



QM-C-7.1/POLYMER/0003
Inspection Plan(Check Sheet)

Item : Injection Moulded Thermoplastic Polyester Elastomer (Hytrel)
Axle Box Front Cover for MG & BG Main Line & EMU Coaches
Specn. : RDSO/2007/CG-07, Rev.1 of Sep'2012
Amd. :
Drg. No. & Alt. : CG-K7131, Alt.-1

1. Firm's Name
2. Description of material
3. Drg.No.
4. RDSO File No.
5. Specification No.
6. Purchase order No.
7. Firm's offer letter No. & Date
8. Quantity earlier passed
9. Quantity now offered
10. Quantity consumed in testing
11. Quantity accepted
12. Quantity rejected
13. Date of Inspection & Testing
14. Date of offer
15. i) No. of Boxes
ii) Continuous Sl.No. of boxes
16. D.P.

(A) This is guaranteed by M/s.that
reconstituted recovered material

Signature of Firm's Representative

Signature of RDSO Representative



A. Samples Size for Metallic Bushes:

The above sample size for each lot is 2000 Nos. or part thereof.

The metallic bush fitted on Axle box front cover shall conform to IS: 2062-2011 E 250A. The metallic bush will be accepted on the basis of WTC for each stage i.e. chemical composition, galvanization thickness etc.

B. Record of test result for Metallic Bushes for a lot of 2000 Nos.

Sl. No.	Description of Test	Specified value as per RDSO/2007/CG-07	Lot No.1	Lot No.2	Lot No.3	Lot No.4	Lot No.5
1.	Visual Observation (5% of lot or min 20 Nos.)	Surface shall be smooth, & free from moulding defect					
2.	Dimension as mentioned in Drg. (min 5% of lot or min 20 Nos.)						
	27±0.5						
	21.5±0.25						
	27.5±0.50						
	42.0±0.50						
	3.0±0.1						

Note: - The metallic bush will be picked up every year by inspecting authority and will be tested outside reputed laboratory for chemical composition and galvanizing coating thickness. The testing charges will be borne by the firm.

Signature of Firm's Representative

Signature of RDSO Representative



A. Samples Size for Axle Box Front Cover:

a	Visual Inspection	10% of the lot or min. 10 Nos.	
b	Dimensional check, Tightening Test and product weight	5 samples shall be drawn at random from each lot	
c	Specific Gravity	5 samples shall be drawn at random from each batch/lot. Out of these samples selected 2 nos. shall be tested for each test except impact and resistance to spread of flame. The impact and resistance to spread of flame shall be carried out on one sample.	
d	Hardness		
e	Ash Content		
f	Melting Point		
g	Impact Test		
h	Pull Out Test		
i	Resistance to spread of flame		
j	Compressive strength		
k	Shower Test		Shall be carried out at the time of approval/renewal of the firm.

Signature of Firm's Representative

Signature of RDSO Representative



B. Record of test result for a lot of 500 Nos. or part thereof.

Sl. No.	Description of Test	Specified value as per RDSO/2007/CG-07(Rev.1)	Lot No.1	Lot No.2	Lot No.3	Lot No.4	Lot No.5
1.	Visual Observation (10% or 10 Nos.)	Surface shall be smooth & free from moulding defects. Edges shall be neatly finished and free from flash.					
2.	Dimension as mentioned in Drg. mm						
	Ø 324±2						
	Ø 290+0.50/-0.25						
	Ø 264±2						
	Ø 248±2						
	R 380±2						
	22±0.25						
	Ø 9.5±0.25						
	6.5 +1/-0						
	3±0.1						
	104±2						
	60 +0/-0.5						
	9±0.25						
	34±0.5						

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3	Specific Gravity	1.30±0.05					
4	Melting Point °C	219±8 °C					
5	Hardness	70±5 D					
6	Ash Content	Less than 1%					
7	Weight with 4 Nos. Metallic Bush	2692±30 gms					
8	Impact Strength Test	6.125 Kg-m (min)					
9	Pull out test with bush	900 kgf (min)					
10	Tightening test on lugs	12 kg-m (min)					
11	Resistance to spread of flame	Shall pass					
12	Compressive strength	3000 kg (min)					
13	Shower test	Shall pass	Shall be carried out at the time of approval/renewal of the firm				
14	Resistance to grease test at 140±5 C for 48 hrs	No change in hardness	Type test as per para 6.2 of section A of RDSO Spec. RDSO/2007/CG-07 (Rev.1)				

C. Marking (As per clause 8.1 of Spec.): OK/NOT OK

D. Packing (As per clause 9.1 of Spec.) : OK/NOT OK

E. Storage As per clause 10 of Spec.) : OK/NOT OK

Signature of Firm's Representative

Signature of RDSO Representative