



**QM-C-7.1/NYLON FRP/0006**  
**Inspection Plan(Check Sheet)**

**Item:** Self lubricating Polyester Resin based composite brake gear bushes to be used in main line coaches(BG)  
**Specn. :** C-K605 (Rev.1 of Aug'2009 )  
**Amd.:** 1 of Mar'2010  
**Drg. No. & Alt.:** SK-81039, Alt.12

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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



## SUMMARY OF RESULT

Sample Planning for Acceptance Tests:-

Lot size	First Sample	Second Sample	Acceptance Criterion	
			First Sample	Second Sample
Every 2500 Nos. or part thereof	125	250	NIL Rejection	NIL Rejection

Sl.No. of specn C-K 605	Parameters	Specific Value	Quntun of check	Observation	
				OK	NOT OK
4.2.3.i	Visual Check		125 Nos/lot		
4.2.3.ii	Dimensional Check	By GO-NO GO Gauges	10 Nos/lot		
4.2.3.iii	Specific Gravity	1.60 - 1.68	5 Nos/lot		
4.2.3.iv	Ash Content	22 – 27 %	5 Nos/lot		
4.2.3.v	Ring Crushing Test	Load when compressed to half of original O.D is 75% or more than Load supported at yield point	5 Nos/lot		
4.2.3.vi	Rockwell Hardness(M)	75 Min	5 Nos/lot		

Note:- 10samples shall be drawn at random from each lot. Out of these, 5 no shall be tested for hardness as per ISO 2039-2 and appendix 2 of spec no. C-K605. Balance shall be tested for ring crushing test as per appendix 1 of the same spec. Density and ash content test shall be done as per table-1 of the spec.on bushes passing the ring crushing test.

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4.2.3.(ii) Dimensional Check :  
Specific Sample Size as per sampling plan-10Nos/lot  
Actual sample size/lot

Lot No.	Parameters	01	02	03	04	05	06	07	08	09	10
	OD										
	ID										
	LENGTH										
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	LENGTH										
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