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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

Rev. Date

31-07-2013

Inprocess Inspection (Pellet Dies)

| S.No. | Check Parameter | Specification | Observations | Remarks |
|-------|---------------------------------------|------------------------|--------------------------|-------------------------------|
| 1 | Work Order No. | | 13201 | |
| 2 | Machined By | | M72 MIC Shop | 55/100 |
| 3 | Pallet Die No. | | 12258 (8.0) | 2 Drg N 9743 P/B |
| 4 | Die Category | Drg. No. | S. Jumbo | |
| 5 | Out Side Diameter | Drg. No. | 1051 mm | OP Step - 1041.8 mm |
| 6 | Inside Diameter | Drg. No. | 851.1 mm one side | And so - 846 mm |
| 7 | Width of Pellet Die | Drg. No. | 50 X 11 X 12.8 mm | 11 and so - 33 X 17 X 10.5 mm |
| 8 | Grooves as per Drawing | Drg. No. | 251 mm | Tap - 15° |
| 9 | Fitting Sizes on CNC Plate | Drg. No. | OK | Tap - 4° |
| 10 | Drilling Area Surface Smoothness | | OK | |
| 11 | Tapping Operator | | MIC Shop | Tapping No of |
| 12 | Tapping PCD | | 958 mm | Holes - 24 holes |
| 13 | Tapping Hole Diameter | | M30 Check M30 Best | |
| 14 | Tapping On Second Side | Half pitch of 1st side | OK | |
| 15 | Tapping Hole Depth | | Drilling Depth - 43.2 mm | Tapping Depth - 40.3 mm |
| 16 | Perpendicularity of Tapped Hole | | Yes | |
| 17 | Visual Inspection Before Gun Drilling | | OK | |

Inspected By (Sign) & Date

[Signature] 18/11/24

| | | | |
|---|--------------------------------|--------|----|
| 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 - 30°

| | | | | | | | |
|---|--|-------|-----------|----|----|--|--|
| 1 | Counter Sinking Depth & Finish | OK | | | | | |
| 2 | External Relief Dia | Ø 9.0 | Rel | | | | |
| 3 | External Relief Depth | | 45 mm | | | | |
| 4 | Inspection Done Before Hardening By (Name) | | Sanjiv | | | | |
| 5 | Material Sent For Hardening By (Name) | | work from | | | | |
| 6 | Material Sent For Hardening On Date | | 18 | 11 | 24 | | |

Inspected By (Sign) & Date

[Signature] 18/11/24

[Signature] 18/11/24

Reviewed by (Engineer-CNC)

Manager-QA