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# 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

## Inprocess Inspection (Pellet Dies)

Rev. Date 31-07-2013

| S.No. | Check Parameter                       | Specification          | Observations                                | Remarks                            |
|-------|---------------------------------------|------------------------|---|------------------------------------|
| 1     | Work Order No.                        |                        | 9880  | 45/60                              |
| 2     | Machined By                           |                        | V.T.L. n/c Stop                             | Dry No. 180-584                    |
| 3     | Pallet Die No.                        |                        | 10474 (8.0) n/c                             | Ren=01                             |
| 4     | Die Category                          | Drg. No.               | Jumbo                                       |                                    |
| 5     | Out Side Diameter                     | Drg. No.               | 780 n/c Step 002 798 n/c / 797.9 n/c        | Tapping 4                          |
| 6     | Inside Diameter                       | Drg. No.               | 660.12 n/c                                  | Step length = 25.5 n/c             |
| 7     | Width of Pellet Die                   | Drg. No.               | 324 n/c                                     | Under note = 8.9 n/c               |
| 8     | Grooves as per Drawing                | Drg. No.               | 21.57 8 x 1 n/c   21.57 8 x 10 n/c          |                                    |
| 9     | Fitting Sizes on CNC Plate            | Drg. No.               | ok  |                                    |
| 10    | Drilling Area Surface Smoothness      |                        | ok  |                                    |
| 11    | Tapping Operator                      |                        | n/c Stop                                    | Tapping No of holes = 12 Both Side |
| 12    | Tapping PCD                           |                        | 785 n/c                                     |                                    |
| 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 = 30.4 n/c Tapping Depth = 28.7 |                                    |
| 16    | Perpendicularity of Tapped Hole       |                        | yes   |                                    |
| 17    | Visual Inspection Before Gun Drilling |                        | ok  |                                    |

Inspected By (Sign) & Date

Ravi 8/6/23

|   |                                |        |    |   |
|---|--------------------------------|--------|----|---|
| 1 | As per programme no.           |        |    | 2 Slot<br>32.1 n/c width & n/c Deep Both Side |
| 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      |               |             |         |   |    |  |  | Len=28 |
| 2                          | External Relief Dia                        | 8.5 n/c | outside (2-3) |             | inner   |   |    |  |  |        |
| 3                          | External Relief Depth                      |         | 2.3 n/c       |             | 1.5 n/c |   |    |  |  |        |
| 4                          | Inspection Done Before Hardening By (Name) |         |               |             | Ravi    |   |    |  |  |        |
| 5                          | Material Sent For Hardening By (Name)      |         |               |             | Keshav  |   |    |  |  |        |
| 6                          | Material Sent For Hardening On Date        |         |               |             | 8       | 6 | 25 |  |  |        |
| Inspected By (Sign) & Date |  |         |               | Ravi 8/6/23 |         |   |    |  |  |        |

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Reviewed by (Engineer-CNC)

Manager-QA