Last test done	Next test due
1.	Dynamo meter	As per the QAP approved by RDSO & Specn. No. WD-13-ABR-2006 (Latest)		

(B) Routine Check :

* (Routine check shall be conducted after ensuring the Periodical / Intermediate check is not over due)

(I) Ensure clause 4.2.2 (i), (ii), (iii) & 4.2.2.1

Sr No.	Parameters	Specified Value	Observation	
			Max.	Min.
1	Visual Check	No. surface cracks		
2	Dimensional check	As per drawing		
3	Physical Properties			
	1. Compression modulus	As per Mfg. Approved QAP		
	2. Cross Braking Strength	As per Mfg. Approved QAP		
	3. Acetone extract	As per Mfg. Approved QAP		
	4. Ash Content/Loss on ignition	As per Mfg. Approved QAP		
	5. Hardness	As per Mfg. Approved QAP		
	6. Density	As per Mfg. Approved QAP		
	7. Pull off Strength	As per Mfg. Approved QAP		



Item-L Type CBB for Container Flat wagon					Sample Size :1%					Inspection Date				
SL. NO.	Criteria Specified	Nominal Dimension	Measuring Device	Gauge Ref	1	2	3	4	5	6	7	8	9	10
1	Back plate radius	R 570±13	Radius gauge											
2	Face radius	R 425 Min	Radius gauge											
3	Block length	300 Min	Snap gauge											
4	Block width	80 Min-85 Max	Snap gauge											
5	Block thickness	58 +2/-0	Snap gauge											
6	Taper	01:20	Taper gauge											
7	Width of key hole in clip	25±3	Gauge											
8	Height of key hole	22 +1/-2	Snap gauge											
9	Clip plate thickness	4.0±0.2	Snap gauge/Ver nier											
10	Lug height	10	Special gauge											

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Item-L Type CBB for Container Flat wagon					Sample Size :1.0%					Inspection Date				
SL. NO.	Criteria Specified	Nominal Dimension	Measuring Device	Gauge Ref	1	2	3	4	5	6	7	8	9	10
11	Clip length at bottom	57.0 max	Plug gauge											
12	Clip length at top	38.0 min	Radius gauge											
13	Lug width	36.0 +1/-2	Snap gauge											
14	Distance between lugs	265 +2/-0	Snap gauge											
15	Width of clip	76±2	Snap gauge											
16	Wear limit	10	Vernier Caliper											
17	Middle stop length	10 min	Vernier Caliper											
18	Marking on brake block	As per Spec	Visual											
19	Weight of Brake block (Kg)	As per firm approved QAP/Drg.	Weighing Balance											

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Item-L Type CBB for Container Flat wagon				Qty Checked						Inspection Call No. CBB			
				Sample Size:						Inspection Date			
SL. NO.	Test	Unit	Value (As per approved QAP)	1	2	3	4	5	6	7	8	9	10
1	Density	gm/cc											
2	Hardness	HRX											
3	Compression Modulus	N/mm ²											
4	Cross breaking strength	Kg/cm ²											
5	Back plate pull of strength	Ton											
6	Ash content	%											
7	Acetone Extract	%											

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