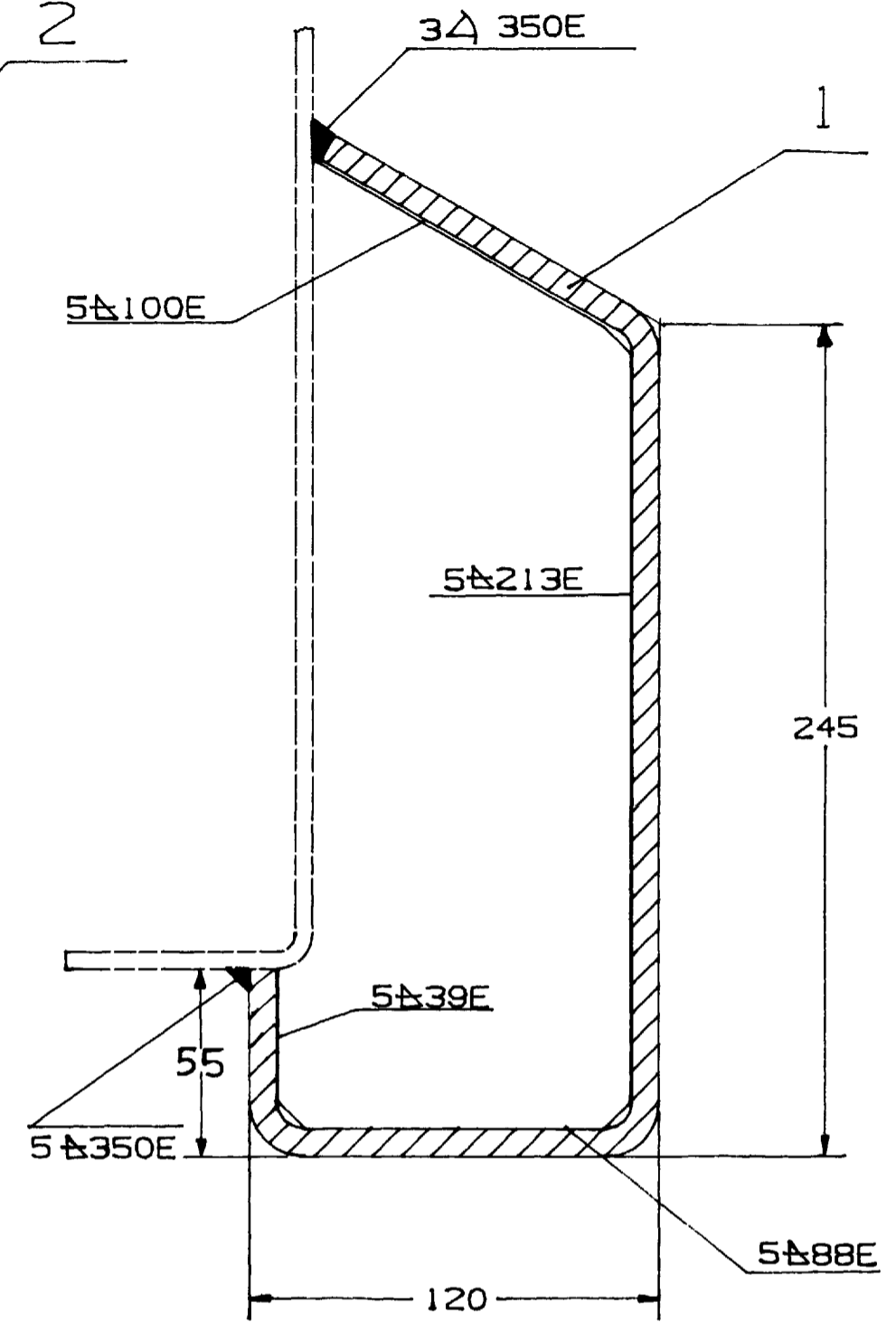
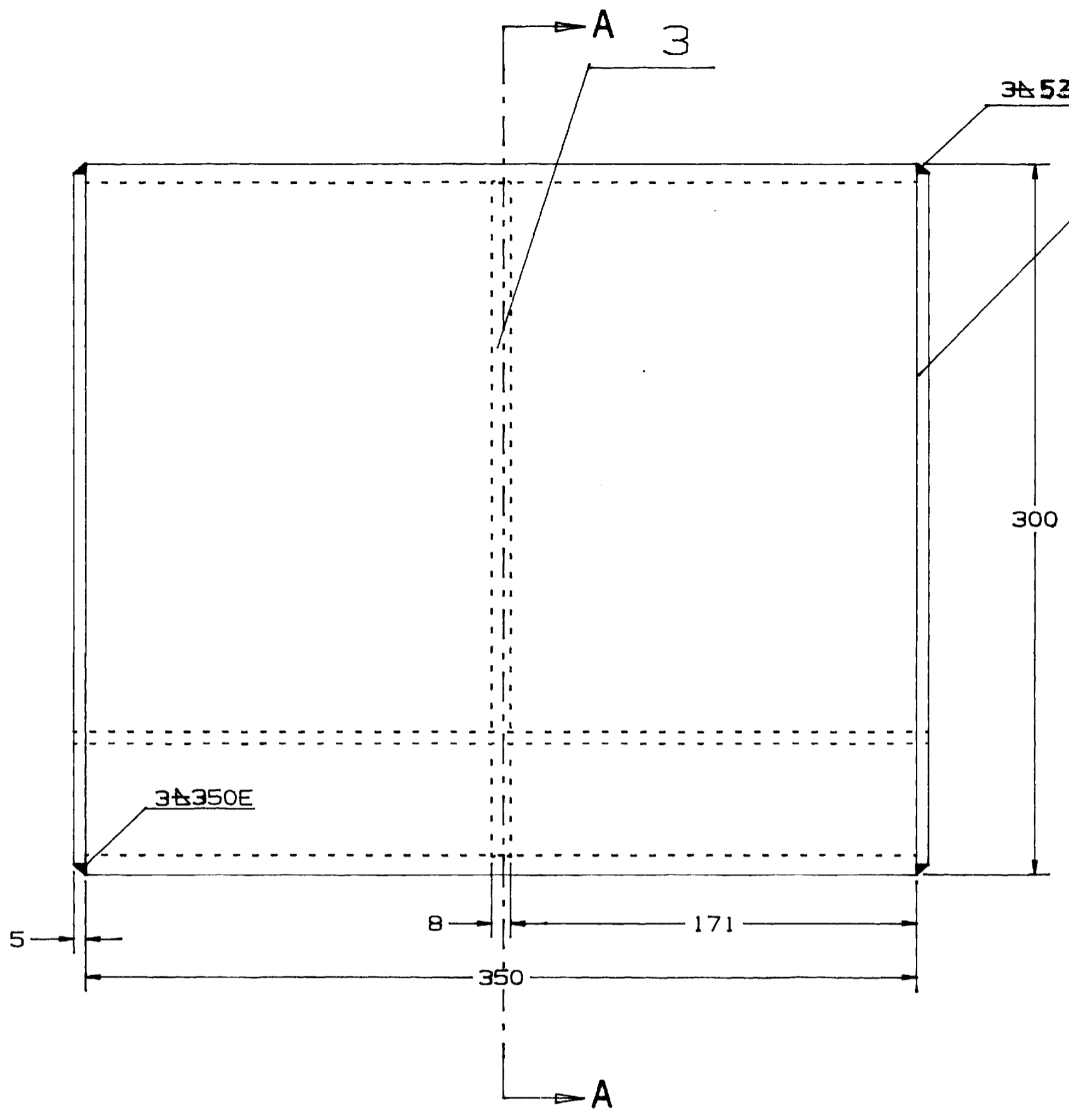


ALT. NO.	ALTERATIONS	INITIAL



SECTION AA

3	RIB FOR LIFTING PAD	1	CC11121				
2	COVER SHEET	2	CC11122				
1	LIFTING PAD FRONT SHEET	1	CC11120				
ITEM	DESCRIPTION & DIMENSIONS	NO. OF P.	REF. DRG.	MAT. & SPEC.	REMARKS		
GROUP UNDERFRAME				SUPERSEDED BY:			
LIFTING PAD				SUPERSEDES:			
				SCALE	SDO		
				1:2	CHD		
					TRD		
					DRN		
INDIAN RAILWAY STANDARDS				RAIL COACH FACTORY KAPURTHALA			
CODE NO.				DRG. NO.	CC11330		
				UG	SHEET OF		

RCF12
CONSOLE LOGIN

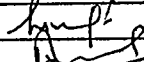
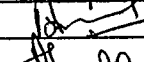
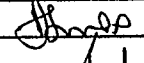
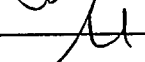
H.S. Jaiswal
16/1/1993

FOR UNTOLERANCED DIMENSIONS REFER RCFM 627.DP

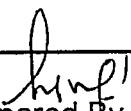
DY. QME/D A/E/D

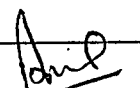
SCHEDULE	SCHEDULE OF INFRASTRUCTURAL REQUIREMENTS FOR MANUFACTURING & TESTING FOR LIFTING PAD TO DRAWING. NO. CC11330	MDST: 28 Rev: NIL PAGE 1 OF 3
		Dated 08.12.2005

SCHEDULE OF INFRASTRUCTURAL REQUIREMENTS FOR MANUFACTURING & TESTING FOR LIFTING PAD

NAME	DESIGNATION	SIGNATURE	DATE	LEVEL
Harish Kumar	SSE/VD		8/12/05	Prepared
Joginder Singh	ADE/VD		8/12/05	Agreed
Amitabh Sinha	Dy CME/TOT		9/12/05	Reviewed
S K Aggarwal	CDE		12/12/05	Approved

Issue/Rev	Details of Changes	Date


Prepared By


Agreed By

SCHEDULE	SCHEDULE OF INFRASTRUCTURAL REQUIREMENTS FOR MANUFACTURING & TESTING FOR LIFTING PAD TO DRAWING. NO. CC11330	MDST: 28 Rev: NIL PAGE 2 OF 3
		Dated 08.12.2005

1.0 REQUIREMENTS

1.1 This schedule is applicable for lifting pad to drawing. no. CC11330. The vendors seeking approval shall comply with all the requirements mentioned below:

2.0 GENERAL & MANUFACTURING FACILITIES

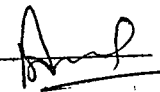
- 2.1 Covered area with adequate space underneath for storage of raw materials e.g. billets, round corner squares, rounds etc. The covered area should have display board showing different colour shades nominated to different grades of steel to avoid mix up of materials. Arrangement of painting the billets, RCS rounds etc with particular paint shade previously nominated according to the grade of steel should be available.
- 2.2 Minimum 1 No of shearing machine/ oxy-acetylene gas cutting machine of suitable capacity
- 2.3 Atleast one number of MIG/MAG or electric arc welding machine of suitable capacity and standard make shall be available.
- 2.4 Adequate Nos. of hand grinders for removal of fins & burrs shall be available.
- 2.5 The firm shall have atleast one power press of suitable capacity along-with punch and dies for component forming.
- 2.6 The raw material should be procured from authorized distributor of original manufacturer of steel and firm should procure material with test certificate from primary manufacturer
- 2.7 The firm shall comply with IS:822 regarding selection of weld wire, storage of consumables, calibration of welding equipment , training of welder, testing of welding and remedies for welding defects.
- 2.8 The welder shall have a minimum of 2 years experience of the same type of welding.
- 2.9 The firm shall have separate paint booth for doing priming of the component.
- 2.10 The firm shall have suitable facility of grit/shot blasting in-house.

3.0 TESTING FACILITIES

- 3.1 **Chemical Lab:** The firm should have permanent arrangement with NABL certified Lab or a reputed steel making company for arranging the spectro analysis of the material.
- 3.2 **Physical Testing Lab:** The firm must possess a well-equipped physical lab with following facilities:

- Universal testing machine of 40t capacity with load/ deflection plotting arrangement to


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SCHEDULE	SCHEDULE OF INFRASTRUCTURAL REQUIREMENTS FOR MANUFACTURING & TESTING FOR LIFTING PAD TO DRAWING. NO. CC11330	MDST: 28 Rev: NIL PAGE 3 OF 3
		Dated 08.12.2005

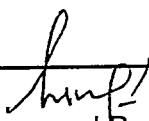
conduct UTS, Yield strength.

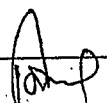
3.3 Other Testing Facilities: The firm shall possess the following:

- The firm shall have adequate facilities for preparation of test sample. Facilities like machining, grinding, polishing etc. should be available in house.
- Adequate number of fine punches for stamping marking particulars on finished components.
- Adequate numbers of measuring instruments such as:
 - Digital Vernier Calipers - 0 mm to 300 mm
 - Measuring scales – 1 meter
 - GO & NO-GO gauges.
 - Profile gauges
 - Set of radius gauge.

4.0. QUALITY CONTROL REQUIREMENTS

- 4.1 There should be a system to ensure the traceability of the product from raw material stage to finished product stage. This system should also facilitate to identify the raw material composition from the finish product stage.
- 4.2 The firm shall ensure that there is a QAP for the product detailing various aspects: -
- QA Organisational Chart
 - Flow Process Chart
 - Stage inspection details
 - Various parameters and to ensure control over them
- 4.3 There should be at least one full time technologist having a minimum bachelor's degree in relevant field & 5 years experience or a person with diploma in relevant field with 12 years experience.
- 4.4 The firm should have acquired ISO: 9000 series certification and the product for which an approval is sought should be broadly covered in the scope of the certification for manufacture and supply.
- 4.5 The Quality manual of the firm for ISO: 9000 should clearly indicate at any stage the control over manufacturing and testing of the said railway product.
- 4.6 The firm shall ensure that proper analysis is being done on monthly basis to study the rejection at various internal stages and it is documented.
- 4.7 The firm shall ensure that all the relevant specifications, IS standards are available with them.


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