



QM-C-7.1/AB/ 0012
Inspection Plan(Check Sheet)

Item : **K type Non-asbestos Composition Brake Block for Freight Stock
840 mm wheel dia.**
Specn : **WD-14-ABR-2007 (Amendment No.3 of Sept, 2016)**
Drg.No. &Alt : **SK-WD-15023-S-01 (Alt.Nil)**

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. Date of offering for inspection
5. Consignee
6. Delivery period

Quality Control Incharge of M/s.....

Inspecting Official of RDSO



SUMMARY OF RESULT

Lot size 2000 Nos.

(A) Periodical / Intermediate check

S.No.	Name of Test	Specified	Last test done	Next test due
1	Dynamometer	As per QAP approved by RDSO and WD-14-ABR-2007		

(B) Routine check:

*(routine check shall be conducted after ensuring the periodical/intermediate check is not over due)

(i) Ensure Clause 4.2.2(i),(ii), (iii) & 4.2.2.1

S.No.	Parameter	Specified value	Observation	
			Max	Min
1	Visual check	No surface cracks		
2	Dimensional check	As per drawing		
3	Physical properties			
	1. Compression Modulus	As per approved QAP		
	2. Cross breaking strength	As per approved QAP		
	3. Acetone extract	As per approved QAP		
	4. Ash content/Loss of ignition	As per approved QAP		
	5. Hardness	As per approved QAP		
	6. Density	As per approved QAP		
	7. Pull off Strength	As per approved QAP		

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Ministry of Railways
Research Designs & Standards Organization
Manak Nagar, Lucknow - 226 011

Item: K type Composition Brake block for freight stock(for 840mm dia wheel)					Sample size: 1%					Inspection Date				
S. No.	Criteria specified	Nominal Dim. (mm)	Measuring device	Gauge reference	1	2	3	4	5	6	7	8	9	10
1	Brake block length	300 (Min.)	Snap gauge											
2	Brake block width	80 (Min) 85 (Max)	Snap gauge											
3	Brake block thickness	58+2/ -0	Snap gauge											
4	Lug (middle stop) width	36+1/-2	Snap gauge											
5	Lug(middle stop) height	10±1	Snap gauge											
6	Inner distance between lugs	265+2/-0	Snap gauge											
7	Inner distance between cylindrical deep	100±1	Snap gauge											
8	Key hole width in clip	25±3	Snap gauge											
9	Key hole height in clip	22+1/-2	Snap gauge											
10	Key holder thickness	4±0.2	Snap gauge											
11	Key holder width top	38Min	Snap gauge											
12	Key holder width bottom	57Max	Snap gauge											
13	Key holder length	76±2	Snap gauge											
14	Wear limit	10	Vernier caliper											
15	Back plate radius	570±13	Snap gauge											

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S. No.	Criteria specified	Nominal Dim. (mm)	Measuring device	Gauge reference	1	2	3	4	5	6	7	8	9	10
16	Friction material radius	425 (Min)	Snap gauge											
17	Back plate thickness	4 \pm 0.2	Snap gauge											
18	Taper	1:20	Snap gauge											
19	Chamfer/Radius	R12 (Min)	Snap gauge											
20	Relief	1	Snap gauge											
21	Cylindrical lug height	7+1	Snap gauge											
22	Cylindrical lug dia	12 \pm 0.5	Snap gauge											
23	Depth of cylindrical hole	7+2	Snap gauge											
24	Cylindrical deep dia	15 \pm 0.5	Snap gauge											
25	Distance between Cylindrical lugs	180 \pm 1	Snap gauge											
26	Brake block weight (kg) :	As per Firm's Approved DRG./QAP	Weighing machine											
27	Marking on back plate	As per RDSO DRG. No. WD - 15023-S-01	Visual											

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Item- K TypeComposition BrakeBlock for freight stock		Specification: WD-14-ABR-2007		Quantity checked Sample size						Inspection call No. Inspection date			
S.No.	Test	Unit	Specified value as per QAP	1	2	3	4	5	6	7	8	9	10
1.	Compression Modulus	N/mm ²											
2.	Cross breaking strength	Kg/cm ²											
3.	Acetone extract	%											
4.	Ash content	%											
5.	Hardness (Rockwell)	HRX											
6.	Density	Gm/cc											
7.	Back plate pull off strength	Ton											

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