



QM-C-7.1/CASTING/0003

Inspection Plan(Check Sheet)

Item: Spares for side buffer assembly of locomotive
Specn. : MP.0.41.00.02 Rev-0 of Apr'02
Amd.: 02 of Jul'05
Drg. No. & Alt.:

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

Signature of Inspecting Official of RDSO



CHEMICAL AND PHYSICAL REPORT

HEAT NO.	ITEM	CHEMICAL ANALYSIS					HEAT TREATMENT BATCH NO	MECHANICAL AND PHYSICAL REPORT						ASTM GRANE SIZE NO.	HARDNESS
		C% 0.25 max	Mn% 1.20 max	Si% 0.60 max	S% 0.035 max	P% 0.040 max		YS Mpa 280	UTS Mpa 520	EL% 18	RA% 25	BEND AT 60 DEGREE	IMPACT IN JOULES 22		
	Buffer Plunger Buffer Casing Buffer Base & Buffing Washer														
	Buffer Plunger Plug	0.15- 0.25	0.60- 0.90	0.15- 0.35	0.050	0.050									
	Buffer Spindle	0.40- 0.50	0.60- 0.90	0.15- 0.25	0.050	0.050									
	Washer	0.20	1.5	0.40	0.040	0.040									
	Shim	0.22	1.5	0.40	0.045	0.045									
	Check Sleeve	0.50- 0.60	0.80- 1.00	1.50- 2.00	0.050	0.050									235-241 BHN

Signature of firms Representative

Signature of Inspecting Official of RDSO



DIMENSIONAL CHECK SHEET
LOCO.SIDE BUFFER (BG) ASSEMBLY TO IRS DRG. NO. SK.DL-4561 ALT-1

01. Buffer Plunger SK.DL-4562 Material Specification IS-1030 GR. 280-520 W										
DRG. DIMENSIONS	OBSERVED DIMENSION									
I.D. 174 - 0.8/-0.3										
O.D. 203 - 0.8/-13										
I.D. 194 + 0.0/-0.4										
FLANGE THICKNESS 19mm										
LENGTH FROM COLLAR 432+0.25 / -0.00										
THICKNESS FROM COLLAR TO FLANGE 60±0.3										
FLANGE DIA 457 ± 2										
OVER ALL LENGTH 492 ± 2										
SLOT 25+0.4/+0.8										
SLOT 19-0.4/-0.8										
SLOT-13.00										

02. Buffer Casing SK.DL-4563 Material Specification : IS-1030 GR. 280 – 250 W										
DRG. DIMENSIONS	OBSERVED DIMENSION									
I.D. 203 + 0.51 /- 0.00										
I.D. 216 + 0.51 /- 0.00										
DIA 244 ± 2										
DIA 238 ± 2										
OVER ALL LENGTH 370 ± 2										
COLLAR 25 ± 2										
SQUARE 274 x 274 ± 2										
CRS 210 ± 0.2										
4 HOLE DIA 17 ± 0.2										
4 HOLE DIA 29 ± 0.2										
FLANGE THICKNESS 16±1										
LENGTH - 186.00										

Signature of firms Representative

Signature of Inspecting Official of RDSO



03. Buffer Base SK.DL – 4564 ITEM – 1 ALT – 1 Material Specification – IS – 1030										
DRG. DIMENSIONS	OBSERVED DIMENSION									
THICKNESS 16 ± 1										
SQUARE 274 x 274 ± 2										
CRS 210 ± 0.2										
BOSS DIA 98 ± 1										
BOSS INNER DIA 44±0.5										
HOLE DIA 17±0.2										
HOLE DIA 29±0.2										
BOSS HEIGHT 15.00										

04. Check Sleeve L/BD-655/M ALT.6 Material Specification : Spring Steel – IS-3885 Pt.I										
DRG. DIMENSIONS	OBSERVED DIMENSION									
I.D. 203 ± 0.8										
O.D. 216 – 0.8 /-1.0										
I.D. 194-0.0/+0.4										
HEIGHT 57±1										
GROVE 25 – 0.0 /- 0.4										
GROVE 19+0.0 / +0.4										
GAP IN POSITION 3mm										

05. BUFFER SPINDLE SK.DL – 4564 ITEM – 2 ALT – 1 Material Specification : IS – 1875										
DRG. DIMENSIONS	OBSERVED DIMENSION									
TOTAL LENGTH 480										
DIA 40 ± 0.8										
DIA 30										
TAPER LENGTH 60										
DIA 60										
SLOT LENGTH 22+0.5/- 0.0										
SLOT DEPTH 11										

06. SHIM SK.DL. – 4564 ITEM– 6 ALT – 1 Material Specification : IS – 2062										
DRG. DIMENSIONS	OBSERVED DIMENSION									
OUTER DIA 168.0										
INNER DIA 42.0										
THICKNESS 3.0										

Signature of firms Representative

Signature of Inspecting Official of RDSO



07. BUFFER PLUNGER PLUG SK.DL – 4564 ALT – 1 ITEM – 5 Material Specification : IS – 1875										
DRG. DIMENSIONS	OBSERVED DIMENSION									
DIA 75										
DIA 54										
WIDTH OF KEY $21+0.0/-0.5$										
HEIGHT 11										
THICKNESS 19										

08. BUFFING WASHER SK.DL. – 4564 ITEM– 4 ALT – 1 Material Specification : IS – 1030										
DRG. DIMENSIONS	OBSERVED DIMENSION									
OUTER DIA 170										
INNER DIA 100										
INNER DIA 44										
THICKNESS 25										
THICKNESS 15										
TOTAL THICKNESS 135										
DEPTH										
RIB THICKNESS 13										

09. WASHER SK.DL. – 4564 ITEM– 3 ALT – 1 Material Specification : IS – 2062										
DRG. DIMENSIONS	OBSERVED DIMENSION									
OUTER DIA 168										
INNER DIA 89										
THICKNESS 20										
THICKNESS 12										
THICKNESS 8										

10. RUBBER BUFFER SPRING SK.DL. – 4565										
DRG. DIMENSIONS	OBSERVED DIMENSION									
OUTER DIA 168										
INNER DIA $42+1.0/-0$										
THICKNESS 112 ± 1										
PLATE THICKNESS 5										
GAP BETWEEN PLATES 16.5										

Signature of firms Representative

Signature of Inspecting Official of RDSO



11. LOCO SIDE BUFFER ASSEMBLY DRG. NO. – SKDL – 4561 ALT – 1										
DRG. DIMENSIONS	OBSERVED DIMENSION									
OUTER DIA 168										
TOTAL HEIGHT 635 +2/- 1.5										
STROKE 110mm										

HAMMERING TEST REPORT

Welded portion of plug on plunger head was applied five blows of 5 Kgs. Hammer on two nos. Of plungers and there after DPT was carried out. No. cracks were observed.

MARKING ON COMPONENTS

Marking on components of were checked and found to be legible and as per drawing.

DIMENSIONAL CHECK

Components of two assemblies were dimensionally checked and were found acceptable.

Signature of firms Representative

Signature of Inspecting Official of RDSO



LIQUID DYE PENERTRATION EXAMINATION

(HIGH CAPACITY BUFFER ASSEMBLY)

Place of testing :
Testing date & place :
Job description :
Testing Location :
Developer :
Cleaner :
Penetrant :
Observation :
Remarks :
Tested by :

Signature of firms Representative

Signature of Inspecting Official of RDSO