

**North Western Railway  
Process Inspection Details**

<b>Stock/Non-Stock</b>	Non-Stock	<b>Brief Item Description</b>	Elastic rail Clips MK-V as per RDSO Drawing No. T-5919, Specification No. IRS/T-31-2021 (Fifth Revision)
<b>Main Group (for NS items)</b>	60- Permanent Way and Bridge Work	<b>Sub Group (for NS Items)</b>	10 – Elastic Rail Clips
<b>Minimum Lot Quantity</b>	35000	<b>Unit</b>	Numbers

<b>Whether Shift Working Implemented</b>	Yes	<b>Number of Shifts in day</b>	Three
--	-----	--------------------------------	-------

<b>Process No.</b>	<b>Process Description</b>	<b>Manpower Required (Nos) (1<sup>st</sup> Shift)</b>	<b>Manpower Required (Nos) (2<sup>nd</sup> Shift)</b>	<b>Manpower Required (Nos) (3<sup>rd</sup> Shift)</b>
1	Checking of length of cut bars	1	1	1
2	Turning length	1	1	1
3	MPI Test	1	1	1
4	Forging temperature	1	1	1
5	Checking of die	1	1	1
6	Quenching temperature and duration	1	1	1
7	Quenching hardness	1	1	1
8	Tempering temperature and duration	1	1	1
9	Dimension check	1	1	1
10	Hardness of finished ERC	1	1	1
11	Documentation	1	1	1

<b>General Remarks</b>	Process inspection methodology in terms of Railway Board letter No. 2024/RS(G)/779/12(E3482675) dt- 06.01.25 and as laid down in the Railway Board letter No. 2022/RS(G)/779/8 dated 18.03.24.
------------------------	--