



**QM-C-7.1/BOGIE/0004**

**Inspection Plan(Check Sheet)**

**Item:** Brake Beam for freight stock  
**Specn. :** WD-21-Casnob-22NLB Bogie-93 Rev 2 Jul'02,  
Amd.4 of Feb'2010'  
WD-17-Casnob-22 HS-Bogie-92 Rev.3,  
Amd.4 of Feb'2010  
**Amd.:**  
**Drg. No. & Alt.:** WD-89033-S/1 Alt-20, WD-07052-S/1, Alt. Nil

1	P.O. No.	
2	RDSO Case No.	
3	Name of Firm	
4	Date of Inspection	
5	Qty. Order	
6	Qty. Passed Order	
7	Qty. Now Offered	
8	Qty. Now Passed	
9	Qty. Rejected	
10	Date of Offer	
11	Consignee	
12	D.P.	

13. Laboratory Test Report (attach copies)
- (a) Centre sturt and end casting IS: 1030 (chem.& Micro test).
- (b) Wear plate IS : 3885 Pt. I or IV (Chem. & Hardness)  
(Sample Size: Chemical 1 Pc. Per lot, hardness 5 Pc per Lot).
- (c) Bush IS: 5317 or 4508 (Chemical & Hardness)  
(Sample Size : Chemical 1 Pc. Per lot hardness 5 Pc Per Lot).

Signature of firms Representative

RDSO Representative



14. Check & Record	Challan No.	Qty. Procured	Qty. Balance
(a) Casting			
(b) Low hydrogen electrode			
(c) Wear Place			

15. Check load test 5 in 100 and record under 12 T Load.

(a) Deflection 3mm max and after releasing the load permanent set 0.2mm max.

Description	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
Deflection																				
Permanent Set																				

16. Check 5% or 10 Nos. whichever is minimum with combined gauge for overall over all dimension of 2026 mm Distance between the centers of end casting 1762 min. Ears of end casting 36mm and Parallelism.

(a) Nos. checked .....

(b) Nos. Found OK .....

17. Section the Brake Beam 1 in 200 and attach the impression of the section surface and gas cut the sectioned Brake Beam for disposal. Give observation on the sectioned Brake Beam.

18. Attach physical test report of each lot fo strut / end casting :  
 (Test to be conducted on integral test pieces).

Signature of firms Representative

RDSO Representative



19. Check the 5% or 10 Nos. Which ever is minimum.

Sl.No.	Channel 75x40	Trust Flat 50x22 ±1.0mm as per 1852	Champer 30 trus flat.	Stiffener plate 8mm ±0.5mm	45x5x115 wear plate ±0.15mm	Sturt Casting thick 80 mm ±1.0	Sturt casting gap 35 mm +1.0 -0	Rad of Curvature of end casting 550 mm	End Casting thick 57 mm ±0.0	Remark
1.										
2.										
3.										
4.										
5.										
6.										
7.										
8.										
9.										
10.										

Signature of firms Representative

RDSO Representative