CNC/QA/FM/02

5960

# Lark Engineering Company (India) Pvt. Ltd.

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

| 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. | | 9965 | 55/60 |
| 2 | Machined By | | V.T.L M/c Shop | Drg No: 1.3.D.408 |
| 3 | Pallet Die No. | | 10645 (10.0) mm | Rev: 00 |
| 4 | Die Category | Drg. No. | M. Jumbo | |
| 5 | Out Side Diameter | Drg. No. | 720 mm Step OD = 693 mm | Tapper = 12° |
| 6 | Inside Diameter | Drg. No. | 600.12 mm | Step length = 20 mm |
| 7 | Width of Pellet Die | Drg. No. | 222 mm | |
| 8 | Grooves as per Drawing | Drg. No. | 12×8×7 mm / 12×8×7 mm | |
| 9 | Fitting Sizes on CNC Plate | Drg. No. | ok | |
| 10 | Drilling Area Surface Smoothness | | ok | |
| 11 | Tapping Operator | | M/c Shop | Tapping No of Holes = 12 Both Side |
| 12 | Tapping PCD | | 640 mm | |
| 13 | Tapping Hole Diameter | | M20 Check by M20 Bolt | |
| 14 | Tapping On Second Side | Half pitch of 1st side | ok | |
| 15 | Tapping Hole Depth | | Drill Depth = 20.4 mm Tapping Depth = 18.7 | |
| 16 | Perpendicularity of Tapped Hole | | yes | |
| 17 | Visual Inspection Before Gun Drilling | | ok | |
| | **Inspected By (Sign) & Date** | | Ravi 18/8/23 | |
| 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

| | | | | | | | | |
|---|---|---|---|---|---|---|---|---|
| 1 | Counter Sinking Depth & Finish | ok | | | | | | Row = 13 |
| 2 | External Relief Dia | 10.5 mm | Outside (3-3) | | Inner | | | |
| 3 | External Relief Depth | | 15 mm | | 5 mm | | | |
| 4 | Inspection Done Before Hardening By (Name) | | Ravi | | | | | |
| 5 | Material Sent For Hardening By (Name) | | Lark Furnace | | | | | |
| 6 | Material Sent For Hardening On Date | | 18 | 8 | 23 | | | |
| | **Inspected By (Sign) & Date** | | Ravi 18/8/23 | | | | | |

18/8/23

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner