



**QM-C-7.1/RUBBER/0008**  
**Inspection Plan(Check Sheet)**

**Item** : RF-8 Rubber Spring  
**Specn.** : 55-BD-90  
**Amd.** : 3 of Sep'93  
**Drg. No. & Alt.** : WD-90076-S-01, Alt.01

- 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 :

QUALITY CONTROL MANAGER OF M/S

INSPECTING OFFICIAL OF RDSO



**SUMMARY OF THE RESULTS**  
**LOT SIZE 1500 Nos.**

S.NO.	PARAMETERS	SPECIFIED VALUE	OBSERVATIONS	
			Max.	Min.
7.1	Visual Check	Free from elastomer film, crack, foreign material trapped air, marking.		
7.2	Dimensional Check	By go – No go gauges		
7.3	<b>Physical Properties before ageing</b>	To be done every quarter & should meet the requirements given at the time of approval. Values for these physical properties should be as per firm's approved QAP.		
	Hardness			
	Tensile Strength Kg/cm <sup>2</sup>			
	Tear Strength Kg/cm			
	Tensile strength at 100% elongation Kg/cm <sup>2</sup>			
	Tensile strength at 300% elongation Kg/cm <sup>2</sup>			
	Compression set			
	Specific Gravity			
	<b>Physical properties after ageing at 70 deg. C for 72+0/-2 hrs.</b>			
	<b>Change in properties</b>			
	Hardness	+7/-0 Shore A		
	Tensile Strength	± 25%		
	Elongation at Brea	+ 10% - 30%		
	i) Static test	Compress to a height of 37mm. No bond failure, chunks, cracks & bubbles & must return to height of 61mm within one minute.		
	ii) Static test as per drg. No. : WD-90076-S/04	Must confirm the requirements given in drawing No; : WD-90076-S/04		
	Cyclic endurance test	1000 cycles at a rate of 10 sec. per cycle		

QUALITY CONTROL MANAGER OF M/S

INSPECTING OFFICIAL OF RDSO



**7.1 Visual Check :**

Specified Sample Size – 30 Nos.

Actual Sample Size.

<b>Pad No.</b>	<b>1</b>	<b>2</b>	<b>3</b>	<b>4</b>	<b>5</b>	<b>6</b>	<b>7</b>	<b>8</b>	<b>9</b>	<b>10</b>
<b>Visual check</b>										
<b>Pad No.</b>	<b>11</b>	<b>12</b>	<b>13</b>	<b>14</b>	<b>15</b>	<b>16</b>	<b>17</b>	<b>18</b>	<b>19</b>	<b>20</b>
<b>Visual check</b>										
<b>Pad No.</b>	<b>21</b>	<b>22</b>	<b>23</b>	<b>24</b>	<b>25</b>	<b>26</b>	<b>27</b>	<b>28</b>	<b>29</b>	<b>30</b>
<b>Visual check</b>										

**7.2 Dimensional Check :**

Specified Sample Size – 30 Pads.

Actual Sample Size.

<b>Pad No.</b>	<b>1</b>	<b>2</b>	<b>3</b>	<b>4</b>	<b>5</b>	<b>6</b>	<b>7</b>	<b>8</b>	<b>9</b>	<b>10</b>
<b>Dimension</b>										
<b>Pad No.</b>	<b>11</b>	<b>12</b>	<b>13</b>	<b>14</b>	<b>15</b>	<b>16</b>	<b>17</b>	<b>18</b>	<b>19</b>	<b>20</b>
<b>Dimension</b>										
<b>Pad No.</b>	<b>21</b>	<b>22</b>	<b>23</b>	<b>24</b>	<b>25</b>	<b>26</b>	<b>27</b>	<b>28</b>	<b>29</b>	<b>30</b>
<b>Dimension</b>										

**7.3 Physical Properties before ageing: Test has to be carried out at every quarter year & specified values should be the values at the time of approval. Values for these physical properties should be as per firm's approved QAP.**

**Date of last test done:**

**Result OK / NOT OK**

Specified Sample Size – 1 pad (Nos. of measurements per pad-3)

Actual Sample Size -

Hardness on dumb bells: Shore 'A'

<b>Parameters</b>	<b>Specified Value</b>	<b>1</b>	<b>2</b>	<b>3</b>
Hardness – Shore 'A'				
Mid Value				

**7.3.1 Tensile Strength:**

<b>Parameters</b>	<b>Specified Value</b>	<b>1</b>	<b>2</b>	<b>3</b>
Load at break				
Tensile strengths (min)				
Mid Value				

**QUALITY CONTROL MANAGER OF M/S**

**INSPECTING OFFICIAL OF RDSO**



**Tear Strength:**

Parameters	Specified Value	1	2	3
Load at break				
Tear strengths				
Mid Value				

**Tensile Strength at 100% elongation :**

Parameters	Specified Value	1			2			3		
Load at Kg.										
Tensile strengths (min)										
Mid Value										

**Tensile Strength at 300% elongation:**

Parameters	Specified Value	1	2	3
Load at Kg.				
Tensile strengths (min)				
Mid Value				

**Compression Set :**

Parameters	Specified Value (in mm)	1	2	3
Thickness after aging				
Compression set				
Mid Value				

**Specific Gravity:**

Specified Sample Size – 1 Pad (Nos. of measurement per pad-3)

Actual Sample Size –

Parameters	Specified Value	1	2	3	4	5
Specific Gravity						

QUALITY CONTROL MANAGER OF M/S

INSPECTING OFFICIAL OF RDSO



**Percentage Change in Physical Properties after ageing:**

Specified Sample Size – 1 Pad (Nos. of measurements per pad-3)

Actual Sample Size –

Parameters	Specified Value	1	2	3
Hardness	+7/-0 Shore A			
Mid Value				

Parameters	Specified Value	1	2	3
Tensile Strength	± 25%			
Mid Value				
Elongation at break	+10/-30%			
Mid Value				

**i) Static Test:**

Specified Sample Size: 10 Pad

Actual Sample Size –

Parameter	Specified Value	1	2	3	4	5	6	7	8	9	10

**ii) Static Test:** Should meet the requirements given in drg. No. WD-90076-S/04

Parameter	Specified Value	1	2	3	4	5	6	7	8	9	10
Height after 4 <sup>th</sup> compression	Height 61mm (min)										
Visual	No bond failure, cracks or visual defects.										

**Plot graphs in accordance with drg. No. WD-90076-S/04**

Cyclic endurance test: 1000 cycles @ 10 sec. per cycle.

Specified Sample Size: 1 Pad

Actual Sample Size: 1 Pad

Parameter	Specified Value	1
Cyclic Endurance	Compress 50mm to 37mm	
After Cyclic endurance	Height after 1 minute	
After Cyclic endurance	Height after 24 hour	

**QUALITY CONTROL MANAGER OF M/S**

**INSPECTING OFFICIAL OF RDSO**