Govt. of India
Ministry of Railways
Research Designs & Standards Organisation
Manak Nagar, Lucknow-226 011

QM-C-7.1/BOGIE/0006
Inspection Plan(Check Sheet)

Item : Three Axle Cast Steel Trimount and Flexi-coil Bogie Frame for BG Locomotive

Specn. : MP-0.4900.04, Rev.01 of Oct' 2004

Amd. :

Drg. No. & Alt. : SKDL-3812 & SKDL-3813

---

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)
4. Quantity on order :
5. Quantity earlier passed :
6. Quantity offered for inspection on date :
7. Consignee :
8. Delivery period :

Signature of firms Representative

RDSO Representative

Name Designation & Stamp

Sl. No.	Tests/Check as per RDSO Spec. No. MP-0.4900.04, Rev. 01 of Oct'2004	Sampling plan	Remarks of Inspecting Official
1	Visual Inspection (Stage Inspection viz. Visual inspection after knockout and fettling and Inspection after normalizing and tempering)	100%	
2	Detachment and stamping of integral test coupons	Atleast of 02 nos. or 10% of lot whichever is larger	
3	Check for chemical composition, mechanical properties and microstructure of the material	Atleast of 02 nos. or 10% of lot whichever is larger	
4	Radiographic Examination & Magnetic particle Inspection- Defect evaluation and corrective action	100% by the firm and 5% or min. 1 no. bogie sample to be checked by inspecting official with validation of entire process	
5	Inspection after completion of rectification		
6	Dimension check after machining including tramming and wall thickness as per checklist attached		
7	Weightment of machined/ Un-machined clean castings depending on the supply conditions		
8	Inspection during proof load test	Randomly, at least once in a year	

Signature of firms Representative

RDSO Representative

Name Designation & Stamp

DIMENSION CHECK

Job No. :	
Qty/SL No. :	

Sl. No.	Locations	Prescribed Dimensions	Observed Dimension					
			Left side			Right side		
			End-1	Mid	End-2	End-1	Mid	End-2
1.	Width of end horns	193.5 ±1.0						
2.	Between horns without liners	184 ±1.0						
3.	Width of middle horns	323.0 +0.85/0.35						
4.	Between horns with liners	311.15+0.0/-0.80						
5.	Horns lugs out side	476±0.5						
6.	Hole centers of horns	416						
7.	Horns centre distance (End #1)	1702 ±1.5						
8.	Horns centre distance (End #2)	2108 ±1.5						
9.	Between end horns lateral dimension (without liners)	2031.5±1.5						
10.	Between middle horns lateral dimension (without liners)	2050.5±1.5						
11.	Between end horns lateral dimension (with liners)	2019.5 ±1.5						
12.	Between middle horns lateral dimension (with liners)	2038.5 ±1.5						
13.	Height from horn bottom face to spring seat	452±0.8						
14.	T.M. nose bracket longitudinal centers from horn face	775±0.8						

Signature of firms Representative

RDSO Representative

Name Designation & Stamp

15.	Mounting hole of cylinder brackets for M16 Bolts	∅ 18						
16.	Pivot diameter	∅ 362+0.56/-0.127						
17.	Parallel hole at pivot	Drill & tap ½" BSP						
18.	Pivot height	95±0.8						
19.	Height of oil pad face from horn bottom face	655±0.8						
20.	Difference between centre pivot top & top of oil pan (without liners)	15±1.5						
21.	Pivot centre line from hole face (end 1)	997.5±1.5						
22.	T.M. nose bracket hole centers	298(149+149)						
23.	T.M. nose bracket holes for vertical pin	∅33						
24.	T.M. nose bracket holes for locking pin	∅22						
25.	Height of equalizer bracket pad from bottom face to horn	699 ±1.0						
26.	Height between TM nose bracket without liner	316.0 +0.0/-0.8						
27.	Height between TM nose bracket with liner	304.0 +0.0/-0.8						
28.	Oil pan outer face from horn face (end #2)	730±2						
29.	Spring seat centre from axel centre line (short end)	552						
30.	Spring seat centre from axel centre line (long end)	692						
31.	Between lug of end brake lever bracket	54±1						

Signature of firms Representative

RDSO Representative

Name Designation & Stamp

32.	Brake hanger hole centers from horn bottom face	572±1						
33.	End brake lever lug thickness	35±0.5						
34.	Height of end lever bracket centers from horn bottom face	445±2						
35.	Longitudinal distance of end brake lever centers from 1st axel horn face toward pivot side	511.0±1.5						
36.	Longitudinal distance of end brake lever centers from 3rd axel horn face toward load pad	511.0±1.5						
37.	Longitudinal distance of end brake lever centers 1st axel horn face toward leading side	536.0±1.5						
38.	Longitudinal distance of end brake lever centers from horn face 3rd axel from horn face toward trailing side	536.0±1.5						
39.	Longitudinal distance of middle brake lever centers from horn face 2nd axel from horn face	536.0±1.5						
40.	Inside dimension of longitudinal beam	2057.5±5.0						
41.	Outside dimension of longitudinal beams	2387.5±5.0						
42.	End brake lever hole dia	∅ 47.67/47.67						
43.	Brake lever hole dia for transoms	∅ 44.50/44.45						
44.	Brake lever hole dia at middle axel	∅ 38.15/38.10						
45.	Hole of stay hom plate	∅ 26.0						
46.	Cylinder bracket hole centers	200/165						

Signature of firms Representative

RDSO Representative

Name Designation & Stamp