

ISO9001:2008	Document No: QC-G-7.1-0024 & 0025	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 of Spring Setting Device		



RESEARCH DESIGNS & STANDARDS ORGANIZATION

Manaknagar, Lucknow – 226011

Document No: QC-G-7.1-0024 & 0025

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1.0 Amendment History:

S. No.	Amendment Date	Version	Reasons for Amendment
1.	28.11.2002	1.0	First issue under new documentation system
2.	01.10.2020	2.0	List of plant & machineries and list of testing & measuring instruments added

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2.0 Purpose:

This guideline covers all technical requirement for manufacture and supply of Glued Insulated Rail Joints used for vendor registration/ quality audit of vendor. This guideline replaces the provisions of earlier guidelines issued on the subject i.e. QC-G-7.1-0024 & 0025 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.	Nil	Nil

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.
ARO	Assistant Research Officer

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ITEM SPECIFIC GUIDELINES FOR ASSESSMENT / REASSESSMENT OF FIRMS MANUFACTURING SPRING SETTING DEVICE

In addition to the "**ISO Guidelines for Vendor Approval**" the following shall also be applicable for assessment/re-assessment of firms for manufacturing SSD.

- (i) Separate lists shall be prepared for SSD of 10125 mm and 6400 mm curved switches but common for 52 / 60 Kg rail section for 115 mm throw for PSC Sleeper layouts.
- (ii) For the purpose of assessment, the firm shall be required to lay one set of SSD at 10125 / 6400 mm curved switch BG 60 / 52 Kg rail sections as the case may be. Inspection of SSD shall be carried out and the switch parameters including length of stretcher bars shall be checked which should be within permissible limits of tolerances.
- (iii) The switch shall be operated manually or by Point Machine many times and then track parameters shall be checked as specified in the design parameters. The clearance at open side of tongue rail at Junction of Head (JOH) should be more than 58 mm (60 ± 2 mm).
- (iv) During reassessment the firm shall be required to offer one sample set of 10125 mm or 6400 mm BG 60 Kg / 52 Kg SSD, as the case may be for the list for which the firm is approved.
- (v) The sample set shall be offered on 10125 / 6400 mm switch laid at proper gauge and alignment on trough or PSC Sleepers.
- (vi) All parameters shall be checked and recorded. The matching of stock and tongue rail must be from toe to JOH within 0.5 mm. The clearance on open side of tongue rail at JOH shall be more than 58 mm (60 ± 2 mm).
- (vii) It shall be the responsibility of the firm to arrange switches for laying of SSD for assessment / reassessment purposes.
- (viii) The gauges shall be approved/revalidated at the time of inspection of infrastructural facilities during assessment/reassessment of the firm.

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PROFORMA FOR CAPABILITY / CAPACITY ASSESSMENT OF FIRMS FOR MANUFACTURE OF SPRING SETTING DEVICE

(To be prepared in duplicate)

SECTION-1: GENERAL INFORMATION

1. Name of the firm

2. Postal address of the firm

2.1 Head Office

2.2 Works

3. Telephone No. (with STD Code)

3.1 Head office

3.2 Works

4. Telegraphic address Telex & fax of-

4.1 Head office

4.2 Works

4.3 E-mail

4.4 Works

5. Description of works-

5.1 Total land area (in Sq meters)

5.2 Total covered area (in Sq meters)

5.3 A fully dimensioned plan of the works showing covered area and different shops shall be enclosed

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6. Number of personnel employed (category-wise)

6.1 Managerial

6.2 Supervisory
(Enclose list of Managers / Technical Supervisors)

7. Hours of working

8. Weekly off days

9. State whether the firm is already in approved List with RDSO for supply of Spring Setting Device. If so, please give details of last approval.

9.1 Letter date and issued by

9.2 Date of expiry of validity of approval

10. Details of orders executed in past for Spring Setting Device made in Zonal Railways.

11. QUALITY ASSURANCE

11.1 Details of manufacturing process

11.2 Enclose copy of QAP

11.3 Enclose copy of ISO-9000 of the firm for switches and crossings.

12 Whether one sample set of SSD of each design for which approval is required to be extended are ready for inspection, duly laid on relevant type of switches.

13 Whether one sample set of SSD of each design for which approval is required to be extended are ready for inspection, duly laid on relevant type of switches.
(Separately for 10125 mm & 6400 mm curved switches BG 60 & 52 Kg)

14. TECHNICAL INFORMATION

The firm must possess capability / capacity to manufacture IRS design of switches and shall be in approved list of supplies of switches (1:12 and 1:8.5 both)

Valdity of approval of firm:.

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Minimum Facilities & Machineries required for manufacture of Spring Setting Device

S.No	Description	Minimum Capacity	Minimum Quantity	Available with Firm
1.	Gantry Crane facilities	2-3 t	1 No.	
2.	Radial drill	40 mm dia.	1 No.	
3.	Shapers	600 mm stroke	1 No.	
4.	Circular band saw	900 mm dia.	1 No.	
5.	Milling Machine	-	1 No.	
6.	Plano Miller	2-3m stroke	1 No.	
7.	Pug Cutting Machine	-	1 No.	
8.	Universal Testing Machine	40 t (minimum)	1 No.	
9.	Charpy impact testing machine	-	1 No.	
10.	Hardness tester Poldi/ Rockwell	-	1 No.	
11.	CO ₂ / Mig welding equipment	-	One complete set with approved brand of welding wires	
12.	Assembly & Inspection bay		A separate area to be dedicated with proper levelled floor	
13.	Chemical lab	Spectro (For chemical analysis) of MS ,Medium & Low alloy steel	1 wet unit installed in house	

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14.	Non-destructive testing facilities	i) Metallurgical Microscope	1 No.	
		ii) Polishing Machine	1 No	

SECTION -III: DECLARATION

- (i) **We do hereby declare that the above particulars are correct and no discrepancy shall be found during actual investigation before and during execution of order on our firm.**
- (ii) **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.**
- (iii) **We also declare that our concern has not been black-listed by Railway / Railway Board / RDSO for business with the Railways.**
- (iv) We hereby undertake that all our equipments for manufacturing and testing as listed above shall be maintained in good working order at all times.
- (v) We hereby declare that the contents and the instructions of latest "**ISO Guidelines for Vendors Approval**" effective from have been 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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