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**QM-C-7.1/BOGIE/0001/C (Mod-1)**

**Inspection Plan (Check Sheet)**

**Item:** Centre Pivot Assembly (Top & Bottom) (Mod-1)  
**Specn. :** AAR-M-201 Gr. C  
**Amd.:** --  
**Drg. No. & Alt.:** WD-97049-S/3, Alt.3

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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



1. (A) CHEMICAL COMPOSITION (as per M&C Heat clearance Register)

Heat no.					
Body Sl. No.					
Qty. Cast					
Qty. Passed					
Qty. Offered					
Qty. Balance					
% age Spec.					
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 THE Register)

Spec (Kg/mm <sup>2</sup> )					
UTS- 63.33 Kg/mm <sup>2</sup> min					
YS- 42.22 Kg/mm <sup>2</sup> min					
EL%- 22 min					
RA%- 45 min					
Hardness 300 BHN min					
Micro Temp Marten site					

Annealing Lug Test  
i) Break one Lug of 1%  
whichever is higher  
& conduct the following  
test in Spectro.

(a) Heat No.

(b) Sl. No.

Chemical:-

Heat No.

C-

Mn-

Si-

S-

P-

ii) Grain  
Size 6-9:

iii) Micro Structure

iv) Hardness

v) Confirmed that all  
material bear  
manufacturer's initial  
and Serial No. as per Drg.

vi) Checked H.T. Register  
& confirmed that all  
the serial nos. offered  
have been properly heat  
treated as per H.T. register

Signature of firms Representative

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1. Centre Pivot Top & Bottom (Modified-1) Sl. No.
2. Whether metallurgical test report of Centre Pivot Top & Bottom (Modified-1) is attached and heat no. mentioned.

No. of heats Involved -----	All Heats Cleared -----	R.D.S.O. I&L Insp. Clear -----
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- [a] Centre Pivot Top
- [b] Centre Pivot Bottom

3. Gauge Application (5%):

- [a] Centre Pivot Top
- [b] Centre Pivot Bottom

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## GAUGE CHECK

Sl. No.	Attributes/Parameters	Drg. No.	Observation
A.	C. P. Bottom (Modified-1)	WD-97049-S/3, Item-1	
	Height Gauge for Dimention 40 mm	MCPB/01	
	Template for 350 mm diameter inside	MCPB/02	
	Thickness Gauge for dimention 30 mm	MCPB/03	
	Go/ No Go gauge for 60 mm hole	MCPB/04	
	Template for 390 mm outside diameter	MCPB/05	
	Plug Gauge for 4 nos. 23.5 mm dia holes & 330 mm PCD	MCPB/06	
	Square Template for 425mm	MCPB/07	
B.	C. P. Top (Modified-1)	WD-97049-S/3, Item-2	
	Template for Diameter 270 mm +0.5/-0.0	MCPB/08	
	Height Gauge for dimention 82 mm	MCPB/09	
	Go/ No Go Plug gauge for 60 mm hole	MCPB/10	
	Template for 328 mm dia	MCPB/11	
	Thickness Gauge for 28 mm height	MCPB/12	
	Plug Gauge for 85 mm dia and 15 mm height	MCPB/13	
	Plug Gauge for 8 nos. 23.5 mm dia holes with PCD 235/438 mm	MCPB/14	

### Other Checks:-

- Check any notch mark/ cut mark/ cross joint is visible the vulnerable areas of the centre pivot assembly.
- Whether any porosity/ pinholes/ sand fusion/ excess sand sticking beyond acceptable limit are noticed.
- Whether surface finish is within acceptance limit.

Signature of firms Representative

RDSO Representative

Name Designation & Stamp