

8.8 Lubrication & Painting

Only dry lubricant shall be applied to the coupler head or the coupler head fittings. This lubricant may be applied using water, alcohol, or other non-petroleum based carrier.
Painting.

Only exposed surfaces of Coupler and Yoke shall be painted with Black quick drying paint after inspection. Painting scheme and paint to be used shall be part of the approved QAP. Paint must not be applied to the inside of the Coupler or internal fittings. Painting shall be done after the completion of inspection on Coupler & Yoke of acceptable casting lot.

Any deviation in lubrication or painting is permitted only with prior approval of DG/Wagon/RDSO.

9.0 GUARANTEE

The coupler supplied shall be accompanied by a guarantee for a period of 72 months from the date of supply or 60 months from the date of fitment, whichever is earlier.

10.0 RECORD OF INTERNAL ACCEPTANCE TESTS:

The manufacturer will maintain a list of all internal acceptance tests being carried out by him at various stages of manufacturing of the product. Proper record of such internal acceptance tests shall be maintained by him and also included in the QAP. At the time of inspection of the product, these records shall be put up to the Inspecting Authority for scrutiny and countersign.

The manufacturer shall maintain records for a minimum period of six(6) years of all weights, mechanical test reports, chemical test reports and heat treatment records applicable to the purchased castings. These records shall be made available to the purchaser upon request. The manufacturer shall also maintain records for a minimum of six(6) years that provide traceability from the serial number of individual castings, where applicable to the records stated above.

11.0 MINIMUM FOUNDRY INFRASTRUCTURE REQUIREMENTS

- 11.1 A foundry producing coupler castings should have the capacity to produce at least 5000 couplers and coupler components per year.
- 11.2 To ensure dimensional and feature control, the castings shall be produced by one of the following moulding processes mentioned in Clause 5.3.3 of this specification for which the necessary infrastructure should be available.
- 11.3 The foundry must have the ability to conduct all the tests mentioned in this specification.
- 11.4 Chemically bonded no bake sands out of a articulated continuous mixer with PLC control shall be used to produce casting cores for which necessary infrastructure should be available.
- 11.5 Melting furnace capacity should be a minimum of 5 MT utilizing electric arc.
- 11.6 Heat treating furnaces should be capable of holding at least 3 MT of castings and reaching and maintaining temperatures of 950 deg C. Furnaces should have automatic temperature control and be capable of operating as low as 500 deg C and fitted with an automatic digital recorder.
- 11.7 Other equipment to meet the requirements of this specification should be available.
- 11.8 The foundry shall hold a valid Quality Assurance Certification as per AAR M1003 or ISO 9001.