



QM-C-7.1/COUPLER/00011/E
INSPECTION PLAN (CHECK SHEET)

Item : Knuckle Pivot Pin
Specn : WD-70-BD-10 (Rev- 2 or latest)
Drg. No.& Alt : SK-62724, Alt. 26 or Latest, Item- 4

- 1 P.O.NO.
- 2 RDSO CASE NO
- 3 NAME OF THE FIRM
- 4 DATE OF INSPECTION
- 5 QTY. ON ORDER
- 6 QTY PASSED EARLIER
- 7 QTY NOW OFFERED
- 8 QTY NOW PASSED
- 9 QTY REJECTED
- 10 DATE OF OFFER
- 11 CONSIGNEE
- 12 D.P.

SIGNATURE OF FIRM REPRESENTATIVE

SIGNATURE OF RDSO REPRESENTATIVE



Chemical & Physical of each lot

Chemical Test as per IS: 5517 42 CR4 MO2

	%C	%Mn	%Si	%S	%P	%Cr	%Mo
Specified Value	0.38-0.45	0.60-0.90	0.10-0.35	0.035 max.	0.035 max.	0.90-1.20	0.15-0.30
Observed Value							

Physical Test as per WD-70-BD-10 (Rev-2 or Latest) for K.P. Pin

	U.T.S (KGF/mm ²)	Y.S (KGF/mm ²)	% EL 5.65√so	% RA
Specified Value	103 kgf/mm ² (min)	63kgf/mm ² (min)	16.5 (min)	46.20(min)
Observed Value				

14. VISIUAL CHECK: 10%

1	2	3	4	5	6	7	8	9	10	11	12	13	14

15. DIMENSION CHECK: 10 % checked by gauge (all dimension in mm)

SMPL NO.	HEAD DIA 52.4	PIN DIA 41.28 ± 0.3	TOTAL LEGNTH 342	HEAD THK 12.5	DIA OF WASHER 51.0	THK. OF WASHER 5.0

16. Hardness check 5 % (229-428 BHN) As per para 4.2.1.2 of WD-70-BD-10 (Rev-2 or Latest)

1	2	3	4	5	6	7	8	9	10

17. FINISH CHECK 5 %

The finished pin shall be straight, free from scale and have surface finish of Ra 3.2 μm (Max.)

1	2	3	4	5	6	7	8	9	10

- 18.a) Marking: Manufacturing initial, month -Year & UHT steel stamped on head. OK/Not OK
 b) Packing: Material in loose sealed in gunny bag. OK/Not OK
 c) Straightness: It should be 5 mm/meter (Maximum)
 d) Painting: Should not be painted.

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SIGNATURE OF RDSO INSPECTOR