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Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

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|-----------|--------------|
| Form No. | CNC/QA/FM/02 |
| Rev. No. | 01 |
| Rev. Date | 31-07-2013 |

Inprocess Inspection (Pellet Dies)

| S.No. | Check Parameter | Specification | Observations | Remarks |
|-------|---------------------------------------|------------------------|---|--------------------------------------|
| 1 | Work Order No. | | 12776 ✓ | 66/66 ✓ |
| 2 | Machined By | | V.T.L M/c Shop | Dwg No- LSD 609 |
| 3 | Pallet Die No. | | 13278 (10.0mm) | (REV 01) ✓ |
| 4 | Die Category | Drg. No. | M. Jumbo 2200Vc-413mm | |
| 5 | Out Side Diameter | Drg. No. | 680-1mm Step OD- 693mm | Step Length- 31mm |
| 6 | Inside Diameter | Drg. No. | 548-12mm | ✓ |
| 7 | Width of Pellet Die | Drg. No. | 195mm ✓ | |
| 8 | Grooves as per Drawing | Drg. No. | 32 X 7 X 8mm / 32 X 7 X 8mm | 4 X 8mm |
| 9 | Fitting Sizes on CNC Plate | Drg. No. | OK | [Tapping No. of Holes 4 Both Side] |
| 10 | Drilling Area Surface Smoothness | | OK | |
| 11 | Tapping Operator | | M/c Shop | |
| 12 | Tapping PCD | | 619mm ✓ | ✓ |
| 13 | Tapping Hole Diameter | | M16 Check by M16 Bolt | Face Side Step 2mm |
| 14 | Tapping On Second Side | Half pitch of 1st side | OK ✓ | Deep Both Side |
| 15 | Tapping Hole Depth | | Drill Depth- 34mm Tapping Depth- 31.8mm | ✓ |
| 16 | Perpendicularity of Tapped Hole | | Yes | ✓ |
| 17 | Visual Inspection Before Gun Drilling | | OK | |

Inspected By (Sign) & Date

Ramanpreet Singh 02/09/14

| | | | | |
|---|--------------------------------|--------|----|--|
| 1 | As per programme no. | | — | |
| 2 | Gun Drilling Work Completed On | | — | |
| 3 | Hole Finish In Gun Drilling | Marked | OK | |
| 4 | Defective Holes (If Any) | | No | |

Note : Mark the defective holes/missed holes with the help of Permanent Marker

Counter- 60° Row- 8 ✓

| | | | | | | | |
|---|--|-----------|------------------|----|----|--|--|
| 1 | Counter Sinking Depth & Finish | OK | | | | | |
| 2 | External Relief Dia | No Relief | — | | | | |
| 3 | External Relief Depth | | — | | | | |
| 4 | Inspection Done Before Hardening By (Name) | | Ramanpreet Singh | | | | |
| 5 | Material Sent For Hardening By (Name) | | Lark Furnace | | | | |
| 6 | Material Sent For Hardening On Date | | 02 | 09 | 14 | | |

Inspected By (Sign) & Date

Ramanpreet Singh 02/09/14

Signature
21/9/14

Reviewed by (Engineer-CNC)

Manager-QA