



QM-C-7.1/FORGING/0004
Inspection Plan(Check Sheet)

Item: Side Frame Key
Specn. :
Amd.:
Drg. No. & Alt.: SK-69594 Item 6, Alt-34

- 1) Firm's Name :
- 2) Date (Period) of Inspection :
- 3) Contract Details
 - a) Contract No. & 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 offered for Inspection on Date :
- 6) Consignee :

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SIGNATURE OF RDSO INSPECTOR



1.0 Scope : Technical requirement for manufacture and supply of side frame key to be filled in cast steel bogies.

2.0 Acceptance Criteria :-

- 1) Raw material procurement record and in coming raw material with TC reference of supplier as well as internal audit checking from outside .
- 2) The Selection of sample for visual as well as dimensional check shall be at the discretion of the inspection official.
- 3) Select at least one sample for chemical test.

3.0 Visual Check : The test specimen shall be taken at random from the offered lot.
Sample Size : 5% of the lot subject to minimum of 50 Nos.

Side Frame key shall be free from any manufacturing defect.

4.0 Dimensional Check :

5.0 Heat Treatment :-

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6.0 Tests :- Chemical & Physical Test

One sample from each lot shall be taken for chemical & physical test.

a) Required Chemical Composition:-

C%	0.40 to 0.50
Mn%	0.60 to 0.90
Si%	0.15 to 0.35
S & P %	0.04 max.

b) Required Physical Properties :

UTS	620 Mpa Min.
Yield	320 Mpa Min.
Elongation	15% min.

c) Required Hardness – 175 BHN min.

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INSPECTION CHECK SHEET

13. LAB : Test report for chemical & physical of each lot.
(copy attached)
Specification IS:2004 CL.IV.

14. VISUAL : 5% OF THE LOT.

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

15. DIMENSIONAL CHECK: 0.2% OF THE LOT.

S.No.	Total Length	Total Width	Hole Dmn.	DRAWING DIMENSION								Hard ness									
				24.0	25.5 ^{+1.5} ₋₀	54.0 ^{+1.5} ₋₀	12.5 ⁺⁰ _{-1.5}	28.5 ^{+1.5} ₋₀	15R	38R	108R										
	163	57	21 ⁺¹ ₋₀																	175	

16. a) **MARKING** : Manufacturer's initial in 6mm. raised type.
b) **PACKING** : Material in loose / packed in gunny bags.
c) **REMARKS.**

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