

ISO9001:2008	Document No: QC-G-7.1-13	Version No: 2.0	Date Effective: 01.10.2020
Document Title: Item Specific guideline & Schedule of Technical Requirements for Vendor approval for manufacture and supply HTS HEX Bolts and Nuts Size 24 x 140 MM			



RESEARCH DESIGNS & STANDARDS ORGANIZATION

Manaknagar, Lucknow – 226011

Document No: QC-G-7.1-13

Document Title : Item Specific guideline & Schedule of Technical Requirements for Vendor approval for manufacture and supply of HTS HEX Bolts and Nuts Size 24 x 140 MM

1.0 Amendment History:

S. No.	Amendment Date	Version	Reasons for Amendment
1.	01.12.2001	1.0	First issue under new documentation system
2.	01.10.2020	2.0	In new ISO format

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2.0 Purpose:

This guideline covers all technical requirement for manufacture and supply HTS HEX Bolts and Nuts Size 24 x 140 MM used for vendor registration/ quality audit of vendor. This guideline replaces the provisions of earlier guidelines issued on the subject i.e. QC-G-7.1-13 rev '1'

3.0 Scope of Application

This shall be applicable for initial capability assessment, quality audit, up-gradation of vendors and maintaining their approved list. In case of any variation between the procedure/provision given in the work instruction and that in this 'Item-specific guidelines', the later shall prevail. The competent authority wherever referred to in this document shall mean Executive Director, Quality Assurance Civil Dte.

4.0 Procedure / Details

Procedure/details is annexed.

5.0 Referenced Documents

S.No.	Document Name	Document No.
1.	IRS Specification for HTS HEX Bolts and Nuts	IRS/T-28-73
2.	Indian Standard 'Hexagon head bolts — Product grade C'	IS: 1363-2002
3.	Indian Standard TECHNICAL SUPPLY CONDITIONS FOR THREADED STEEL FASTENERS	IS: 1367-2002

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	Director/QAC	ED/QAC	DD/XEN/AIE/ARO	Track Design Dte. & M&C Dte.	All vendors/ concerned through website
Compliance of directives contained in this document	DD/XEN/AIE/ARO	Director/QAC	Respective staff	-	-
Requirement of deviation from this directive	Director/QAC	ED/QAC	DD/XEN/AIE/ARO	Track Design Dte. & M&C Dte.	All vendors/ concerned through website

9.0 Abbreviations

QA	Quality Assurance.
QAC	Quality Assurance Civil.
ED/QA	Executive Director/Quality Assurance Civil
RDSO	Research Designs & Standards Organisation
DD	Dy. Director
XEN	Executive Engineer
AIE	Assistant Inspecting Engineer.

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ARO	Assistant Research Officer
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QUALITY ASSURANCE CIVIL DIRECTORATE

RESEARCH DESIGNS & STANDARDS ORGANISATION

MANAK NAGAR, LUCKNOW – 226011

**SCHEDULE OF TECHNICAL REQUIREMENTS FOR MANUFACTURE OF
HTS HEX BOLTS AND NUTS SIZE 24 X 140 MM**

1. General and manufacturing facilities required:

- 1.1 Adequate covered and uncovered area for storage of raw and finished material
- 1.2 Source of sufficient power with at least a standby generator.
- 1.3 At least 2 nos. mechanical powers presses of 150-200 t capacity.
- 1.4 A tool room and die making facilities i.e. shaper, surface grinder, bench grinder, nose grinder and measuring instrument etc.
- 1.5 Facilities of heat treatment furnace including oil quenching and finally analyzing arrangement with automatic temperature control system

2. Testing Facilities required

- 2.1 Certified atmospheric lab for maintaining standard temperature and humidity when testing as per BIS code.
- 2.2 At least 40-ton capacity tensile testing machine capable of reading the load and elongation as per the requirement of the product duly calibrated form an approved laboratory.
- 2.3 Facilities for Dump bell preparation, bend test and full-fledged facility for chemical analysis of the product.
- 2.4 Rock well (HRC) hardness testing M/c with standard test piece.
- 2.5 The following measuring instrument in adequate number:
 - i) Vernier Callipers and Scale (Linear)
 - ii) Suitable facilities for cutting the test specimen from the product
 - iii) At least two sets of Go-No Go gauges to check the dimensional accuracy of the product – calibrated on due dates along with the calibration record. All the gauges must bear the firm's initials and set number.

3. Quality control requirements:

- 3.1 There should be a system to ensure the traceability of the product from raw material sample to finished product stage.
- 3.2 Ensure that there is a QAP for the product detailing various aspects like Organizational chart, flow process chart and stage inspection details.
- 3.3 Ensure that the relevant specification & BIS standard are available with the firm.

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**TECHNICAL CAPABILITY REASSESSMENT FOR
MANUFACTURE OF HTS HEX BOLTS AND NUTS SIZE 24 X 140 MM**

Note:

- (i) To be filled in by the firm in duplicate attached extra sheet wherever necessary. No Para to be left blank
- (ii) All manufacturing and test facilities to be available in the unit.
- (iii) All enclosures to be signed.

1. SECTION I: GENERAL INFORMATION

1.1. Name of the firm:

1.2. Address:

- (a) Head office
- (b) Works
- (c) Distance of works in km from
the nearest Rly station
- (d) Nearest Railway station

1.3 Factory area (sq,m)

- (a) Covered
- (b) Uncovered

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(c) Is the factory site in your name or on rental basis?

support with documents

(lease deed etc.)

1.4 (a) Telephone nos.

1) Head office

2) Works

(b) Telegraphic address / telex address / fax address

1) Head office

2) Works

3) E-Mail address

1.5. SSIC / NSIC Regn no. (if any)

(Furnish photocopy)

1.6 Power availability (kVA)

(a) General allotted capacity

(b) Standby generator & its capacity, if available

(c) Name the party / person in whose name the power is

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sanctioned & your agreement

(support reasonable with

documents)

1.7 Name of any other unit located in the above premises:

1.8.1 Man power management:

- (a) Managerial staff

- (b) Shop Floor Engineers / Supervisors, (their nos., name
Qualifications & services experience)

- (c) Laboratory in-charge whether full time or part time, indicate their names,
qualifications & services

- (d) Inspection & quality control staff & given their name,
Qualification and service experience

- (e) Workmen
 - 1) Highly skilled

 - 2) Semi-skilled

 - 3) Un-skilled

2. SECTION II : TECHNICAL INFORMATION

2.1 Manufacturing measuring facilities

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- i) Warping machine
- ii) Looms for weaving
- iii) Pirn winding machine
- iv) Folding machine
- v) Weighting instrument
- vi) Oven
- vii) Weight balance
- viii) Pick glass for measuring the warp & weft in the cloth
- ix) Scale for measuring warp and weft
- x) Pressure micrometer
- xi) Muffle furnace

2.2 Testing facilities

- i) Tensile test / testing machine
 - a) Capacity :
 - b) Make :
 - c) In-house calibration facilities :
- ii) Dimensional check facilities inspection gauges:

2.3 Laboratory-cum-inspection room

- i) Indicate available in yes / no: :
- ii) If yes, indicate size of room :

2.4 Source of raw material

2.5 Arrangement for storing at a time (in Tonnes)

2.6 Arrangement for storing finished material & capacity to store at a time (in Tonnes)

3. SECTION-III : EXPERIENCE (For Record Purpose Only)

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- 3.1 Indicate various types of items being manufactured in your works and the name of the agency / client for whom it is being manufactured.
- 3.2 Indicate important customers for the last 3 years both government and non-government, if any, for information furnished in your reply to 3.1
- 3.3 Give details (contract reference, item and quantity manufactured and supply of important orders executed in the past three years for the following each.
 - i) Govt. deptt. (Central / State), Govt. undertaking other than railway.
 - ii) Directly to the Railways
 - iii) Outside important firms
- 3.4 Please specify current orders in hand on your firm (Contract reference client, item, under Manufacture and supply).
- 3.5 Whether you are already registered with RSSO for other P. way items, if so, name the item supported by documents
- 3.6 Whether you are already registered with RDSO for items other p.way items, if so, name the item and department with which you are registered, support with documents.
- 3.7 Indicate annual turnover of your company.

4.0 DECLARATION

- 4.1 We do hereby declare that the above that the above particulars are correct and no discrepancy shall be found during actual investigation before and during execution of order on our firm.
- 4.2 Any change in the plant and machinery and change of place of office and of works site shall be brought to the notice of RDSO for clearance and approval.
- 4.3 We also declare that our concern has not been black listed by Railway, Railway Board/RDSO for business with the Railways.
- 4.4 We hereby undertake that all our equipments for manufacturing and testing as listed above shall be maintained in good working order at all times.

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4.5 We hereby declare that the contents and the instructions of latest ISO Apex Documents shall be read and understood by us and our firm shall agree abide by all the stipulations laid therein.

Signature

Name in full of Signing Authority

Status in the Firm,

Place

Date

Stamp of the firm.

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