



QM-C-7.1/COUPLER/0004
INSPECTION Plan (CHECK SHEET) FOR “SCHAKU” SEMI PERMANENT COUPLER AS PER RDSO
AS PER RDSO SPEC. NO. 61-B-36/REV.68-1 with amendment no.1 of Oct. 2016

Purchase Order details of other as per other check sheet of principle manufactured items

- 1) PO No. & Date :
- 2) RDSO Case No. :
- 3) Name of Firm :
- 4) Description of items :
- 5) Drawing No. :
- 6) Specification :
- 7) Date of Inspection :
- 8) Quantity on order :
- 9) Quantity now offered :
- 10) Quantity Passed :
- 11) Quantity Rejected :
- 12) Quantity Passed earlier :
- 13) Delivery Period :
- 14) Consignee :
- 15) Remarks :

Signature of Firm’s Representative

Signature of RDSO Inspector



2. Visual Inspection along with NDT Testing e.g. Ultrasonic or MPI or DP :
(5% or 02 nos. minimum) from the offered lot

Sl. No.	Quality verified with USG or MPI or DP report	Surface finish, to observe for pitting lamination etc.	Bending of split pin to its locating zone	Painting, finished with primer or not	Remarks

Signature of Firm's Representative

Signature of RDSO Inspector



CHECK SHEET
AIR PIPE COUPLING FOR END 'A' & 'B' TO
SCHAKU DRG. No. 40.587.04(3) and RESPECTIVE FIRM'S DRAWINGS
AS PER RDSO SPEC. NO. 61-B-36/REV.68-1 with amendment no.1 of Oct. 2016

01	Po No.& Date:	07	RDSO case No. :
02	Name of Firm:	08	Date of Inspection:
03	Drawing No :	09	Specification :
04	DP :	10	Consignee :
05	Qty Ordered :	11	Qty Passed Earlier :
06	Qty now Offered:	12	Qty Rejected :

13. Material Test Certificate No. & date :
(To be provided at a frequency of once in every 1000 sets)

14. Visual Check :

15. Dimension checked 5% or 5 nos. minimum :

16. Parameters to be checked (all dimensions are in mm):

SI. NO	MEASURING POINTS	DRG. DIMN.	OBSERVED DIMENSIONS					
			1	2	3	4	5	6
1	VISUAL	FREE FROM SURFACE DEFECT						
2	HEIGHT OF ANGLE PLATE	127.0 ±0.5						
3	BOSS LENGTH (WIDTH OF ANGLE PLATE)	110.0 ±0.5						
4	THICKNESS OF ANGLE PLATE	12.0 11.0(Min.)						
5	MOUNTING HOLE DIAMETER	15.0						
6	FACE TO HOLE CENTRE DISTANCE (ANGLE PLATE)	85.0						
7	CENTRE DISTANCE	*150.0						
PLEASE VERIFY DIMENSIONS AGAINST RESPECTIVE FIRM'S PART DRAWINGS								

Note: Unspecified Tolerance as per IS: 2102, 1993 is applicable

17. Marking : "MANUFACTURERS" Punch, Hologram, Name Plate.(Whichever is applicable)

18. Packing : Packed in wooden boxes/loose

Signature of Firm's Representatives

Signature of RDSO Inspector



Remarks : Bore, Thickness, Length, angle etc. checked as per relevant gauges, Templates, jigs, fixture etc. and found satisfactory – denoted by “OK”

* TO BE MEASURED AFTER DISASSEMBLING SPRING, BRASS SLEEVE & SEAL FROM SPRING POT

Signature of Firm's Representatives

Signature of RDSO Inspector



CHECK SHEET

BEARING BRACKET SUB ASSY. (BEARING BRACKET WITH UPPER & LOWER BUSH)
TO SCHAKU DRG. NO 40-588.07(2) (ITEM NO. 3, 4, 32) and RESPECTIVE FIRM'S DRAWINGS
AS PER RDSO SPEC. NO. 61-B-36/REV.68-1 with amendment no.1 of Oct. 2016

01	Po No.& Date:	07	RDSO case No. :
02	Name of Firm:	08	Date of Inspection:
03	Drawing No :	09	Specification :
04	DP :	10	Consignee :
05	Qty Ordered :	11	Qty Passed Earlier :
06	Qty now Offered:	12	Qty Rejected :

13. Material Test Certificate No. & date :
(To be provided at a frequency of once in every 1000 sets)

14. Visual Check :

15. Dimension checked 5% or 5 nos. minimum :

16. Parameters to be checked (all dimensions are in mm):

SI. NO	MEASURING POINTS	DRG. DIMN.	OBSERVED DIMENSIONS						
			1	2	3	4	5	6	
1	VISUAL	FREE FROM SURFACE DEFECT							
BEARING BRACKET									
2	LENGTH	533.0 ^{+2.0/-3.0}							
3	WIDTH	266.0 ^{±2.0} 266.0 ^{+2.0/-3.0}							
4	HEIGHT	240.0 ^{±2}							
5	OUTSIDE GAP	190.0 ^{+2.0/-0.0} 190.0 ^{-0.3}							
6	INSIDE GAP	86.2 ^{+0.3/-0.0}							
UPPER AND LOWER BUSH									
7	INTERNAL DIAMETER	80.0 ^{+0.320/-0.000} 80.0 ^{+0.274/+0.200}							
PLEASE VERIFY DIMENSIONS AGAINST RESPECTIVE FIRM'S PART DRAWINGS									

Note: Unspecified Tolerance as per IS: 2102, 1993 is applicable

Signature of Firm's Representatives

Signature of RDSO Inspector



17. Marking : "MANUFACTURERS" Punch, Hologram, Name Plate.(Whichever is applicable)

18. Packing : Packed in wooden boxes/loose

Remarks : Bore, Thickness, Length, angle etc. checked as per relevant gauges, Templates, jigs, fixture etc. and found satisfactory – denoted by "OK"

Signature of Firm's Representatives

Signature of RDSO Inspector



CHECK SHEET
CENTERING ADJUSTMENT DEVICE
TO SCHAKU DRG. No. 40-1000.10(2) and RESPECTIVE FIRM's DRAWINGS
AS PER RDSO SPEC. NO. 61-B-36/REV.68-1 with amendment no.1 of Oct. 2016

01	Po No.& Date:	07	RDSO case No. :
02	Name of Firm:	08	Date of Inspection:
03	Drawing No :	09	Specification :
04	DP :	10	Consignee :
05	Qty Ordered :	11	Qty Passed Earlier :
06	Qty now Offered:	12	Qty Rejected :

13. Material Test Certificate No. & date :
(To be provided at a frequency of once in every 1000 sets)

14. Visual Check :

15. Dimension checked 5% or 5 nos. minimum :

16. Parameters to be checked (all dimensions are in mm):

SI. NO	MEASURING POINTS	DRG. DIMN.	OBSERVED DIMENSIONS					
			1	2	3	4	5	6
1	VISUAL	FREE FROM SURFACE DEFECT						
2	OUTER DIAMETER OF SPRING CASING SUB ASSY.	101.6 ^{+1.016}						
3	INTERNAL DIAMETER EYE	25H11 ^{+0.130/-0.000}						
4	WIDTH OF EYE FOR LOCK NUT	60.0						
5	OUTER DIAMETER OF PIN	22h11 ^{+0.000/-0.130}						
6	LENGTH	400.0						
7	CENTRE DISTANCE	612.0						
PLEASE VERIFY DIMENSIONS AGAINST RESPECTIVE FIRM's PART DRAWINGS								

Note: Unspecified Tolerance as per IS: 2102, 1993 is applicable

17. Marking : "MANUFACTURERS" Punch, Hologram, Name Plate.(Whichever is applicable)

18. Packing : Packed in wooden boxes/loose

Signature of Firm's Representatives

Signature of RDSO Inspector



Remarks : Bore, Thickness, Length, angle etc. checked as per relevant gauges, Templates, jigs, fixture etc. and found satisfactory – denoted by "OK"

Signature of Firm's Representatives

Signature of RDSO Inspector



CHECK SHEET

CENTERING CARRIER END-B TO SCHAKU DRG. No. 40-318.13(4) and RESPECTIVE FIRM'S DRAWINGS
AS PER RDSO SPEC. NO. 61-B-36/REV.68-1 with amendment no.1 of Oct. 2016

01	Po No.& Date:	07	RDSO case No. :
02	Name of Firm:	08	Date of Inspection:
03	Drawing No :	09	Specification :
04	DP :	10	Consignee :
05	Qty Ordered :	11	Qty Passed Earlier :
06	Qty now Offered:	12	Qty Rejected :

13. Material Test Certificate No. & date :
(To be provided at a frequency of once in every 1000 sets)

14. Visual Check :

15. Dimension checked 5% or 5 nos. minimum :

16. Parameters to be checked (all dimensions are in mm):

SI.NO	MEASURING DRG. POINTS	DIMN.	OBSERVED DIMENSIONS					
			1	2	3	4	5	6
CENTERING CARRIER END-B								
1	VISUAL	FREE FROM SURFACE DEFECT						
2	OUTSIDE DIAMETER	170d9 ^{-0.145/-0.245}						
3	HOLE DIAMETER	41.0 ±0.2						
4	TOTAL LENGTH	53.0 ^{±0.3}						
5	CENTRE DISTANCE	98 ^{±0.2}						
CENTERING PIN								
6	OUTER DIAMETER	40.0 ^{+0.0/-0.2}						
PLEASE VERIFY DIMENSIONS AGAINST RESPECTIVE FIRM'S PART DRAWINGS								

Note: Unspecified Tolerance as per IS: 2102, 1993 is applicable

17. Marking : "MANUFACTURERS" Punch, Hologram, Name Plate.(Whichever is applicable)

18. Packing : Packed in wooden boxes/loose

Remarks : Bore, Thickness, Length, angle etc. checked as per relevant gauges, Templates, jigs, fixture etc. and found satisfactory – denoted by "OK"

Signature of Firm's Representatives

Signature of RDSO Inspector



CHECK SHEET

SEMI PERMANENT COUPLER END-A TO SCHAKU DRG. No. 40-586 A (0) and RESPECTIVE FIRM'S DRAWINGS
AS PER RDSO SPEC. NO. 61-B-36/REV.68-1 with amendment no.1 of Oct. 2016

01	Po No.& Date:	07	RDSO case No. :
02	Name of Firm:	08	Date of Inspection:
03	Drawing No :	09	Specification :
04	DP :	10	Consignee :
05	Qty Ordered :	11	Qty Passed Earlier :
06	Qty now Offered:	12	Qty Rejected :

13. Material Test Certificate No. & date :
(To be provided at a frequency of once in every 1000 sets)

14. Visual Check :

15. Dimension checked 5% or 5 nos. minimum :

16. Parameters to be checked (all dimensions are in mm):

SI. NO	MEASURING POINTS	DRG. DIMN.	OBSERVED DIMENSIONS					
			1	2	3	4	5	6
BEARING BRACKET								
1	VISUAL	FREE FROM SURFACE DEFECT						
2	FACE TO HOLE CENTRE	146.0						
3	HEIGHT	240.0						
4	WIDTH	266.0 +2.0/-3.0						
5	LENGTH	533.0 +2.0/-3.0						
DRAW AND BUFF GEAR								
6	LENGTH FROM CENTRE	*554.0						
7	CENTRE DISTANCE	543.0 +2.0/-3.0 533.0						
8	LENGTH OF PACK	249.5 (+0.0/-0.5)						
AIR PIPE COUPLING								
9	CENTRE DISTANCE	150.0						
10	CENTRE DISTANCE	183.0						
COMPLETE COUPLER								
11	TOTAL LENGTH FROM CENTRE	**1107.0						
PLEASE VERIFY DIMENSIONS AGAINST RESPECTIVE FIRM'S PART DRAWINGS								

Note: Unspecified Tolerance as per IS: 2102, 1993 is applicable

Signature of Firm's Representatives
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Signature of RDSO Inspector

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17. Marking : "MANUFACTURERS" Punch, Hologram, Name Plate (Whichever is Applicable)

18. Packing : Packed in wooden boxes/loose

Remarks : Bore, Thickness, Length, angle etc. checked as per relevant gauges, Templates, jigs, fixture etc. and found satisfactory – denoted by "OK"

* TO BE MEASURED AFTER DISASSEMBLING UPPER & LOWER CUP SLEEVE

**TO BE MEASURED AFTER ASSEMBLING WITH SEMI PERMANENT COUPLER END-B

Signature of Firm's Representatives

Signature of RDSO Inspector



CHECK SHEET

SEMI PERMANENT COUPLER END-B TO SCHAKU DRG. No. 40-587 A (0) and RESPECTIVE FIRM'S DRAWINGS
AS PER RDSO SPEC. NO. 61-B-36/REV.68-1 with amendment no.1 of Oct. 2016

01	Po No.& Date:	07	RDSO case No. :
02	Name of Firm:	08	Date of Inspection:
03	Drawing No :	09	Specification :
04	DP :	10	Consignee :
05	Qty Ordered :	11	Qty Passed Earlier :
06	Qty now Offered:	12	Qty Rejected :

13. Material Test Certificate No. & date :

(To be provided at a frequency of once in every 1000 sets)

14. Visual Check :

15. Dimension checked 5% or 5 nos. minimum :

16. Parameters to be checked (all dimensions are in mm):

SI. NO	MEASURING POINTS	DRG. DIMN.	OBSERVED DIMENSIONS					
			1	2	3	4	5	6
BEARING BRACKET								
1	VISUAL	FREE FROM SURFACE DEFECT						
2	FACE TO HOLE CENTRE	146.0						
3	HEIGHT	240.0						
4	WIDTH	266.0 ^{+2.0/-3.0}						
5	LENGTH	533.0 ^{+2.0/-3.0}						
DRAW AND BUFF GEAR								
6	LENGTH FROM CENTRE	*554.0						
7	CENTRE DISTANCE	543.0 ^{+2.0/-3.0} 533.0						
8	LENGTH OF PACK	249.5 ^{+0.0/-0.5}						
AIR PIPE COUPLING								
9	CENTRE DISTANCE	150.0						
10	CENTRE DISTANCE	183.0						
COMPLETE COUPLER								
11	TOTAL LENGTH FROM CENTRE	**1107.0						
PLEASE VERIFY DIMENSIONS AGAINST RESPECTIVE FIRM'S PART DRAWINGS								

Note: Unspecified Tolerance as per IS: 2102, 1993 is applicable

Signature of Firm's Representatives

Signature of RDSO Inspector



17. Marking : "MANUFACTURERS" Punch, Hologram, Name Plate
(Whichever is Applicable)

18. Packing : Packed in wooden boxes/loose

Remarks : Bore, Thickness, Length, angle etc. checked as per relevant gauges, Templates,
jigs, fixture etc. and found satisfactory – denoted by "OK"

* TO BE MEASURED AFTER DISASSEMBLING UPPER & LOWER CUP SLEEVE

**TO BE MEASURED AFTER ASSEMBLING WITH SEMI PERMANENT COUPLER END-A

Signature of Firm's Representatives _____

Signature of RDSO Inspector _____



CHECK SHEET
DRAFT GEAR / DRAW & BUFF GEAR TO
SCHAKU DRG. No. 40-586.06(2), and RESPECTIVE FIRM'S DRAWINGS
AS PER RDSO SPEC. NO. 61-B-36/REV.68-1 with amendment no.1 of Oct. 2016

01	Po No.& Date:	07	RDSO case No. :
02	Name of Firm:	08	Date of Inspection:
03	Drawing No :	09	Specification :
04	DP :	10	Consignee :
05	Qty Ordered :	11	Qty Passed Earlier :
06	Qty now Offered:	12	Qty Rejected :

13. Material Test Certificate No. & date :
(To be provided at a frequency of once in every 1000 sets)

14. Visual Check :

15. Dimension checked 5% or 5 nos. minimum :

16. Parameters to be checked (all dimensions are in mm):

SI. NO	MEASURING POINTS	DRG. DIMN.	OBSERVED DIMENSIONS					
			1	2	3	4	5	6
DRAW AND BUFF GEAR								
1	VISUAL	FREE FROM SURFACE DEFECT						
2	LENGTH OF PACK	249.5/250.5 ^{+0.0/-0.5}						
3	WIDTH	416.0 ^{±1}						
4	LENGTH FROM CENTRE	*554.0						
ARTICULATION BEARING								
5	INTERNAL DIAMETER	80H8 ^{+0.046/-0.000}						
PLEASE VERIFY DIMENSIONS AGAINST RESPECTIVE FIRM'S PART DRAWINGS								

Note: Unspecified Tolerance as per IS: 2102, 1993 is applicable

17. Marking : "MANUFACTURERS" Punch, Hologram, Name Plate.(Whichever is applicable)

18. Packing : Packed in wooden boxes/loose

Remarks : Bore, Thickness, Length, angle etc. checked as per relevant gauges, Templates, jigs, fixture etc. and found satisfactory – denoted by "OK"

* TO BE MEASURED AFTER DISASSEMBLING UPPER & LOWER CUP SLEEVE

Signature of Firm's Representatives

Signature of RDSO Inspector



CHECK SHEET

INTERMEDIATE TUBE TO SCHAKU DRG. No. 40-586.01:01(2) and RESPECTIVE FIRM'S DRAWINGS
AS PER RDSO SPEC. NO. 61-B-36/REV.68-1 with amendment no.1 of Oct. 2016

01	Po No.& Date:	07	RDSO case No. :
02	Name of Firm:	08	Date of Inspection:
03	Drawing No :	09	Specification :
04	DP :	10	Consignee :
05	Qty Ordered :	11	Qty Passed Earlier :
06	Qty now Offered:	12	Qty Rejected :

13. Material Test Certificate No. & date :
(To be provided at a frequency of once in every 1000 sets)

14. Visual Check :

15. Dimension checked 5% or 5 nos. minimum :

16. Parameters to be checked (all dimensions are in mm):

SI. NO	MEASURING POINTS	DRG. DIMN.	OBSERVED DIMENSIONS						
			1	2	3	4	5	6	
	VISUAL	FREE FROM SURFACE DEFECTS							
1	TOTAL LENGTH	548 ^{+0.8}							
2	OUTER DIAMETER OF FLANGE	210.0 ^{+0.0/-0.5}							
3	FLANGE THICKNESS (DRAW & BUFF GEAR END)	25.0 ^{+0.0/-0.3}							
4	FLANGE THICKNESS (MUFF COUPLING END)	25.0 ^{+0.0/-0.3}							
5	ANGLE 11°20'	(AS PER GAUGE)							
PLEASE VERIFY DIMENSIONS AGAINST RESPECTIVE FIRM'S PART DRAWINGS									

Note: Unspecified Tolerance as per IS: 2102, 1993 is applicable

17. Marking : "MANUFACTURERS" Punch, Hologram, Name Plate.(Whichever is applicable)

18. Packing : Packed in wooden boxes/loose

Remarks : Bore, Thickness, Length, angle etc. checked as per relevant gauges, Templates, jigs, fixture etc. and found satisfactory – denoted by "OK"

Signature of Firm's Representatives

Signature of RDSO Inspector



CHECK SHEET

**LEAF SPRING WITH SUPPORT TO SCHAKU DRG. No. 40-588.07(2) and RESPECTIVE FIRM's DRAWINGS
AS PER RDSO SPEC. NO. 61-B-36/REV.68-1 with amendment no.1 of Oct. 2016**

01	Po No.& Date:	07	RDSO case No. :
02	Name of Firm:	08	Date of Inspection:
03	Drawing No :	09	Specification :
04	DP :	10	Consignee :
05	Qty Ordered :	11	Qty Passed Earlier :
06	Qty now Offered:	12	Qty Rejected :

13. Material Test Certificate No. & date :
(To be provided at a frequency of once in every 1000 sets)

14. Visual Check :

15. Dimension checked 5% or 5 nos. minimum :

16. Parameters to be checked (all dimensions are in mm):

SI. NO	MEASURING POINTS	DRG. DIMN.	OBSERVED DIMENSIONS					
			1	2	3	4	5	6
LEAF SPRING								
1	VISUAL	FREE FROM SURFACE DEFECT						
2	LENGTH 1	*740.0 ±0.8						
3	LENGTH 2	*710.0 ±0.8						
4	WIDTH	*100.0 ±0.8 80 ±0.5						
5	THICKNESS	10.0 ±0.1 13.0						
BEARING BOLT								
6	OUTER DIAMETER	*80d9 -0.100/-0.174						
7	OUTER DIAMETER	109.0 10.0						
8	ACROSS FLAT	60.0						
PLEASE VERIFY DIMENSIONS AGAINST RESPECTIVE FIRM's PART DRAWINGS								

Note: Unspecified Tolerance as per IS: 2102, 1993 is applicable

17. Marking : "MANUFACTURERS" Punch, Hologram, Name Plate.(Whichever is applicable)

18. Packing : Packed in wooden boxes/loose

Remarks : Bore, Thickness, Length, angle etc. checked as per relevant gauges, Templates, jigs, fixture etc. and found satisfactory – denoted by "OK"

* TO BE MEASURED AFTER DISASSEMBLING SUPPORT SUB. ASSEMBLY.

Signature of Firm's Representative
REVISION 2

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Signature of RDSO Inspector
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CHECK SHEET

ADJUSTABLE CUP SLEEVE TO SCHAKU DRG. No. 40-317.13(2) and RESPECTIVE FIRM'S DRAWINGS
AS PER RDSO SPEC. NO. 61-B-36/REV.68-1 with amendment no.1 of Oct. 2016

01	Po No.& Date:	07	RDSO case No. :
02	Name of Firm:	08	Date of Inspection:
03	Drawing No :	09	Specification :
04	DP :	10	Consignee :
05	Qty Ordered :	11	Qty Passed Earlier :
06	Qty now Offered:	12	Qty Rejected :

13. Material Test Certificate No. & date :
(To be provided at a frequency of once in every 1000 sets)

14. Visual Check :

15. Dimension checked 5% or 5 nos. minimum :

16. Parameters to be checked (all dimensions are in mm):

SI. NO	MEASURING POINTS	DRG. DIMN.	OBSERVED DIMENSIONS					
			1	2	3	4	5	6
ADJUSTABLE CUP SLEEVE								
1	VISUAL	FREE FROM SURFACE DEFECT						
2	LENGTH	300.0						
3	INTERNAL DIAMETER	*193.0 ^{+0.25/-0.00}						
4	INTERNAL DIAMETER	*212.0 ^{+0.5/-0.0}						
SPINDLE								
	TOTAL LENGTH	490.0 ^{+0.0/-1.0}						
CENTERING CARRIER END-A								
5	LENGTH	*156.0 ^{+0.0/-2.0}						
6	FLANGE THICKNESS	*18.0 ^{+0.0/-0.4} 18.5 ^{+0.0/-0.2}						
7	CENTRE DISTANCE	*98.0±0.2						
8	HOLE DIAMETER	*41.0						
9	OUTER DIAMETER	*170d9 ^{-0.145/-0.245}						
10	OUTER DIAMETER	*210.0 ^{+0.0/-0.5}						
WINGED NUT								
11	WIDTH OF WINGED NUT	32.0 ±0.3						
PLEASE VERIFY DIMENSIONS AGAINST RESPECTIVE FIRM'S PART DRAWINGS								

Note: Unspecified Tolerance as per IS: 2102, 1993 is applicable

Signature of Firm's Representatives
REVISION 2

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Signature of RDSO Inspector
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17. Marking : "MANUFACTURERS" Punch, Hologram,
Name Plate.(Whichever is applicable)

18. Packing : Packed in wooden boxes/loose

Remarks : Bore, Thickness, Length, angle etc. checked as per relevant gauges,
Templates, jigs, fixture etc. and found satisfactory – denoted by
"OK"

* TO BE MEASURED AFTER DISASSEMBLING PAIR OF CUP SLEEVE

Signature of Firm's Representatives

Signature of RDSO Inspector