



QM-C-7.1/BOGIE/0001/C
Inspection Plan (Check Sheet)

Item: Centre Pivot Assembly (Top & Bottom)
Specn. : AAR-M-201 Gr. C
Amd.: --
Drg. No. & Alt.: WD-85079-S/2, Alt.4 Item 2 &1

1. Name of Manufacture
2. Date of Offer
3. RDSO File No.
4. Description of Material
5. Drawing and Alt.No.
6. Specification & Grade
7. Purchase order No.
8. Quantity Ordered
9. Quantity earlier passed
10. Quantity now offered
11. Date of Inspection
12. Consignee
13. D.P.

All the gauges used are duly calibrated:

- i. Date of Inspection**
- ii. Quantity Accepted**
- iii. Quantity Rejected**
- iv. Balance Order**

Signature of firms Representative

RDSO Representative

Name Designation & Stamp



Metallurgical Report

1. MATERIAL DETAILS:

Heat No.						
Casting S.No.						
Quantity Cast						
Quantity Passed						
Qty. Balance						

A.CHEMICAL COMPOSITION (As per M&C Heat Clearance Register)

Specified Value (in %)	OBSERVED VALUES					
C 0.32 Max						
Mn 1.85 Max						
Si 1.50 Max						
S 0.04 Max						
P 0.04 Max						

B.MECHANICAL PROPERTIES (As per M&C Heat Clearance Register)

Specified Value (in %)	OBSERVED VALUES					
UTS – 63.33 kg/mm ² (min)						
YS – 42.22 kg/mm ² (min)						
EL% - 22 (Min)						
RA% - 45 (Min)						
Hardness 179-241 BHN						
Micro Structure						
Impact 21 Jmin at -18°C						

Machining of Spherical surface of the top & Bottom centre pivots shall be done on the copying type arrangement. At least 75% contact between the two surfaces required.

Approximate % Contact Area (Visual Check)

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2 Dimensional Check:-

Top Pivot

Sl. No.	Specified values	Observed values									
		1	2	3	4	5	6	7	8	9	10
1.	260.00+0.5/-0.0										
2.	20.00+0.5 / -0.0										
3.	102+1 / -0.0										
4.	CRS 438.0										
5.	CRS 235.0										

Bottom Pivot

Sl. No.	Specified values	Observed values									
		1	2	3	4	5	6	7	8	9	10
1.	Height 76 (22+54)										
2.	Dimension 8										
3.	16 -1/ +0										
4.	Wall thickness 30 and 19										
5.	Ø 127										
6.	Ø 60 ±1										
7.	Ø 100 ±1										
8.	22										

Top & Bottom Pivot

Sl. No.	Specified values	Observed values									
		1	2	3	4	5	6	7	8	9	10
1.	Assembled Height 120+2/-0										
2.	Approximate Area of Contact 75%										

Others Checks :-

- (a) Check any notch mark/ cut mar/cross joint is visible in the vulnerable areas of the centre pivot assembly.
- (b) Whether any porosity/ pinholes/sand fusion/excess sand sticking beyond acceptable limit are noticed.
- (c) Whether surface finish is within acceptance limit.
- (d) 5% Gauging check sheet attached.
- (e) Confirm, that marking is as per Drawing.
- (f) Check heat treatment record

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Gauge Check for (Drg. No. WD-85079-S/2) individual casting :

No. of Sample : 5%

Actual No. of Sample :

Sl. No	Top Pivot Casting	Bottom Casting	OBSERVATION																			
			1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
1.	Bottom Profile gauge	Centre check gauge																				
2.	Rivet hole check gauge																					
3.	Centre check gauge	Pin hole check gauge																				
4.	Depth check gauge																					
5.	Bottom check gauge	Flange check gauge																				
6.	Top profile gauge	centre check gauge																				
7.	Rivet hole check gauge																					
8.	Retainer hole check gauge	ring check gauge																				
9.	Profile thickness gauge	wall check gauge																				
10	Top flange check gauge																					

Signature of firms Representative

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