



QM-C-7.1/AB/0013
Inspection Plan(Check Sheet)

Item: Non-asbestos based k-type high friction composite brake blocks for EMU stock
Specn. : C 9508 (Rev.3 of May'2009)
Amd.:
Drg. No. & Alt.: SK-80029, Alt.04

1. Date (Period) of Inspection :
2. 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)
3. Quantity on order :
4. Quantity offered for inspection :
5. Date of offering for inspection :
6. Consignee :
7. Delivery Period :

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Signature of RDSO



SUMMARY OF RESULT

Lot Size 2000 nos.

(A) Periodical / Intermediate check :

S.NO.	Name of Test	Specified	Last test done	Next text due
1.	Dynamo meter (After manufacture of every 50000 no. of brake blocks)	As per Spec.No. C-9508 (Rev.3)		

(B) Routine check:

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

Ensure clause 2.5, 2.7 & 4 of specification for inspection

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	As per Mfg. Approved QAP		
	5. Hardness	As per Mfg. Approved QAP		
	6. Density	As per Mfg. Approved QAP		
	7. Shear Strength	As per Mfg. Approved QAP		
	8. Bending test	As per Mfg. Approved QAP		

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Govt. of India
Ministry of Railways
Research Designs & Standards Organisation
Manak Nagar, Lucknow-226 012

BATCH	Qty. Checked :	
	Sample Size :	

Sl. No.	Criteria Specified	Nominal Dimn.	Measuring Device	Gauge Ref.	1	2	3	4	5	6	7	8	9	10	11
1.	DISTANCE BETWEEN LUGS	240+4/-0	Special Gauge												
2.	CLIP LENGTH	52+/-1	Snap Gauge												
3.	LUG HEIGHT	8+2/-0	Vernier												
4.	FRICTION MATERIAL RADIUS	R476 min. R482 nom R508 max.	Radius Gauge												
5.	BACK PLATE RADIUS	R 550 min. R610 max	Radius Gauge												
6.	BRAKE BLOCK LENGTH	270+/-2	Snap Gauge												
7.	LUG WIDTH	28+2/-0	Snap Gauge												
8.	LENGTH	230 mm min.	Special Gauge												
9.	KEY HOLE HIGHT	20+/-1													

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Sl. No.	Criteria Specified	Nominal Dimn.	Measuring Device	Gauge Ref.	1	2	3	4	5	6	7	8	9	10	11
10.	KEY HOLE WIDTH IN. CLIP	25.4+1/-0	Plug Gauge												
11.	BRAKE BLOCK WIDTH	76+/-2	Snap Gauge												
12.	BRAKE BLOCK THICKNESS	46+3/-0	Snap Gauge												
13.*	BP THICKNESS	4+/-0.25	Vernier												
14.	CLIP PLATE THICKNESS	6+0/-2	Vernier												
15.	INCLINATION	1:20 Inclination	Bevel Protector												
16.	CLIP DIMENSION	31+/-1	Snap Gauge												
17.**	RADIUS/ Chamfer	R-15.5+0/-0.5 16x17 mm	Radius Gauge												
18.**	RELIEF	3	Vernier												
19.	MARKINGS ON BRAKE BLOCK	Marking as per RDSO Specs No C-9508	Visual												

* This may be measured only on destructive test brake block.

** This is manufacturer option either radius or chamfer of 16x17

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Qty. Checked :	
Sample Size :	

Sl. No.	TEST	UNIT (as per approved QAP)	Specified (as per Approved QAP & Specn.)	1	2	3	4	5	6	7	8	9	10
1.	Density												
2.	Hardness												
3.	Compression Modulus												
4.	Cross Breaking Strength												
5.	Shear Strength												
6.	Ash Contents												
7.	Acetone Extract												
8.	Bending Strength												

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