

4830805/2026/O/a WM/Design/DMW/PTA

Stage inspection of items/components/sub-assemblies of 3-ph TM type 6FRA 6068:

Sl. No.	Description	UVAM Item ID	Stage Inspection required	No. of stages with description of each stage (NA/1/2/3)	Warranty period (in months) from date of delivery
* 1	3-ph Traction Motor type 6FRA 6068	2100438	Yes	No. of Stage- 01 No. (Excluding final routine inspection) Stage-1 : a) Verification of purchase document of raw material. b) Dimensional Inspection of Machined Stator & Associated Components of Machined Stator i.e.11 components by 3D CMM. Above tests to be done as per Specification No. 4TMS.096.080 & 081 (latest), Clause No. 7.5.2.	As per IRS condition
2	Set of Stator & Rotor Stamping (05 items in a set) of TM type 6FRA 6068	2100421	Yes	No of Stage- 01 No.(Excluding final routine inspection) Stage-1: Raw material Inspection of CRNO Steel Sheet as per Specification No. 4TMS.096.053 (latest) Clause No. 2.2 and Metallurgical test of raw material of end plate as per RDSO's L/No. EL/3.2.182 dtd. 17/07/2014.	As per IRS condition
3	Associated components of machined stator assembly of TM type 6FRA 6068	2100501	Yes	No of Stage- 01 No. (Excluding final routine inspection) Stage-1: Metallurgical & Radiography inspection of casting as per Specification No. 4TMS.096.068 (latest) Clause No. 4.3. (i) & 5.0	As per IRS condition

* **Note:** Stage inspection of 3-ph Traction Motor type 6FRA 6068, UVAM Item Id: 2100438 has to be carried out as per Specification No. 4TMS.096.080 & 081 (latest), Clause No. 7.5.2. Warranty: As per IRS condition.



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SN	Description	UVAM Item ID	Stage Inspection required	No. of stages with description of each stage (NA/1/2/3)	Warranty period (in months) from date of delivery
4	Complete Wound Stator Assly. of TM type 6FRA 6068	2100427	Yes	No of Stages- 01 No. (Excluding final routine inspection) Stage-1: (a) Inspection of Coils, (b) Core Loop test of Machined Stator, (c) Dimension Measurement of machined Stator by 3D CMM (d) Verification of purchase document of raw material Above tests to be done as per Specification No. 4TMS.096.089 (latest) Clause No. 6.2.1, 6.3 (b), (f) & (g).	As per IRS condition
5	Complete Rotor Assly. of TM type 6FRA 6068	2100429	Yes	No of Stage- 01 No. (Excluding final routine inspection) Stage-1: Verification of purchase document of raw material as per Routine Test Schedule No. QA/TM/Rotor/17340 dtd. 25/04/2023 Clause No. 8.1 for sch-II design rotor & QA/TM/Rotor/17340/Sch-I dtd. 27/02/2024 Clause No. 8.1 for sch-I design rotor	As per IRS condition
6	Set of stator chamber DE & nDE	2100454	Yes	No of Stage- 01 No. (Excluding final routine inspection) Stage-1: Chemical, Mechanical & Radiography inspection of casting as per Specification No. 4TMS.096.059 (latest) Clause 4.1 (b) to (e).	As per IRS condition
7	Rotor Bar for Sch-I & Sch-II Rotors	2100425	No	NA RDSO's specification is followed.	As per IRS condition
8	Rotor Shaft (Rough Machined)	2100477	Yes	No of Stage- 01 No. (Excluding final routine inspection) Stage-1: Metallurgical Inspection of forged shaft as per Specification No. 4TMS.096.051 (latest) Clause No. 7.0	As per IRS condition
9	Winding Wire Flat Fl Cu Fo 13 CR	2100428	No	NA	As per IRS condition

