



QM-C-7.1/Rubber/0005
Inspection Plan(Check Sheet)

Item: Centre Pivot Rubber Bush for WDP1, WDG3A
Specn. :
Amd.:
Drg. No. & Alt.: SKVL-266, Alt.-3
(Item-2 of Drg. No. SKVL-028A, alt.7 & SKVL-128, Alt.6)

-
1. Name of Component :
 2. Firm's Name :
 3. Date (Period) of Inspection :
 4. Contract Details
a) Purchase Order No. & Date :
b) Order placing Authority :
c) Specification No. as P.O. :
d) Drawing No. as per P.O. :
 5. Quantity on Order :
 6. Quantity offered for Inspection :
 7. Consignee :
 8. Validity of D.P. of P.O. :
 9. Remarks on adherence to firm's QAP. :
 10. Remarks on calibration of Measuring Instruments & Testing Facilities. :
 11. Remarks on availability of latest copies of Specification & Standards referred. :

Signature of firms Representative

Signature of Inspecting Official of RDSO

**SUMMARY OF RESULTS**

Clause	Parameter	Specified Value	Observation /Remarks	
5.3	Metal Component	Material shall be as per specification		
5.4	Method of moulding	Injection moulding		
	Bonding of rubber with sleeves	Rubber to be bonded both with outer & inner sleeves		
5.5	Visual checks	No sharp edges and burrs on metal sleeves		
		Rubber shall be free from pin holes, blisters and other visual flaws		
5.6	Identification marks	Firms name/ Code, year & month of manufacturer to be marked on inner sleeves as per RDSO drawings		
			Max	Min
5.7	Dimensional checks	As per drawing no. indicated in P.O.		
5.8 (A)	Physical properties before aging			
	Tensile strength	180 kg/cm ² (min)		
	Elongation at Break	450% Min		
	Compression set	25% max		
5.8 (B)	Physical properties after aging			
	Tensile strength	23%		
	Elongation at Break	+10/-30% Min		
	Hardness(shore A)	+7/-0 units		
5.9	Compressive Load-Deflection test (In X-X direction)			
	Difference of deflections at 8500 kg & 2000 kg	1.90 to 2.00 mm		
	Maximum compressive load (17000 kg)	No rubber cracks or bond failure permissible		
	Torsional test for 5°Rotation in Clockwise & anti clockwise direction	No rubber cracks or bond failure permissible		

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Clause wise details of checks

5.1 Lot Size:

Specified lot size: 50 nos or part thereof

5.2 Specifications of metal components:

Whether metal properties confirm to specifications as per test certificates:

5.3 Method of moulding (If injection moulding used or not):

Whether Rubber to be bonded both with metal sleeves (i.e. Inner & outer):

5.5 Visual Check:

Specified sample size: 20% of lot

Actual sample size:

Bush No.	1	2	3	4	5	6	7	8	9	10
Metal Sleeves										
Rubber										

5.6 Identification Marking:

Specified sample size: 20% of lot

Actual sample size:

Bush No.	1	2	3	4	5	6	7	8	9	10
Yes/No										

5.7 Dimensional checks:

Specified sample size: 20% of lot

Actual sample size:

Bush No.	1	2	3	4	5	6	7	8	9	10
Dimensions (refer drawing indicated in P.O.)										

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5.8 (A) Physical properties before ageing

Specified sample size: 4 nos (Test slabs)

Actual sample size:

I. Tensile Strength

Parameters	Specified Value	1			2			3			4		
		a	b	c	a	b	c	a	b	c	a	b	c
Load at break (kg)													
Tensile Strength (kg/cm ²)	180 kg/cm ²												
Mid value (kg/cm ²)													

2. Elongation at Break

Parameters	Specified Value	1			2			3			4		
		a	b	c	a	b	c	a	b	c	a	b	c
Load at break (kg)													
Elongation (%)	450% min.												
Mid value (%)													

3. Compression set

Parameters	Specified Value	1			2			3			4		
		a	b	c	a	b	c	a	b	c	a	b	c
Thickness after ageing													
Compression set	25% max.												
Average													

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5.8 (B) Physical properties after ageing

Specified sample size: 4 nos (Test slabs)

Actual sample size:

I. Tensile Strength

Parameters	Specified Value	1			2			3			4		
		a	b	c	a	b	c	a	b	c	a	b	c
Load at break (kg)													
Tensile Strength (kg/cm ²)	±23%												
Mean value(kg/cm ²)													

2. Elongation at Break

Parameters	Specified Value	1			2			3			4		
		a	b	c	a	b	c	a	b	c	a	b	c
Load at break (kg)													
Elongation (%)	+10/-30%												
Mean value (%)													

3. Hardness

Parameters	Specified Value	1			2			3			4		
		a	b	c	a	b	c	a	b	c	a	b	c
Variation in hardness													
Average	+7/-0												

5.9 Compressive Load-Deflection Characteristic:

Sr	Parameters	Specified value	1	2	3	4	5
1	2000 to 8500 kg	1.900 to 2.00 mm					
2.	17000 kg	No rubber cracks or bond failure					

Torsional test

Parameters	Specified value	1	2	3	4
Anti clock wise Torsion	5°Rotation				
Clock wise Torsion	5°Rotation				

Signature of firms Representative

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