



QM-C-7.1/CRF/0002
Inspection Plan(Check Sheet)

Item : Body End Arrangement, Body Side Arrangement, Flap
Door Arrangement for BOXNR Wagon
Spec. : WD – 16– BOXNR – 2010
Drg.No. : WD-07001-S-10 Alt.08, WD-07001-S-08 Alt.09, WD-
09081-S-01 Alt.Nil

Firm's Name:

Product Description:

1. Date (period) of Inspection:

2. Contract Details:

- a. Contract no. and Date:
- b. Order Placing Authority:
- c. Specification no.:
- d. Drawing no. :

3. Quantity on order:

4. Quantity offered for inspection:

5. Quantity already passed for this contract:

6. Raw Materials Test details:

- a. Date of final product test for physical properties:
- b. Name and details of Test House:
- c. Result of last test (verify from certificate):
- d. Last audit conducted:

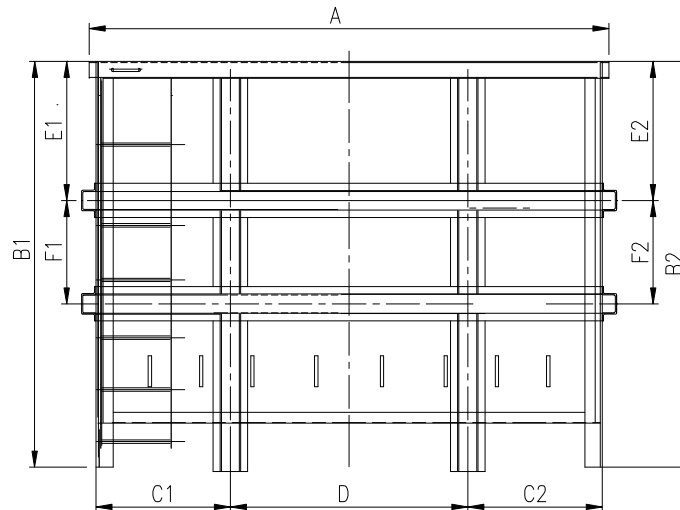
7. Sample Size: 10% or 5 nos. whichever is more

- a) Total Qty. :
- b) No. off tested :



(A) ITEM - BODY END ARRANGEMENT

Drg. No. WD-07001-S-10



BODY END NO:			Date:	
SL. NO.	STAGE	Works Inspection	Inspecting Authority	Remarks
1.	Fitment of all components			
2.	Welding	Check quality of welding Visually. If required check with welding gauge		
3.	Dressing			
4.	Dimensions	As Under		
	LOCATION	Nominal Dimensions & Allowable Deviation (in mm)	Actual Dimension	Remarks
i.	Width over corner bend angle	A	3176±3	

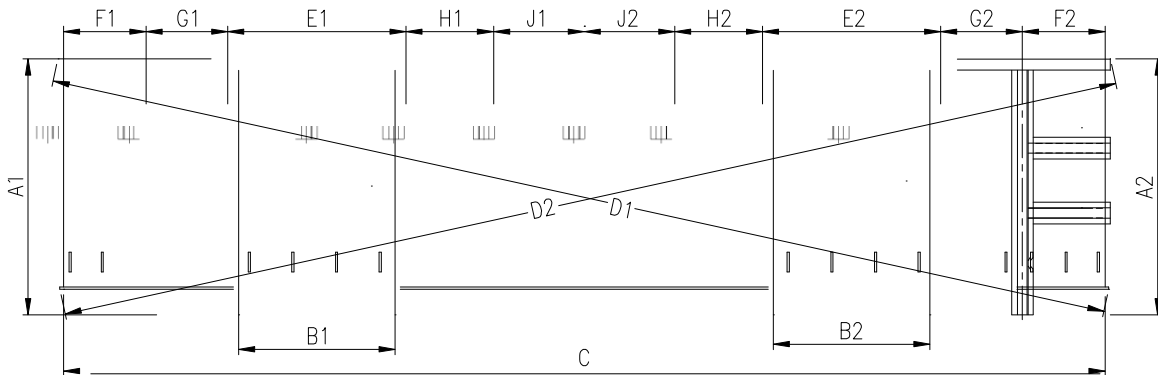


ii.	End Wall overall height	B1	2377±3		
		B2			
iii.	Distance between corner angle to centre of outer stanchion	C1	968±1.5		
		C2			
iv.	Distance between centre of inner to inner stanchion	D	1044±1.5		
v.	Distance between end top coping top to end wall middle coping centre (upper)	E1	756±1.5		
		E2			
vi.	Distance between two end wall middle coping	F1	661±1.5		
		F2			
5.	Product Identification	As per clause 6.0 (i) of WD – 16 – BOXNR – 2010			



(B) ITEM- BODY SIDE ARRANGEMENT

Drg No. WD-07001-S-08



BODY SIDE NO:		Date:		
SN	STAGE	Works Inspection	Inspecting Authority	Remarks
1.	Fitment of all components			
2.	Welding	Check quality of welding visually. If required check with welding gauge		
3.	Dressing			
4.	Dimensions	As Under		
	LOCATION		Nominal Dimensions & Allowable Deviation (in mm)	Actual Dimension
i.	Side Wall Overall Height	A1	2371±3	
		A2		
ii.	Door opening	B1	1460+0/-3	
		B2		
				Remarks

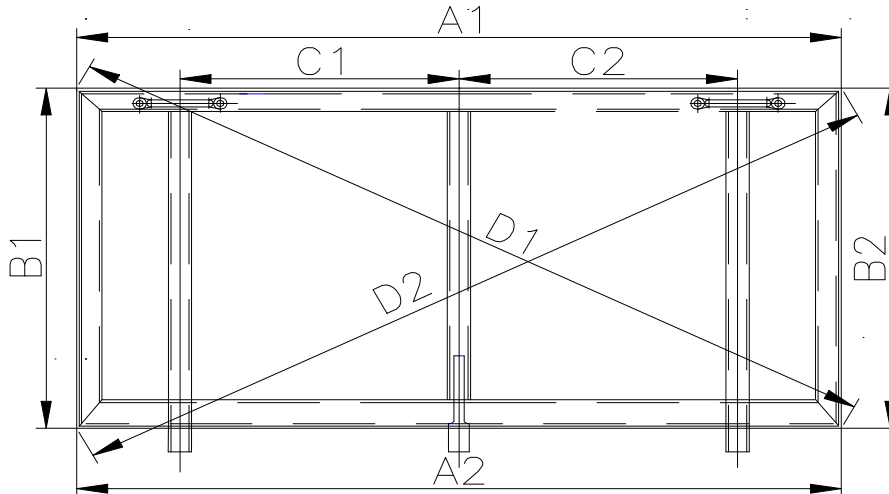


iii.	Distance between side plate end to end	C	9710+7/-3		
iv.	Diagonal difference over corner	D1	≤ 5		
		D2			
v.	Distance between stanchion centre at doorway	E1	1661 \pm 3		
		E2			
vi.	Distance between door way stanchion centres to dummy quarter	H1	832 \pm 3		
		H2			
vii.	Distance between side plate end line to 1st Stanchion centre	F1	733 \pm 3		
		F2			
viii.	Distance between 1st Stanchion centre to 2nd Stanchion centre	G1	799 \pm 3		
		G2			
ix.	Distance between centre stanchion to dummy quarter stanchion (centres)	J1	830 \pm 3		
5.	Product Identification	As per clause 6.0 (i) of WD – 16 – BOXNR – 2010			



(C) ITEM - FLAP DOOR ARRANGEMENT

Drawing No. WD-09081-S-01



FLAP DOOR NO:			DATE:	
S L.	STAGE	Works Inspection	Inspecting Authority	Remarks
1.	Fitment of all components			
2.	Welding	Check quality of welding visually. If required check with welding gauge		
3.	Dressing			
4.	Dimensions	As Under		
	LOCATION		Nominal Dimensions & Allowable Deviation (in mm)	Actual Dimension
i.	Overall Length	A1	1480+5/-0	
		A2		



ii.	Overall height	B1	777+3/-0		
		B2			
iii.	Distance between door C.L to C.L of door hinge	C1	540±1.5		
		C2			
iv	Diagonal difference over corner	D1	≤ 3		
		D2			
5.	Product Identification	As per clause 6.0 (i) of WD – 16 – BOXNR – 2010			



(D) Process Check-

Remarks of the Inspector

- (I) Verification of :-
- (a) Raw Material (Records)-
- Receipt particulars
 - Stacking of raw material
 - Tested material composition
 - Issue of material
 - Traceability to be maintained up to final stage & piece
- (b) Preparatory Work (Visual & Review of records)-
- Material Identification
 - Stacking, Colour coding & lot no.
- (c) Bought out items (Visual & Review records)-
- C. R. F. Sections
 - Welding Electrodes/Wires
- (II) Checking during Fabrication - (OK/ NotOK)
(if any manufacturing process is going on during the visit of inspector)
- Edge preparation
 - Fixing on fixture
 - Welding quality
 - Material identification
- (III) Periodical verification - (6 monthly)
- Jigs, Fixtures, Templates etc. for dimensional accuracy, general condition & identification
 - Welders for performance, qualification & training