

**INDIAN RAILWAYS**



**CHECK SHEETS**

**FOR**

**CRF SECTIONS OF BOGIE OPEN WAGON TYPE – BOXNS (Design F)**

| S.No. | Month & Year of issue | Revision / Amendment | Page No. | Reason for Amendment |
|-------|-----------------------|----------------------|----------|----------------------|
| 1.    | August - 2016         | First issue          | -        | --                   |
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**ISSUED BY**

**RESEARCH DESIGNS AND STANDARDS ORGANISATION  
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LUCKNOW-226 011**

August, 2016

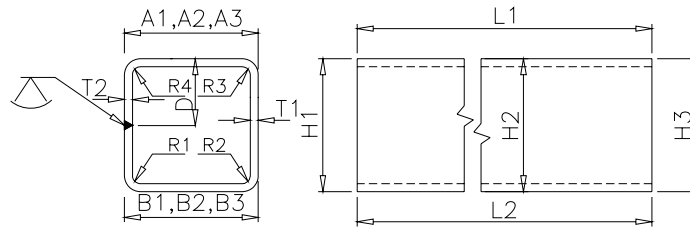
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**Note:**

1. These check sheets do not detail all the dimensions or technical requirements of respective wagon assemblies/components. These check sheets are issued only for General Guidance & assistance of inspecting officials. Notwithstanding the above, the inspecting officials are advised to refer to relevant drawings and/or relevant specifications to confirm conformity to the specified dimensions and technical details.
2. (a) In check sheets wherever it is indicated that two dimensions are to be measured, it means measurement of that dimension at two end locations of the component.  
  
(b) In check sheets wherever it is indicated that three dimensions are to be measured, it means measurement of that dimension at two end locations of the component, and one at the center of the component.

**SIDE TOP COPING**



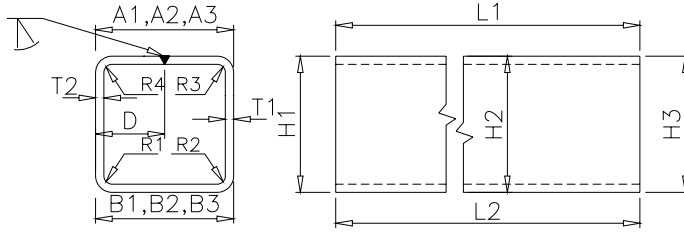
Ref: Drawing No. WD-14014-S-05 Item-11 & WD-14014-S-21 Item-1

| Side Top Coping |                 |  |  | Date:                |                      |         |
|-----------------|-----------------|--|--|----------------------|----------------------|---------|
| SL. NO.         | STAGE           | Works Inspection                         |  | Inspecting Authority |                      | Remarks |
| 1.              | Dimensions      | As follows                               |  |                      |                      |         |
|                 | LOCATION        | Nominal Dimensions & Allowable Deviation |  | Actual Dimension     |                      | Remarks |
|                 |                 |  |  | Works Inspection     | Inspecting Authority |         |
| i.              | Flange (top)    | A1                                       | 110± 1.5   |                      |                      |         |
|                 |                 | A2                                       |  |                      |                      |         |
|                 |                 | A3                                       |  |                      |                      |         |
| ii.             | Flange (bottom) | B1                                       | 110±1.5  |                      |                      |         |
|                 |                 | B2                                       |  |                      |                      |         |
|                 |                 | B3                                       |  |                      |                      |         |
| iii.            | Thickness       | T1                                       | 7 +0.35/-0.0   |                      |                      |         |
|                 |                 | T2                                       |  |                      |                      |         |
| iv.             | Height          | H1                                       | 110± 1.5   |                      |                      |         |
|                 |                 | H2                                       |  |                      |                      |         |
|                 |                 | H3                                       |  |                      |                      |         |
| v.              | Length          | L1                                       | 10090 (+4.0/-2.0)  |                      |                      |         |
|                 |                 | L2                                       |  |                      |                      |         |
| vi.             | Joint Location  | D  | 55 ± 0.5   |                      |                      |         |
| vii.            | Radius          | R1                                       | 14± 1.50   |                      |                      |         |
|                 |                 | R2                                       |  |                      |                      |         |
|                 |                 | R3                                       |  |                      |                      |         |
|                 |                 | R4                                       |  |                      |                      |         |
| viii.           | Angle           | -  | ±1°  |                      |                      |         |
| ix.             | Waviness        | -  | 2 max  |                      |                      |         |
| x.              | Bow             | -  | 1 in 600. Max bow in horizontal plane should be 5mm.                         |                      |                      |         |
| xi.             | Camber          | -  | 1 in 600   |                      |                      |         |
| xii.            | Twist           | -  | 1 deg./meter. Max twist over entire length of section should be within 35mm. |                      |                      |         |
| xiii.           | Appearance      | -  | Free From Deep Marks ,Cracks & Other Defects                                 |                      |                      |         |

All dimensions are in mm

| Works Inspector |  | Inspecting Authority |  |
|-----------------|--|----------------------|--|
| Signature:      |  | Signature:           |  |
| Name:           |  | Name:                |  |
| Designation:    |  | Designation:         |  |
| Date:           |  | Date:                |  |

END TOP COPING



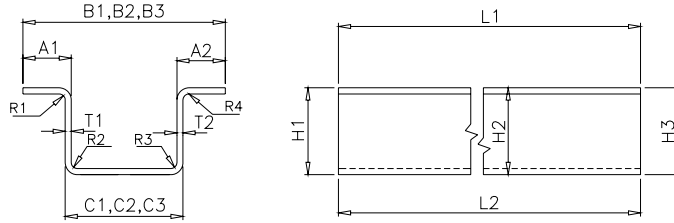
Ref: Drawing No. WD-14014-S-06 Item-3 & WD-14014-S-21 Item-2

| End Top Coping |                 | Date:                                    |   |                      |                      |
|----------------|-----------------|--|---|----------------------|----------------------|
| SL. NO.        | STAGE           | Works Inspection                         |   | Inspecting Authority | Remarks              |
| 1.             | Dimensions      | As follows                               |   |                      |                      |
|                | LOCATION        | Nominal Dimensions & Allowable Deviation |   | Actual Dimension     |                      |
|                |                 |  |   | Works Inspection     | Inspecting Authority |
| i.             | Flange(top)     | A1                                       | 150 +1.25/ -0.00  |                      |                      |
|                |                 | A2                                       |   |                      |                      |
|                |                 | A3                                       |   |                      |                      |
| ii             | Flange (bottom) | B1                                       | 150 +1.25/ -0.00  |                      |                      |
|                |                 | B2                                       |   |                      |                      |
|                |                 | B3                                       |   |                      |                      |
| iii.           | Thickness       | T1                                       | 4 ± 0.20  |                      |                      |
|                |                 | T2                                       |   |                      |                      |
| iv.            | Height          | H1                                       | 170 +1.25/-0.0  |                      |                      |
|                |                 | H2                                       |   |                      |                      |
|                |                 | H3                                       |   |                      |                      |
| v.             | Length          | L1                                       | 2915 +3.0/-1.0  |                      |                      |
|                |                 | L2                                       |   |                      |                      |
| vi.            | Joint Location  | D  | 75 ± 0.5  |                      |                      |
| vii.           | Radius          | R1                                       | 8 ±1.50   |                      |                      |
|                |                 | R2                                       |   |                      |                      |
|                |                 | R3                                       |   |                      |                      |
|                |                 | R4                                       |   |                      |                      |
| viii.          | Angle           | -  | ±1°   |                      |                      |
| ix.            | Waviness        | -  | 2 max   |                      |                      |
| x.             | Bow             | -  | 1 in 600. Max bow in horizontal plane should be 5mm                           |                      |                      |
| xi.            | Camber          | -  | 1 in 600  |                      |                      |
| xii.           | Twist           | -  | 1 deg./ meter. Max twist over entire length of section should be within 35mm. |                      |                      |
| xiii.          | Appearance      | -  | Free From Deep Marks ,Cracks & Other Defects                                  |                      |                      |

All dimensions are in mm

| Works Inspector |  | Inspecting Authority |  |
|-----------------|--|----------------------|--|
| Signature:      |  | Signature:           |  |
| Name:           |  | Name:                |  |
| Designation:    |  | Designation:         |  |
| Date:           |  | Date:                |  |

**END STANCHION**



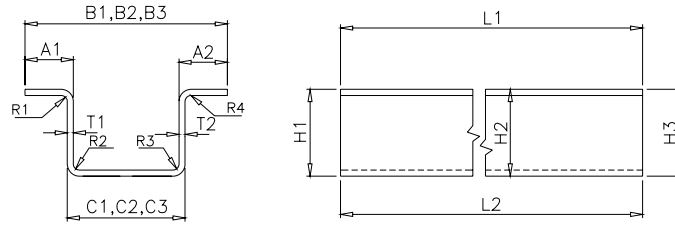
Ref: Drawing No. WD-14014-S-06 Item-2 & WD-14014-S-21 Item-3

| End Stanchion |              |  |  | Date:                |                      |         |
|---------------|--------------|--|--|----------------------|----------------------|---------|
| SL. NO.       | STAGE        | Works Inspection                         |  | Inspecting Authority |                      | Remarks |
| 1.            | Dimensions   | As follows                               |  |                      |                      |         |
|               | LOCATION     | Nominal Dimensions & Allowable Deviation |  | Actual Dimension     |                      | Remarks |
|               |              |  |  | Works Inspection     | Inspecting Authority |         |
| i.            | Flange       | A1                                       | 54 ± 1.25  |                      |                      |         |
|               |              | A2                                       |  |                      |                      |         |
| ii.           | Thickness    | T1                                       | 4 ± 0.20   |                      |                      |         |
|               |              | T2                                       |  |                      |                      |         |
| iii.          | Top Width    | B1                                       | 200 ± 1.5  |                      |                      |         |
|               |              | B2                                       |  |                      |                      |         |
|               |              | B3                                       |  |                      |                      |         |
| iv.           | Bottom Width | C1                                       | 100 ± 1.0  |                      |                      |         |
|               |              | C2                                       |  |                      |                      |         |
|               |              | C3                                       |  |                      |                      |         |
| v.            | Height       | H1                                       | 125 ± 1.25   |                      |                      |         |
|               |              | H2                                       |  |                      |                      |         |
|               |              | H3                                       |  |                      |                      |         |
| vi.           | Length       | L1                                       | 2390 +3.0/-1.0   |                      |                      |         |
|               |              | L2                                       |  |                      |                      |         |
| vii.          | Radius       | R1                                       | 8± 1.50  |                      |                      |         |
|               |              | R2                                       |  |                      |                      |         |
|               |              | R3                                       |  |                      |                      |         |
|               |              | R4                                       |  |                      |                      |         |
| viii.         | Angle        | -  | ±1°  |                      |                      |         |
| ix.           | Waviness     | -  | 2 max  |                      |                      |         |
| x.            | Bow          | -  | 1 in 600. Max bow in horizontal plane should be 5mm                          |                      |                      |         |
| xi.           | Camber       | -  | 1 in 600   |                      |                      |         |
| xii.          | Twist        | -  | 1 deg./meter. Max twist over entire length of section should be within 35mm. |                      |                      |         |
| xiii.         | Appearance   | -  | Free From Deep Marks ,Cracks & Other Defects                                 |                      |                      |         |

All dimensions are in mm

| Works Inspector |  | Inspecting Authority |  |
|-----------------|--|----------------------|--|
| Signature:      |  | Signature:           |  |
| Name:           |  | Name:                |  |
| Designation:    |  | Designation:         |  |
| Date:           |  | Date:                |  |

**SIDE STANCHION**



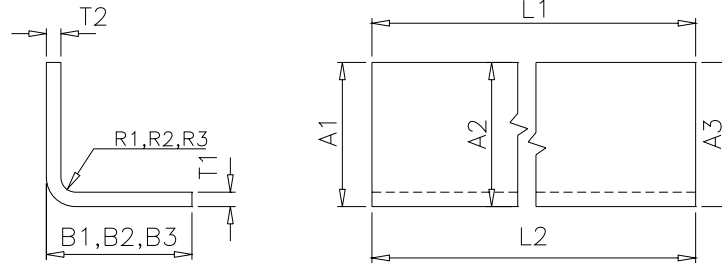
Ref: Drawing No. WD-14014-S-05 Item-12 & WD-14014-S-21 Item-4

| Side Stanchion |              |  |  | Date:                |                      |         |
|----------------|--------------|--|--|----------------------|----------------------|---------|
| SL. NO.        | STAGE        | Works Inspection                         |  | Inspecting Authority |                      | Remarks |
| 1.             | Dimensions   | As follows                               |  |                      |                      |         |
|                | LOCATION     | Nominal Dimensions & Allowable Deviation |  | Actual Dimension     |                      | Remarks |
|                |              |  |  | Works Inspection     | Inspecting Authority |         |
| i.             | Flange       | A1                                       | 53   |                      |                      |         |
|                |              | A2                                       |  |                      |                      |         |
| ii.            | Thickness    | T1                                       | 8 ± 0.40   |                      |                      |         |
|                |              | T2                                       |  |                      |                      |         |
| iii.           | Top Width    | B1                                       | 250 ± 1.5  |                      |                      |         |
|                |              | B2                                       |  |                      |                      |         |
|                |              | B3                                       |  |                      |                      |         |
| iv.            | Bottom Width | C1                                       | 160 ± 1.5  |                      |                      |         |
|                |              | C2                                       |  |                      |                      |         |
|                |              | C3                                       |  |                      |                      |         |
| v.             | Height       | H1                                       | 110 ± 1.5  |                      |                      |         |
|                |              | H2                                       |  |                      |                      |         |
|                |              | H3                                       |  |                      |                      |         |
| vi.            | Length       | L1                                       | 2442 +3.0/-1.0   |                      |                      |         |
|                |              | L2                                       |  |                      |                      |         |
| vii.           | Radius       | R1                                       | 16 ± 1.50  |                      |                      |         |
|                |              | R2                                       |  |                      |                      |         |
|                |              | R3                                       |  |                      |                      |         |
|                |              | R4                                       |  |                      |                      |         |
| viii.          | Angle        | -  | ±1°  |                      |                      |         |
| ix.            | Waviness     | -  | 2 max  |                      |                      |         |
| x.             | Bow          | -  | 1 in 600. Max bow in horizontal plane should be 5mm                          |                      |                      |         |
| xi.            | Camber       | -  | 1 in 600   |                      |                      |         |
| xii.           | Twist        | -  | 1 deg./meter. Max twist over entire length of section should be within 35mm. |                      |                      |         |
| xiii.          | Appearance   | -  | Free From Deep Marks ,Cracks & Other Defects                                 |                      |                      |         |

All dimensions are in mm

| Works Inspector |  | Inspecting Authority |  |
|-----------------|--|----------------------|--|
| Signature:      |  | Signature:           |  |
| Name:           |  | Name:                |  |
| Designation:    |  | Designation:         |  |
| Date:           |  | Date:                |  |

**CORNER STANCHION**



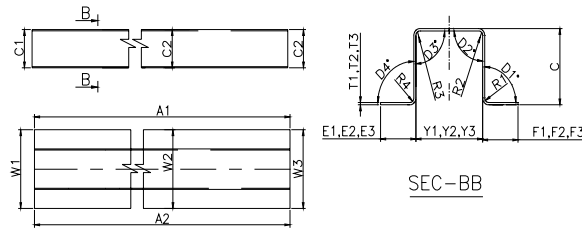
Ref: Drawing No. WD-14014-S-05 Item-4 & WD-14014-S-21 Item-5

| Corner Stanchion |            |  |   | Date:                |         |
|------------------|------------|--|---|----------------------|---------|
| SL. NO.          | STAGE      | Works Inspection                         | Inspecting Authority  | Remarks              |         |
| 1.               | Dimensions | As follows                               |   |                      |         |
|                  | LOCATION   | Nominal Dimensions & Allowable Deviation | Actual Dimension  |                      | Remarks |
|                  |            |  | Works Inspection  | Inspecting Authority |         |
| i.               | Flange - 1 | A1                                       | 110 ± 1.5   |                      |         |
|                  |            | A2                                       |   |                      |         |
|                  |            | A3                                       |   |                      |         |
| ii.              | Flange - 2 | B1                                       | 110 ± 1.5   |                      |         |
|                  |            | B2                                       |   |                      |         |
|                  |            | B3                                       |   |                      |         |
| iii.             | Thickness  | T1                                       | 8 ± 0.40  |                      |         |
|                  |            | T2                                       |   |                      |         |
| iv.              | Length     | Top                                      | 2447 (+3,-1)  |                      |         |
|                  |            | Bottom                                   |   |                      |         |
| v.               | Radius     | R1                                       | 16 ± 1.50   |                      |         |
|                  |            | R2                                       |   |                      |         |
|                  |            | R3                                       |   |                      |         |
| vi.              | Angle      | -  | ± 1°  |                      |         |
| vii.             | Waviness   | -  | 2 max.  |                      |         |
| viii.            | Bow        | -  | 1 in 600. Max bow in horizontal plane should be 5mm                         |                      |         |
| ix.              | Camber     | -  | 1 in 600  |                      |         |
| x.               | Twist      | -  | 1 deg./meter. Max twist over entire length of section should be within 35mm |                      |         |
| xi.              | Appearance | -  | Free From Deep Marks ,Cracks & Other Defects                                |                      |         |

All dimensions are in mm

| Works Inspector |  | Inspecting Authority |  |
|-----------------|--|----------------------|--|
| Signature:      |  | Signature:           |  |
| Name:           |  | Name:                |  |
| Designation:    |  | Designation:         |  |
| Date:           |  | Date:                |  |

CENTRE SILL (HAT SECTION)



Ref: Drawing No. WD-14014-S-03 Item-1 & WD-14014-S-21 Item-6

| Centre sill |                   |  | Date:   |                      |                      |         |
|-------------|-------------------|--|---|----------------------|----------------------|---------|
| SL. NO.     | STAGE             | Works Inspection                         |   | Inspecting Authority |                      | Remarks |
| 1.          | Dimensions        | As follows                               |   |                      |                      |         |
|             | LOCATION          | Nominal Dimensions & Allowable Deviation |   | Actual Dimension     |                      | Remarks |
|             |                   |  |   | Works Inspection     | Inspecting Authority |         |
| i.          | Left Flange       | E1                                       | 173.5   |                      |                      |         |
|             |                   | E2                                       |   |                      |                      |         |
|             |                   | E3                                       |   |                      |                      |         |
| ii.         | Right flange      | F1                                       | 173.5   |                      |                      |         |
|             |                   | F2                                       |   |                      |                      |         |
|             |                   | F3                                       |   |                      |                      |         |
| iii.        | Height            | C1                                       | 327 ±1.50   |                      |                      |         |
|             |                   | C2                                       |   |                      |                      |         |
|             |                   | C3                                       |   |                      |                      |         |
| iv.         | Thickness         | T1                                       | 10+ 0.50<br>-0.00   |                      |                      |         |
|             |                   | T2                                       |   |                      |                      |         |
|             |                   | T3                                       |   |                      |                      |         |
| v.          | Length            | A1                                       | 9784 (+4,-2)  |                      |                      |         |
|             |                   | A2                                       |   |                      |                      |         |
| vi.         | Top Width(inside) | Y1                                       | 327+3.-0  |                      |                      |         |
|             |                   | Y2                                       |   |                      |                      |         |
|             |                   | Y3                                       |   |                      |                      |         |
| vii.        | Bottom width      | W1                                       | 674 ±3.00   |                      |                      |         |
|             |                   | W2                                       |   |                      |                      |         |
|             |                   | W3                                       |   |                      |                      |         |
| viii.       | Radius            | R1                                       | 20± 1.50  |                      |                      |         |
|             |                   | R2                                       |   |                      |                      |         |
|             |                   | R3                                       |   |                      |                      |         |
|             |                   | R4                                       |   |                      |                      |         |
| ix.         | Angle             | D1°                                      | 90± 1°  |                      |                      |         |
|             |                   | D2°                                      |   |                      |                      |         |
|             |                   | D3°                                      |   |                      |                      |         |
|             |                   | D4°                                      |   |                      |                      |         |
| x.          | Waviness          | -  | 2 max.  |                      |                      |         |
| xi.         | Bow               | -  | 1 in 600. Max bow in horizontal plane should be 5mm                         |                      |                      |         |
| xii.        | Camber            | -  | 1 in 600  |                      |                      |         |
| xiii.       | Twist             | -  | 1 deg./meter. Max twist over entire length of section should be within 35mm |                      |                      |         |
| xiv.        | Appearance        | -  | Free From Deep Marks ,Cracks & Other Defects                                |                      |                      |         |

All dimensions are in mm

| Works Inspector |  | Inspecting Authority |  |
|-----------------|--|----------------------|--|
| Signature:      |  | Signature:           |  |
| Name:           |  | Name:                |  |
| Designation:    |  | Designation:         |  |
| Date:           |  | Date:                |  |



| Sampling plan |  |                               |  |  |                             |  |  |  |                      |                         |                                     |
|---------------|--|-------------------------------|--|--|-----------------------------|--|--|--|----------------------|-------------------------|-------------------------------------|
| S. No         | Component s/ Operation /Product/ Process |                               | Characteristics/ Parameters                                  | Mode of Inspection/ Equipment's  | Internal Inspection Sample- |  | Reference documents/ Specification       | Acceptance Criteria                                | Documents of Records | RDSO Inspection Sample- |                                     |
|               |  |                               |  |  | Size                        | Frequency                                  |  |  |                      | Size                    | Frequency                           |
| 1             | Raw Material Receipt                     | a)                            | Source of Procurement  | Visual   | -                           | Every lot                                  | Receipt Particulars & RDSO's Vendor List | Should be procured from RDSO approved sources only | Format no....        | -                       | Every Lot                           |
|               |  | b)                            | System of Unloading  | Visual   | Complete Lot                | Every lot                                  | Nil                                      | No external damage should occur                    |                      | AUDIT                   |                                     |
|               |  | c)                            | Quantity   | Visual   | Complete Lot                | Every lot                                  | Receipt particulars                      | To be as per receipt particulars                   |                      |                         |                                     |
|               |  | d)                            | Weight   | Weighing Machine   | One/Lot                     | Every lot                                  |  |  |                      |                         |                                     |
| 2             | Raw Material Inspection                  | a)                            | Identification of Coil/plate                                 | Visual   | Every coil/plate            | Every coil/ plate                          | T.C.                                     | Coil No. & Heat No. to be as per T.C.              | Format no---         | AUDIT                   |                                     |
|               |  | b)                            | Coil/Strip width & thickness                                 | Measuring Tape/Steel Rule/ Micrometre                                    | One per Coil/Plate          | 3 times (start, middle, end) of coil/plate | Indent & T.C.                            | To be as per indent/design requirement             |                      | Complete Lot            | Every lot                           |
|               |  | c)                            | Grade  | By means of suitable m/c / test equipment in house lab/NABL approved lab | Complete Lot                | Every lot                                  | Indent & T.C.                            | To be as per indent/design requirement             |                      |                         |                                     |
|               |  | d)                            | Mechanical Properties  |  | Complete Lot                | Every lot                                  | Indent & T.C.                            | To be as per prescribed specification              |                      |                         |                                     |
|               |  | e)                            | Chemical Properties  |  | Complete Lot                | Every lot                                  | Indent & T.C.                            | To be as per prescribed specification              |                      |                         |                                     |
|               |  | f)                            | Bend Test  |  | Complete Lot                | Every lot                                  | Indent & T.C.                            | To be as per prescribed specification              |                      |                         |                                     |
|               |  | g)                            | Testing of Mechanical & Chemical Properties and Bend Testing |  | One/Lot                     | Every lot                                  | Prescribed specification                 | To be as per prescribed specification              |                      | Format no....           | 2 (1 to be tested & 1 to be stored) |
| 3             | Raw Material & Final Product Storage     | a)                            | Condition of storage area                                    | visual   | Complete lot                | Daily                                      | WD-01-CRF-08 with latest alt.            | Covered area and protection from water             | Format no---         |                         |                                     |
| b)            |  | Availability of Racks/Packing | Proper racks and packing to be available                     |  |                             |  |  |  |                      |                         |                                     |
| c)            |  | Condition of Material         | To be free from damages, dents & rust.                       |  |                             |  |  |  |                      |                         |                                     |
| 4             | Selection of coil for slitting           | a)                            | Condition of Coil  | Visual   | Complete coil/plate         | Every coil/ plate                          | -  | Coil/plate to be free from damage & rust           | Format no---         | AUDIT                   |                                     |

| S. No | Component s/ Operation /Product/ Process        |    | Charcteristics/ Parameters   | Mode of inspection/ equipments                         | Internal inspection sample  |  | Ref documents/ specifications            | Acceptance criteria  | Documents of records | RDSO inspection Sample |            |
|-------|---|----|--|--|-----------------------------|--|--|--|----------------------|------------------------|------------|
|       |   |    |  |  | Size                        | Frequency                                  |  |  |                      | Size                   | Frequ ency |
| 5     | Handling of coil/plates/S ections till despatch | a) | Care during movement   | Visual   | Every coil/ plate/ Secti on | Every coil/ plate/section                  | -  | No damage/dent to occur  | Format no---         | AUDIT                  |            |
| 6     | Coil/plate slitting                             | a) | Coil/Plate width   | Measuring Tape/ Steel Rule/Vernier                     | One per Coil/Plate          | 3 times (start, middle, end) of coil/plate | Design requirement                       | To be as per design requirement  | Format no---         | AUDIT                  |            |
|       |   | b) | Edge condition   | Visual   | Complete slitted Coil/Plate | Every slitted Coil/ Plate                  | Should be smooth                         | To be free from burrs, sharp edges   |                      |                        |            |
| 7     | Setting of rolls on mill                        | a) | Correctness of rolls   | Visual/Measuri ng Tape/ Steel Rule/Vernier             | Every rolling mill          | Twice in one shift                         |  | All rolls to be as per design requirement  | Format no---         | AUDIT                  |            |
| 8     | In-process Inspection                           | a) | Profile of the section   | Measuring tape, Vernier, Bevel protactor, Radius gauge | 1 no.                       | 3 times (start,middle, end) of coil/plate  | Respective RDSO/P.O. drawing/check sheet | To be as per respective RDSO/P.O. drawing/chec k sheet                                   | Format no---         | AUDIT                  |            |
|       |   | b) | Marking of Coil/plate no.  | Visual   | 1 no.                       | Every coil/plate                           | -  | To be same as the selected coil  | Format no---         | AUDIT                  |            |
| 9     | Post Roll Forming Operations                    | a) | Drilling   | Vernier/Gauge  | 1 no.                       | Every section                              | Respective RDSO/P.O. drawing/check sheet | To be as per respective RDSO/P.O. drawing/chec k sheet                                   | Format no---         | AUDIT                  |            |
|       |   | b) | Notching   | Visual   |                             |  |  |  |                      |                        |            |
|       |   | c) | Edge Preparation   | Visual   |                             |  |  |  |                      |                        |            |
|       |   | d) | Profile cutting  | Visual   |                             |  |  |  |                      |                        |            |
| 10    | Welding   | a) | Weld Preparation, Fixtures, Welding machine and current/voltage, welding electrodes, weld cleaning and condition of weld | Visual, Radiography (if, prescribed)                   | 10%                         | Every lot                                  | WPS, issued by RDSO                      | To be as per WPS, issued by RDSO   | Format no---         | 5% (Mini mum two set)  | Each lot   |
| 11    | Final Inspection                                | a) | Profile of the section   | Measuring tape, Vernier, Bevel protactor, Radius gauge | 10%                         | Every lot                                  | Respective RDSO/P.O. drawing/check sheet | To be as per respective RDSO/P.O. drawing/chec k sheet                                   | Format no---         | 5% (Mini mum two set)  | Each lot   |
|       |   | b) | Edge condition   | Visual   | 10%                         | Every lot                                  | Respective RDSO/P.O. drawing/check sheet | To be as per respective RDSO/P.O. drawing/chec k sheet and free from burrs & sharp edges | Format no---         | 5% (Mini mum two set)  | Each lot   |
|       |   | c) | Drilling   | Plug Gauge/ Vernier                                    | 1 no.                       | Every section                              | Respective RDSO/P.O. drawing/check sheet | To be as per respective RDSO/P.O. drawing/chec k sheet                                   | Format no---         | AUDIT                  |            |
|       |   | d) | Notching   | Visual   |                             |  |  |  |                      |                        |            |
|       |   | e) | Edge Preparation   | Visual   |                             |  |  |  |                      |                        |            |
|       |   | f) | Profile cutting  | Visual   |                             |  |  |  |                      |                        |            |

| S. No | Component s/Operation/ Product/ Process            |    | Characteristics/ parameters  | Mode of inspection/ Equipments | Internal inspection sample |           | Reference documents/ specification | Acceptance criteria  | Documents of records | RDSO inspection sample |           |
|-------|--|----|------------------------------|--------------------------------|----------------------------|-----------|------------------------------------|--|----------------------|------------------------|-----------|
|       |  |    |                              |                                | Size                       | Frequency |                                    |  |                      | Size                   | Frequency |
| 12    | Marking  | a) | Correctness of marking       | Visual                         | 10%                        | Every lot | -                                  | Month and year to be current and Coil No. to be same as Original No.                                       | Format no---         | 5% (Minimum two set)   | Each lot  |
|       |  | b) | Legibility of Marking        | Visual                         | 10%                        | Every lot | -                                  | To be legible  | Format no---         | 5% (Minimum two set)   | Each lot  |
| 13    | Linking of punched Coil No. with Grade of Material | a) | Material Properties          | Visual                         | 10%                        | Every lot | T.C. and lab Results               | To be as per respective RDSO specification   | Format no---         | 5% (Minimum two set)   | Each lot  |
| 14    | Packing of sections                                | a) | Condition of Packing         | Visual                         | 10%                        | Every lot | -                                  | Packing to be sturdy and Marking on Packing should contain complete identification details of the Products | Format no---         | Minimum Two packs      | Each lot  |
|       |  | b) | Marking on Packing           |                                |                            |           |                                    |  |                      |                        |           |
|       |  | c) | Condition of Packed Products |                                |                            |           |                                    |  |                      |                        |           |