

## **ACCEPTANCE CRITERIA FOR MEMU ROOF ASSY :**

**Drawing Nos:** 849-46004, 849-46010

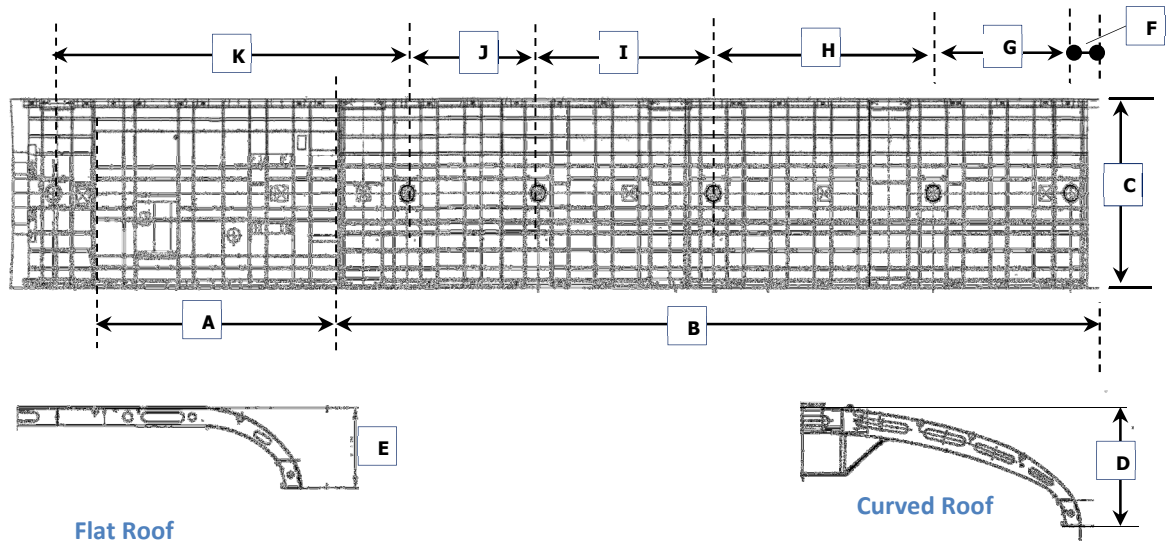
[Refer latest revision of drawings provided by BEML]

S NO	PROCESS	ACCEPTANCE CRITERIA
1	WELDING	
	a) Visual check	BEML STD: RD 230, FINE CLASS
	b) Finish	i) Spatter free ii) <b>Pickling and Passivation</b> of all Stainless steel to Mild steel weld joints
	c) Leak Proof test  (Note: Care shall be taken to clean the joints after the test.)	All welded joints in Roof assy to be 100 % Leak proof.  Leak test to be carried out using Chalk powder and thinner.
	d) Stich / Skip Welding	Length of bead and in-between (pitch) distance shall be maintained as per drawing.
	e) Fillet / Butt Welding Size	Size of weld shall be maintained strictly as per drawing requirement.  Shall be checked using Weld Gauge.
2	CRITICAL TO QUALITY DIMENSIONS	
	a) For critical dimensions – refer <b>Annexure - 1</b>	
	b) Drill & Tap	i) 100% Quality Assurance of all Threaded holes by using Thread Plug Gauge  ii) Pitch dimensions shall be ensured using Checking Template  iii) Holes to be checked using plug gauges  iv) Ensure 100% Burr Free Holes
	c) Orientation & Location of Fan mount brackets	Should be strictly as shown in drawing.
3	PAINTING	Red-oxide Painting on hidden areas
4	FUNCTIONAL	i) ON SITE FIT UP – No Mismatch ii) Free from damages, dents or holes
5	IDENTIFICATION & TRACEABILITY	Name Plate details (to be welded) i) Vendor Code ii) MFD DATE (MM/YY) iii) SL.NO FORMAT DMC- (01 to PO Qty)

# ANNEXURE - 1

<b>VENDOR NAME</b>	<b>INSPECTION CHECK LIST FOR ROOF STRUCTURE ASSY MEMU/DMC COACH</b>	<b>DOC. No.</b>	<b>QE-FR-546</b>
		<b>Doc.DATE</b>	<b>11.07.2019</b>
		<b>Rev. No.</b>	<b>Nil</b>
		<b>Rev. Date</b>	<b>--</b>
		<b>PAGE No</b>	<b>1</b>

<b>PROJECT</b>	<b>DRAWING NO.</b>	<b>Roof Serial No</b>	<b>DATE</b>
<b>MEMU</b>	<b>849-46004 Alt.Latest</b>	<b>DMC-RF-</b>	

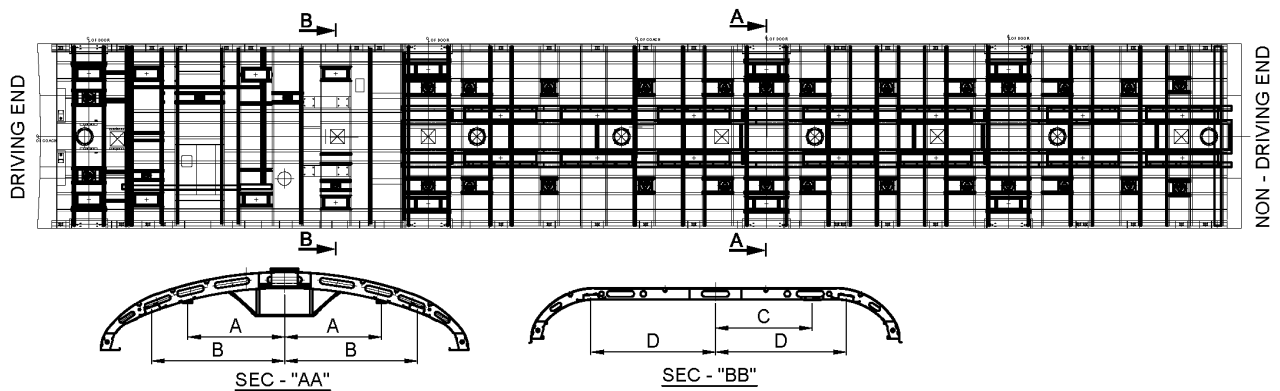


ITEM	DESCRIPTION OF THE PARAMETER	REQ.DIM (mm)	ACTUAL DIM (mm)	Remarks
(A)	Length of Flat roof section	4820±5		
(B)	Length of curved roof section @ Non Driving End	14820±7		
(C)	Width of Roof structure assy	3247±4		
(D)	Height of curved roof section	689±2		
(E)	Height of Flat roof section	448±2		
(F)	Location of 1 <sup>st</sup> Roof Ventilator from N.D.End	570±2		
(G)	Distance b/w 1 <sup>st</sup> and 2 <sup>nd</sup> Roof ventilators	2678±4		
(H)	Distance b/w 2 <sup>nd</sup> and 3 <sup>rd</sup> Roof ventilators	4282±5		
(I)	Distance b/w 3 <sup>rd</sup> and 4 <sup>th</sup> Roof ventilators	3417±4		
(J)	Distance b/w 4 <sup>th</sup> and 5 <sup>th</sup> Roof ventilators	2553±4		
(K)	Distance b/w 5 <sup>th</sup> and 6 <sup>th</sup> Roof ventilators	6930±5		
(L)Miscellaneous	i) Location of all Carlines			
	ii) Leak testing of welded joints in roof by Chalk and Kerosene method		Accepted/Rejected (tick mark)	
	iii) Visual check for Welding defects			
	iv) BOM Verification	No.of items Required		
		No.of items Installed		

QE Inspector

<b>VENDOR NAME</b>	<b>INSPECTION CHECK LIST FOR LOCATION OF SUPPORTS &amp; BRACKET FOR ROOF ASSY – MEMU 3 PHASE DMC</b>	DOC. No.	
		Doc.DATE	
		Rev. No.	
		Rev. Date	
		PAGE No	

Project	Model	Drawing No.	Roof Serial No.	Date
MEMU	849	849 - 46010 Alt. --	DMC-RF-	



Sl.No	Description	Drawing Dimension (mm)	Observed Dimension (mm)	Remarks
1.	Location of Fan Bracket – A (Sec – AA)	855±3 (852-858)		
2.	Location of Lamp Bracket– B (Sec – AA)	1175±4 (1171-1179)		
3.	Location of Fan Bracket - C (Sec – BB)	855±3 (852-858)		
4.	Location of F.L Bracket – D (Sec – BB)	1100±4 (1096-1104)		

SNAGS OBSERVED AND RECORDED		REMARKS
Dimensional deviations		
Visual check for welding		
Status of inspection	Accepted/Rejected	

QE - Inspector