



QM-C-7.1/Casting/0004/A
Inspection plan(Check Sheets)

Item: 30Kj Long life side buffer assembly of locomotive
Specn. : MP-0.41.00.03, Rev.01 of August 2005
Drg. No. : SKDL-4748ALT – 1

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 earlier passed
6. Quantity offered for inspection on date
7. Consignee
8. Delivery period

Quality Control Incharge of M/s..... Inspecting Official of RDSO



Govt. of India
Ministry of Railways
Research Designs & Standards Organisation
Manak Nagar, Lucknow-226 012

CHEMICAL AND PHYSICAL REPORT

HEAT NO.	ITEM	CHEMICAL ANALYSIS					HEAT TREATMENT BATCH NO	MECHANICAL AND PHYSICAL REPORT						ASTM GRANE SIZE NO.	HARD NESS
		C% 0.25 max	Mn% 1.20 max	Si% 0.60 max	S% 0.035 max	P% 0.040 max		YS Mpa 280	UTS Mpa 520	EL% 18	RA% 25	BEND AT 60 DEGREE	IMPACT IN JOULES 22		
	Buffer Plunger														
	Buffer Casing														
	Buffer base														
	Check Sleeve	0.50- 0.60	0.80- 1.00	1.50- 2.00	0.050	0.050									235-241 BHN

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DIMENSIONAL CHECK SHEET
LONG LIFE LOCO SIDE BUFFER (BG) ASSEMBLY TO IRS DRG. NO.SKDL – 4748 ALT – 1

01. Buffer Plunger SK.DL-4562 Alt-2 Material Specification IS-1030 GR. 280-520 W										
DRG. DIMENSIONS	OBSERVED DIMENSION									
I.D. 174 - 0.8/-0.3										
O.D. 203 - 0.8/-1.3										
I.D. 194 + 0.0/-0.4										
FLANGE THICKNESS 19mm										
LENGTH FROM COLLAR 432+0.25 / -0.00										
THICKNESS FROM COLLAR TO FLANGE 60±0.3										
FLANGE DIA 457 ± 2										
OVER ALL LENGTH 492 ± 2										
SLOT 25+0.4/+0.8										
SLOT 19-0.4/-0.8										
SLOT-13.00										

02. Buffer Casing SK.DL-4563 Material Specification : IS-1030 GR. 280 – 250 W										
DRG. DIMENSIONS	OBSERVED DIMENSION									
I.D. 203 + 0.51 /- 0.00										
I.D. 216 + 0.51 /- 0.00										
DIA 244 ± 2										
DIA 238 ± 2										
OVER ALL LENGTH 370 ± 2										
COLLAR 25 ± 2										
SQUARE 274 x 274 ± 2										
CRS 210 ± 0.2										
4 HOLE DIA 17 ± 0.2										
4 HOLE DIA 29 ± 0.2										
FLANGE THICKNESS 16±1										
LENGTH - 186.00										

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03. Buffer Base SK.DL – 4564 ITEM – 1 ALT – 1 Material Specification – IS – 1030										
DRG. DIMENSIONS	OBSERVED DIMENSION									
THICKNESS 16 ± 1										
SQUARE 274 x 274 ± 2										
CRS 210 ± 0.2										
BOSS DIA 98 ± 1										
BOSS INNER DIA 44±0.5										
HOLE DIA 17±0.2										
HOLE DIA 29±0.2										
BOSS HEIGHT 15.00										

04. Check Sleeve L/BD-655/M ALT.6 Material Specification : Spring Steel – IS-3885 Pt.I										
DRG. DIMENSIONS	OBSERVED DIMENSION									
I.D. 203 ± 0.8										
O.D. 216 – 0.8 /-1.0										
I.D. 194-0.0/+0.4										
HEIGHT 57±1										
GROVE 25 – 0.0 /- 0.4										
GROVE 19+0.0 / +0.4										
GAP IN POSITION 3mm										

05. LOCO SIDE BUFFER ASSEMBLY DRG. NO. – SKDL – 4748 ALT – 1										
DRG. DIMENSIONS	OBSERVED DIMENSION									
TOTAL HEIGHT 635 +2/- 1.5										
STROKE 105 mm										

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MARKING ON COMPONENTS

Marking on components were checked and found to be legible and as per drawing.

DIMENSIONAL CHECK

Components of two assemblies were dimensionally checked and were found acceptable.

RADIOGRAPHY TEST

Follow the Para 6.1 of Specification No. MP-0.41.00.03, Rev.01 of August 2005

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LIQUID DYE PENERTRATION EXAMINATION

(Long life side buffer assembly of locomotive)

Place of testing :
Testing date & place :
Job description :
Testing Location :
Developer :
Cleaner :
Penetrant :
Observation :
Remarks :
Tested by :

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