



RESEARCH DESIGNS & STANDARDS ORGANIZATION
Manaknagar, Lucknow – 226011

QM-G-8.1-4

Guidelines for formation of third party quality control agency by wagon manufacturing units for internal stage inspection

1.0 Amendment History:

Sl. no	Amendment Date	Version	Reasons for Amendment
1	28.08.2018	1.1	First issue under ISO 9001:2015. Approved by ED/QA(Mech) on file No. QAM/ISO-9001:2015/Doc-Approval on date 28.08.2018.

2.0 Purpose:

Nomination of third party quality control agency to inspect the wagons where final inspection authority is nominated as RDSO (QA-Mech Dte).

3.0 Scope of Application:

The guidelines are applicable to QA(Mech) Directorate for wagon inspection.

(In these guidelines, RDSO means ED(QA) Mech /RDSO or his representative)

4.0 Procedure:

4.1 Scope of work of third party quality control agency (TPQCA):

- 4.1.1 TPQCA shall be appointed by wagon manufacturer to function on a regular basis at each G-105 certified wagon manufacturing facility, in all shifts of working, for carrying out internal quality control in addition to any internal organization that the Wagon Manufacturer may have.
- 4.1.2 TPQCA's independence from influence of the local Plant Management should be evident from the reporting arrangement laid down in the terms of appointment of the agency.
- 4.1.3 TPQCA should have powers to suspend functioning in a non-compliant work area through a system of notice.
- 4.1.4 Record of all non-compliances and suspension notices issued should be maintained by TPQCA and made available to RDSO.
- 4.1.5 The TPQCA shall be assigned the following minimum quality control responsibility:
 - a) Inspection/Quality control on bought out items other than those pre-inspected by RDSO.
 - b) Internal manufacturing of components and sub-assemblies as per approved QAP, relevant drawings and specifications.
 - c) To ascertain the qualification and competence of technical man power engaged in wagon manufacturing in accordance with G-72 and G-105 Standards.
 - d) To conduct stage-inspection defined in the approved QAP for respective wagon.
 - e) Need based verification of manufacturing and master gauges.
 - f) Verification of process capability in accordance with approved QAP once in a quarter which should cover conformance of manufacturing equipment, jigs and fixtures.

4.2 Criteria for selection of third party quality control agency:

- 4.2.1 These attributes should be verified by the wagon manufacturer prior to appointment of a TPQCA. An advise of TPQCA appointment along with assessment of attributes and agreement should be submitted to RDSO who may choose to verify the authenticity:
 - i) TPQCA should have current accreditation from NABCB.
 - ii) TPQCA should have with MINIMUM 3 YEARS quality control/certification experience in manufacturing industry dealing in heavy engineering products/ vehicles.
 - iii) TPQCA should have at least two international manufacturers on the client references in last three years.

4.3 Appointment and review of the third party quality control agency:

- 4.3.1** Non-conformances observed by RDSO at Final stage inspection or during surprise audits shall constitute failures of TPQCA. Each non-conformance advised by RDSO shall be documented and investigated by TPQCA.
- 4.3.2** In case of repeated non-conformances , RDSO may ask the wagon manufacturer to short close the appointment of TPQCA
- 4.3.3** Entire final inspection and at least 10% of stage inspections shall be done by RDSO in which TPQCA may be associated. The details of TPQCA personnel deployed in wagon manufacturing facilities of a wagon manufacturer shall be advised by the Wagon Manufacturer to RDSO.
- 4.3.4** In case of de-certification of a TPQCA by NABCB, its appointment as TPQCA should be terminated.
- 4.3.5** TPQCA shall provide, without demur, any production quality related information about a wagon manufacturing facility to RDSO on demand.
- 4.3.6** TPQCA should be appointed for minimum term of 1 year with a provision of extensions without gap between two successive terms.
- 4.3.7** Whenever a TPQCA's appointment is terminated for any reasons arising out of the wagon builder's or TPQCA's internal considerations, the date of dis-continuation of services shall be advised to RDSO well in advance.

5.0 Referenced Documents:

None

6.0 Referenced Documents of External Origin:

None

7.0 Associated Records:

None

8.0 Responsibility and Authority:

Activity	Responsible	Approver	Supporting	Consulted	Informed
Creation, maintenance of this document	AIE/ISO/ QA(Mech)	Director/I&L/ LKO	Staff of QA (Mech)		All zonal offices of QA(Mech)
Compliance of guidelines contained in this document.	Director/I&L/ LKO	ED/QA (Mech)	Staff of QA (Mech)		All zonal offices of QA(Mech)
Requirement of deviation from this guideline.	Director/I&L/ LKO	ED/QA(Mech)	Director/ I&L/LKO	MR/ISO Cell	All zonal offices of QA(Mech)

9.0 Abbreviations:

QA	Quality Assurance
ED/QA (Mech)	Executive Director/ Quality Assurance (Mechanical)
RDSO	Research Designs & Standards Organisation
TPQCA	Third Party Quality Control Agency
NABCB	National Accreditation Board for Certification Bodies