



QM-C-7.1/Rubber/0010
Inspection Plan(Check Sheet)

Item : Elastomeric Pads
Specn. : 20-Misc-95, Rev.3 of Mar'2003
Amd. : 5 of July'2013
Drg. No. & Alt. : WD-95005-S-01, Alt.07

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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REVISION 2

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SUMMARY OF RESULTS

Sl.No.	Parameters	Specified value	Observation	
			Max.	Min.
7.1	Visual check			
7.2	Dimensional check	By Go-NoGo gauge		
7.3	Physical Properties			
	a) Tensile Strength	225 Kg/cm ²		
	b) Elongation at Break	400 %		
	c) Compression Set	20 %		
	d) Hardness Shore A	72 Max.		
7.4	Compressive Load Deflection			
	a) At 10 t	2.0 ± 20 % (1.60-2.40)		
	b) At 15 t	2.8 ± 20 % (2.24-3.36)		
	c) At 20 t	3.4 ± 20 % (2.72-4.08)		
7.5	Shear Load Deflection			
	a) At 1 t	1.9 ± 20 % (1.52-2.28)		
	b) At 2 t	3.8 ± 20 % (3.04-4.56)		
	c) At 3 t	5.7 ± 20 % (4.56-6.84)		
	d) At 4 t	7.6 ± 20 % (6.08-9.12)		
	e) At 5 t	9.5 ± 20 % (7.6-11.40)		
7.6	Shear Bond Strength	35.14 Kg/cm ² Min.		
7.7	Shear fatigue 5 lac cycles	Pad thickness 44.5 mm ±1.0 mm		
7.8	Specific gravity	1.22 Max.		
7.9	Ash Content	5 % Max.		
7.10	Metal Plate Examination	No Sharp Edges & Burrs		



7.1 Visual Check

Specified sample size- As per clause 4.2 or 4.2.1 of specification.

Actual sample size:

Pad No.	1	2	3	4	5	6	7	8	9	10	11	12	13	14
Visual Check														

7.2 Dimensional check

Specified sample size- As per clause 4.2 or 4.2.1 of specification.

Actual sample size:

Pad No.	1	2	3	4	5	6	7	8	9	10	11	12	13	14
155 – 158 in mm														
176 – 179														
173 – 174														
110 – 111														
152.5 – 154.5														
45 – 47														
178														
138 or as per approved Drg.														
31 Min.														
72 – 75														
8														
6 or as per approved Drg.														

7.3 Physical Properties: Specified sample size – As per clause 4.2 or 4.2.1 of specification.

Actual sample size:

A. Tensile Strength:

Parameters	Specified Value	1			2		
		a	b	c	a	b	c
Thickness							
Width							
Area							
Load at break							
Tensile Strength	225 Kg/cm ² Min.						

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Mid value			
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B. Elongation at break:

Parameters	Specified Value	1			2		
		a	b	c	a	b	c
Bench Length							
Length at break							
Elongation %	400 % min.						
Mid value							

C. Compression Set:

Parameters	Specified Value	1			2		
		a	b	c	a	b	c
Thickness before age.	6.00 – 6.60 mm						
Spacer Thickness							
Thickness after age.							
Compression set	20 % max.						
Average							

D. Hardness:

Parameters	Specified Value	1			2		
		a	b	c	a	b	c
Hardness Shore A.	72 Max.						

7.4 Compressive Load deflection characteristics :

Specified sample size- As per clause 4.2 or 4.2.1 of specification.

Actual sample size:

Load in tones	Specified deflection in mm								
10	1.60 – 2.40								
15	2.24 – 3.36								
20	2.72 – 4.08								



7.8 Specific Gravity :

Specified size- 0.25 % subject to min. 4 nos. Actual –

Specified value	1	2	3	4	5
1.22 Max.					

7.9 Ash content: Specified value – 5 % Max.

Specified size- 0.25 % subject to min. 4 nos. Actual –

Parameters	1	2	3	4	5
Wt. of Crucible					
Wt. of Crucible + Sample					
Wt. of Sample					
Wt. of Crucible + Ash					
Wt. of Ash					
Ash content %					

7.10 Metal Plate Examination: Specified value: No sharp edges & burrs

Specified size- 2 Nos. Actual –

Parameters	1	2	3	4	5
Metal Plate Examination					

7.11 A) Details of last process audit :

Date of Picking of samples	
Result of Test	
a) M&C Lab	b) Fatigue Testing Lab
i) Result : (Pass/ Fail)	i) Result : (Pass/ Fail)
ii) Report No.:	ii) Report No.:
iii) Date of Report:	iii) Date of Report:

B) Next audit due on:

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