



QM-C-7.1/COUPLER/0002/A, G
Inspection Plan(Check Sheet)

Item: Alliance II Coupler & its components
(Coupler Body/Yoke & Striker Casting)
Specn. : 24-BD-79
Amd.: 3 of Aug' 91
Drg. No. & Alt.: SK-79556, Item-1

1. Name of Manufacturer :
2. Date of Offer :
3. RDSO File No. :
4. Description of Material :
5. Drawing and Alt. No. :
6. Specification and Grade :
7. P.O. No. :
8. Total Quantity Ordered :
9. Quantity Earlier Passed :
10. Quantity now offered :
11. Consignee :
12. D.P. :

- [1. Date of Inspection
- [2. Quantity Accepted
- [3. Quantity Rejected
- [4. Balance Order

Signature of firms Representative

RDSO Representative

Name Designation & Stamp



METALLURGICAL REPORT OF ALLIANCE-2 COUPLER BODY & ALLIANCE-2 YOKE
ALLIANCE-2 STRIKER CASTING
(SPEC. : AARM-201 GR-B)

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 as per 48-BD-08 (Gr.B)					
C-0.32 Max					
Mn-0.90 Max					
P-0.030 Max					
S-0.030 Max					
Si-0.60 Max					

(B) MECHANICAL PROPERTIES (as per the Register)

SPEC Kg/cm ²					
UTS- 4920					
YS- 2670					
EL%-24					
RA%-36					
Impact- 2.07 Kg.m (- 7 °C) as per 48-BD-08 (Gr.B)					
Hardness 137-208 BHN					
Ht. Cl. Dt.					
Micro Temp. Martensite					

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-
P-
S-
Si-

(ii) Grain :
Size :
6-9 :

(iii) Micro Structure

(iv) Hardness

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

RDSO Representative

Name Designation & Stamp



**INSPECTION CHECK SHEET FOR ALLIANCE-2 COUPLER BODY & ALLIANCE-2 YOKE
ALLIANCE-2 STRIKER CASTING**

1. Alliance-2 Coupler Body, Alliance-2 Yoke & Alliance-2 Striker Casting Sl. No.
2. Whether meturgical test report of Alliance-2 Coupler Body & Alliance-2 Yoke & Alliance-2 Striker Casting is attached and heat no. mentioned.

	<u>No. of heats Involved</u>	<u>All Heats Cleared</u>	<u>RDSO I & L Insp. Clear</u>
a. Alliance-2 Coupler Body			
b. Alliance-2 Yoke			
c. Alliance-2 Striker Casting			
3. Gauge Application (5%)			
a. Alliance-2 Coupler Body			
b. Alliance-2 Yoke			
c. Alliance-2 Striker Casting			

Signature of firms Representative

RDSO Representative

Name Designation & Stamp



GAUGE CHECK

Sl. No.	Attributes / Parameters	Gauge Drg. No.	Observation
A.	ALLIANCE-2 COUPLER BODY	WD-84073-S-	
1.	10 A COUNTER GAUGE	CB-1	
2.	PIN PROTECTOR GAUGE	CB-2	
3.	PULLING LUG GAUGE	CB-3	
4.	DISTANCE BETWEEN KHUCKLE TAIL POCKET AND LOCKING FACE WALL	CB-4	
5.	EAR SPRING	CB-5	
6.	PIVOT PIN HOLE GAUGE	CB-6	
7.	ROTARY LUG GAUGE	CB-7	
8.	SHANK LENGTH GAUGE	CB-8	
9.	DUMMEY LUG GAUGE	CB-9	
10.	SHANK HEIGHT GAUGE	CB-10	
11.	BUTT END HEIGHT GAUGE	CB-11	
12.	DISTANCE BETWEEN YOKE PIN HOLE TO BUTT FACE.	CB-12	
13.	BUTT END PROFILE	CB-13	
14.	SHANK END PIN HOLE GAUGE	CB-14	
15.	SHANK LENGTH FEELER GAUGE	CB-15	
16.	PULLING LUG CLEVIS SIDE	CB-16	
17.	PIVOT LUG (EAR SPRING) GAUGE	CB-17	
18.	PIVOT PIN HOLE GAUGE (CLEVIS SIDE)	CB-18	
19.	DISTANCE BETWEEN CLEVIS EAR	CB-19	

Signature of firms Representative

RDSO Representative

Name Designation & Stamp



GAUGE CHECK

Sl. No.	Attributes / Parameters	Gauge Drg. No.	Observation
B.	ALLIANCE-2 YOKE	WD-84073-S-	
1.	MOUTH OPENING GAUGE	Y - 1	
2.	YOKE HEIGHT GAUGE	Y - 2	
3.	YOKE STRAP THICKNESS & WIDTH 'NO GO' GAUGE	Y - 3	
4.	DRAFT GEAR POCKET HEIGHT GAUGE	Y - 4	
5.	YOKE PIN HOLE GAUGE & YOKE PIN HOLE 'NO GO' GAUGE.	Y - 5	
6.	DRAFT GEAR POCKET LENGTH GAUGE	Y - 6	
7.	OUTSIDE WIDTH 'GO' & 'NO GO' GAUGE	Y - 7	
C.	ALLIANCE-2 STRIKER CASTING	WD-84073-S-	
1.	HOLE CENTRE TO BOUNDARY & MOUTH OPENING GAUGE & 4 NOS. PINS.	SC-1	
2.	THICKNESS OF FLANGE 'GO & 'NO GO' GAUGE.	SC-2	
3.	FRONT OPENING HEIGHT WITH WEAR PLATE 'GO & 'NO GO' GAUGE.	SC-3	
4.	THICKNESS OF RIBS 'NO GO' GAUGE FOR 14MM & 18MM.	SC-4	
5.	REAR LUG LENGTH HEIGHT & SQUARNESS GAUGE.	SC-5	
6.	WIDTH OUTSIDE FOR REAR LUGS GAUGE.	SC-6	

Signature of firms Representative

RDSO Representative

Name Designation & Stamp