



**QM-C-7.1/Casting/0004/B**  
**Inspection Plan(Check Sheet)**

**Item:** 15 KJ High Capacity Loco Side Buffer Assembly  
**Specn. :** MP-0.41.00.03, Rev.01 of August 2005  
**Drg. No. & Alt.:** SKDL-4725, Alt.NIL

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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



**CHEMICAL AND PHYSICAL REPORT**

HEAT NO.	ITEM	CHEMICAL ANALYSIS					HEAT TREATMENT BATCH NO	MECHANICAL AND PHYSICAL REPORT						ASTM GRANE SIZE NO.	HARDNESS
		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		
	Buffer Plunger, Buffer Casing, Buffing Washer														
	Buffer Plunger Plug	0.15-0.25	0.60-0.90	0.15-0.35	0.050	0.050									
	Buffer Spindle	0.40-0.50	0.60-0.90	0.15-0.25	0.050	0.050									
	Washer	0.20	1.5	0.40	0.040	0.040									



**DIMENSIONAL CHECK SHEET**  
**LOCO.SIDE BUFFER (BG) ASSEMBLY TO IRS DRG. NO. SK.DL-4725 ALT-NIL**

01. Buffer Plunger W/BD-359 Material Specification IS-1030 GR. 280-520 W										
DRG. DIMENSIONS	OBSERVED DIMENSION									
I.D. 184 +1/-0										
O.D. 202 +0/-0.5										
Length 350 ± 1.2										
LENGTH 452± 2										
FLANGE DIA 460 +2.0/-0										
WALL THICKNESS 9 + 0.0/-0.75										
FLANGE THICKNESS 19mm ± 2										

02. Buffer Casing W/BD-392 Material Specification : IS-1030 GR. 200 – 400 W										
DRG. DIMENSIONS	OBSERVED DIMENSION									
I.D. 203 + 0.50 /- 0.00MM										
O.D. 241 ± 3MM										
LENGTH OF BASE 445 +0/-3										
WIDTH OF BASE 229 ± 4.5										
CENTRE HOLE DIA 45 ± 0.8										
FLANGE THICKNESS 19+2/-0										
LENGTH - 406.00 ± 2.0										
COLLAR 25± 2										



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**Research Designs & Standards Organisation**  
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<b>03. BUFFER SPINDLE W/BD-353 ITEM – 3 Material Specification : IS – 1875 CL4</b>										
<b>DRG. DIMENSIONS</b>	<b>OBSERVED DIMENSION</b>									
DIA 40 +0.8/-0										
THREADING M39x3										
THREAD LENGTH 102 ± 1.2										
SLOT LENGTH 22X10										
SLOT DEPTH 11*										

\* To be verified on separate spindle of same lot, not in assembled condition.

<b>04. BUFFER PLUNGER PLUG W/BD-374 ALT – 4 Material Specification : IS – 1875 CL-2</b>										
<b>DRG. DIMENSIONS</b>	<b>OBSERVED DIMENSION</b>									
WIDTH OF KEY 21+0.0/-0.5										
HEIGHT 11 +0.0/-0.5										
THICKNESS 19 +0.0/-1.0										

<b>05. RECOIL SPRING PARTING PLATE W/BD-2253 : IS – 2062</b>										
OD 110 ± 0.8MM										
ID 42 ± 0.8MM										
THICKNESS 3.15 +0.37/-0.16										

<b>06. RECOIL SPRING WASHER W/BD-350 : IS – 2062</b>										
OD 110 ± 0.8										
OD 42 ± 0.8MM										
THICKNESS 12 +0.9/-0.6										

<b>07. RECOIL SPRING W/BD-2252</b>										
OD 102± 0.8MM										
OD 42 ± 0.8MM										
THICKNESS 22 ± 1MM										



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<b>08. RUBBER BUFFER SPRING SK.DL. – 4565</b>										
<b>DRG. DIMENSIONS</b>	<b>OBSERVED DIMENSION</b>									
OUTER DIA 168										
INNER DIA 42+1.0/-0										
THICKNESS 112 ±1										
PLATE THICKNESS 5										
GAP BETWEEN PLATES 16.5 ±1										

<b>09. BUFFING WASHER SK.DL. – 4564 ITEM– 4ALT – 1 Material Specification : IS – 1030</b>										
<b>DRG. DIMENSIONS</b>	<b>OBSERVED DIMENSION</b>									
OUTER DIA 170										
INNER DIA 100										
INNER DIA 44										
THICKNESS 25										
THICKNESS 15										
TOTAL THICKNESS 135										
DEPTH 15										
DIA 79										
RIB THICKNESS 13										

<b>10. WASHER SK.DL. – 4564 ITEM– 3 ALT – 1 Material Specification : IS – 2062</b>										
<b>DRG. DIMENSIONS</b>	<b>OBSERVED DIMENSION</b>									
OUTER DIA 168										
INNER DIA 89										
THICKNESS 20										
THICKNESS 12										
THICKNESS 8										



LOCO SIDE BUFFER ASSEMBLY DRG. NO. – SKDL – 4725 ALT – NIL										
DRG. DIMENSIONS	OBSERVED DIMENSION									
TOTAL HEIGHT 635 +2/- 1.5										
STROKE 110mm										
ASSMBLY PLUNGER DIA 460 ±2										
FLANGE THICKNESS 19± 2										

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## HAMMERING TEST REPORT

Welded portion of plug on plunger head was applied five blows of 5 Kg. Hammer on two nos. Of plungers and there after DPT was carried out. No. cracks were observed.

## MARKING ON COMPONENTS

Marking on components of 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.01of August 2005



## LIQUID DYE PENERTRATION EXAMINATION

### (HIGH CAPACITY BUFFER ASSEMBLY)

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