

8478

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. | | 13234 | 39/50 |
| 2 | Machined By | | V.T.L. NLC Shop | Dry No. Lark 3370 |
| 3 | Pallet Die No. | | 13265 (3.5) mm | |
| 4 | Die Category | Dr. No. | cut side | |
| 5 | Out Side Diameter | Dr. No. | 620 mm Step OD = 612 mm | Step length 19.4 |
| 6 | Inside Diameter | Dr. No. | 520.12 mm | |
| 7 | Width of Pellet Die | Dr. No. | 222 mm | |
| 8 | Grooves as per Drawing | Dr. No. | 13x8x5 mm 13x8x5 mm | |
| 9 | Fitting Sizes on CNC Plate | Dr. No. | ok | |
| 10 | Drilling Area Surface Smoothness | | ok | |
| 11 | Tapping Operator | | NLC Shop | Tapping No. of holes 12 Both Side |
| 12 | Tapping PCD | | 565 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 8.6 |
| 16 | Perpendicularity of Tapped Hole | | yes | |
| 17 | Visual Inspection Before Gun Drilling | | ok | |

Inspected By (Sign) & Date *Ravi 06/11/24*

| | | | |
|---|--------------------------------|--------|----|
| 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 = 35

| | | | | | | |
|---|--|--------|---------------------|-------|----|--|
| 1 | Counter Sinking Depth & Finish | ok | | | | |
| 2 | External Relief Dia | 4.0 mm | Outside (3-3) | Inner | | |
| 3 | External Relief Depth | | 18 mm | 11 mm | | |
| 4 | Inspection Done Before Hardening By (Name) | | <i>Ravi</i> | | | |
| 5 | Material Sent For Hardening By (Name) | | <i>Lark Porware</i> | | | |
| 6 | Material Sent For Hardening On Date | | 6 | 11 | 24 | |

Inspected By (Sign) & Date *Ravi 6/11/24*

Reviewed by (Engineer-CNC) *Satish 6/11/24*

Manager-QA