



## QM-C-7.1/Spring/0007

### Inspection Plan(Check Sheet)

**Item:** Snubber Assembly for locomotives  
**Specn. :** Nil  
**Amd.:**  
**Drg. No. & Alt.:** SKDL-2089A

- 
1. Firm's Name :
  2. Date (Period) of inspection :
  3. Contract Details :
    - a) Contract No. and 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 :
  7. Delivery Period :

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**SUMMARY OF RESULTS OF SNUBBER ASSEMBLY**

SN	Parameters	Specified Value		Observations	
				Maxi.	Min.
	----- ----- ----- -----				
7.1	Visual check				
7.2	Dimensional check				
a)	Complete snubber				
	Free height	BG 462±6	MG 459±6		
b)	Friction sleeve with cap				
	Outer dia. (mm)	86+0/-0.5			
	Inner dia. (mm)	70+0/-0.5			
	Length (mm)	BG 260	MG 240		
	Cap thickness (mm)	13.5±0.5			
	Perpendicularity	±1/4°			
c)	Friction shoe				
	Length (mm)	240±1			
	Head (mm)	64±0.2			
	Body (mm)	56±0.18			
	Collar thickness (mm)	10±0.03			
d)	Friction shoe ring				
	Outer dia. (mm)	130±0.68			
	Inner dia. I (mm)	72±1			
	Outer dia. II (mm)	95±0.05			
	Thickness (mm)	11±0.06			
	R2 (mm)	2.0			
	R1 (mm)	3.0			
e)	Friction shoe shim				
	Outer dia. (mm)	35±0.5			
	Dia. (mm)	17±0.5			
	Sheet (mm)	1.6			
	Total height (mm)	7.6±0.5			
f)	Friction coil spring				
	Outer dia. (mm)	7.6±0.5			
	Free height (mm)				
	a)	48±0.5			
	b)	49±1			
	c)	52±1			
	Wire dia. (mm)				
	a)	7.1±0.05			
	b)	6.3±0.05			
	c)	5.5±0.05			

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7.3	<b>Hardness</b>			
	Friction sleeve with cap	50-52 RC		
	Friction shoe	293-341 BHN		
	Friction shoe ring	293-341 BHN		
7.4	<b>Load Deflection</b>			

**7.1 Visual check:**

Sample size: 5% or min. 10 nos.

Actual No. Of samples-

Sample	1	2	3	4	5	6	7	8	9	10
Observation										

**7.2 Dimensional check:**

Sample size: 5% or min. 10 nos.

Actual No. Of samples-

**a) Complete Snubber:**

Parameters (mm)	Specified		1	2	3	4	5	6	7	8	9	10
	BG	MG										
Free Height	462±6	459±6										

**b) Friction sleeve with cap:**

Parameters	Specified Value (mm)											
Outer dia.	86+/-0.5											
Inner dia.	70+/-0.5											
Length	260(BG)											
	240(MG)											
Cap thickness	13±0.25											
Coller thickness	±1/4°											

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**c) Friction shoe ring:**

Parameters	Specified Value (mm)	1	2	3	4	5
Outer dia.	130±0.68					
Inner dia. I	72±1					
Inner dia. II	95±0.5					
Thickness	11±0.6					
R2	2.0					
R3	3.0					

**Other parameters as per drawing are to be checked & verified from spring manufacturers' certificate.**

**d) Friction spring shim:**

Parameters	Specified Value(mm)	1	2	3	4	5
Outer dia.	35±0.5					
Depth	17±0.5					
Sheet	1.6					
R. Height	7.6±0.5					

**e) Friction Coil Spring:**

Parameters	Specified Value(mm)	1	2	3	4	5
Outer dia.(mm)	35±0.4					
Free height(mm)						
a)	48±0.5					
b)	49±1					
c)	52±1					
Wire dia.(mm)						
a)	7.1±0.05					
b)	6.3±0.05					
c)	5.5±0.05					

**7.3 Hardness:**

Item	Specified Value	1	2	3	4	5	6	7	8	9	10
Friction sleeve with cap	50-52 RC										
Friction shoe	293-341BHN										
Friction shoe ring	293-341 BHN										

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**7.4 Load deflection:**

Sample size: 1% or min 10 nos.

Actual Nos. Of samples-

SN	Load in Kg	Unloading	Loading	Specified d1-d2 to be between		Observe d d1-d2	Remarks
				BG	MG		
1.	1000			45&75	15&30		
	500			35&55	15&25		
	Release load*						
2.	1000			45&75	15&30		
	500			35&55	15&25		
	Release load*						
3.	1000			45&75	15&30		
	500			35&55	15&25		
	Release load*						
4.	1000			45&75	15&30		
	500			35&55	15&25		
	Release load*						
5.	1000			45&75	15&30		
	500			35&55	15&25		
	Release load*						

Release load for BG-1.25t to 1.8t

MG-2.4t to 2.8t

Despatch Memo No. For Coil Spring =

Date

Issued by-

(Ensure verification of original (DM))

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