



QM-C-8.1/POLYMER/0004
Inspection Plan (Check Sheet)

Item : Injection Moulded High Performance Polyamide “HPPA) (Self lubricating Superior Nylon grade) Brake Gear Bushes for BG Main Line Coaches
Specn. : RDSO/2009/CG-17 (Rev.2)
Amd. : Nil
Drg. No. & Alt. : SK-81039, Alt. 15

1. Firm's Name
2. Description of material
3. Drg.No.
4. RDSO File No.
5. Specification No.
6. Purchase order No.
7. Firm's offer letter No. & Date
8. Quantity earlier passed
9. Quantity now offered
10. Quantity consumed in testing
11. Quantity accepted
12. Quantity rejected
13. Date of Inspection & Testing
14. Date of offer
15. i) No. of Boxes
ii) Continuous Sl.No. of boxes
16. D.P.

(A) This is guaranteed by M/s..... that reconstituted/recovered material has not been used for manufacturing of above items offered for inspection. The material has been kept in poly bags. This is also certified that Nylon resin has only been used.

(B) The bushes shall be securely packed in plastic bags as to permit convenient handling and to protect against or damage during transit and storage.

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A. Sampling Plan

The inspection lot shall consist of 10000 nos. of bushes or part thereof.

a	Visual Inspection	Min. 20 Nos. shall be drawn at random from each lot
b	Dimensional check	
c	Melting Point	Min 20 Nos. shall be drawn at random from each lot & 1 bush shall be tested for c, d, e, f & g.
d	Specific Gravity	
e	Ash Content	
f	Water Absorption-2 hrs	
g	Hardness	
h	Impact Strength Test	Min 20 Nos. shall be drawn at random from each lot & 1 bush each shall be tested for h, i, & j.
i	Crush Strength Test	
j	Compressive Load Test Circumferential	
k	Wear Test –Mass Loss- 2 hrs	Min 20 Nos. shall be drawn at random from each lot (consisting of all types of bushes) and 1 bush (except for item no.11) shall be tested.

B. TEST RESULT OF HPPA BRAKE GEAR BUSHES

Inspection Certificate No. _____

Sl No	Description of Test	Specified value as per RDSO/2009/CG-17 Rev 2	Lot No.1	Lot No.2	Lot No.3	Lot No.4	Lot No.5
1	Visual Observation 20 Nos.	Surface shall be smooth & free from moulding defects. Edges shall be neatly finished and free from flash.					
2	Melting Point °C	300 (min) BS 2782-Part I (Method 123B)					

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3	Specific Gravity	1.07 to 1.18 ASTM D 792					
4	Hardness Rockwell R	120±10 ASTM D-785 & Appendix D					
5	Ash Content	Less than 1% ASTM D 5630					
6	Water Absorption – 2 Hrs.	Less than 0.75% As per Appendix A					
7	Drop Impact Strength Test (Min.)	15 Kg-m for all items of Drg. SK-81039 Alt15 (except item 11) and at 5 Kg-m for item 11 of Drg. SK-81039 Alt 15 As per Appendix B					
8	Wear Test Mass Loss for 2 hrs.	Less than 0.60% As per Appendix C					
9	Crush Strength Test (min) Tonne	As per Appendix E					
10	Compressive Load Test circumferential Tonne	As per Appendix F					
11	Wear Test Mass Loss for 24 hrs.(Type Test)	Less than 1.2% As per Appendix C					

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C. DIMENSIONAL CHECK

Sl. No.	Dimension (Drg. No.as mentioned in PO)	Lot No.1	Lot No.2	Lot No.3	Lot No.4	Lot No.5
Item-1	D=					
	d=					
	L=					
	l=					
	r=					
	Y=					
	Marking					
Item-2	D=					
	d=					
	L=					
	l=					
	r=					
	Y=					
	Marking					
Item-3	D=					
	d=					
	L=					
	l=					
	r=					
	Y=					
	Marking					

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Item-4	D=					
	d=					
	L=					
	l=					
	r=					
	Y=					
	Marking					
Item-5	D=					
	d=					
	L=					
	l=					
	r=					
	Y=					
	Marking					
Item-6	D=					
	d=					
	L=					
	l=					
	r=					
	Y=					
	Marking					

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Item-7	D=					
	d=					
	L=					
	l=					
	r=					
	Y=					
	Marking					
Item-8	D=					
	d=					
	L=					
	l=					
	r=					
	Y=					
	Marking					
Item-9	D=					
	d=					
	L=					
	l=					
	r=					
	Y=					
	Marking					

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Item-10	D=					
	d=					
	L=					
	l=					
	r=					
	Y=					
	Marking					
Item-11	D=					
	d=					
	L=					
	l=					
	r=					
	Y=					
	Marking					

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