

8660



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. | | 13135 | 45/60 |
| 2 | Machined By | | V. T. L. H/C Shop | Drg No. 1-3-02 174 |
| 3 | Pallet Die No. | | 13420 (8.0) H/C | Rev. 00 |
| 4 | Die Category | Drg. No. | M. Jumbo | |
| 5 | Out Side Diameter | Drg. No. | 720 H/C Step OD: 693 H/C | Tapber 12° |
| 6 | Inside Diameter | Drg. No. | 600.12 H/C | Step length 20 H/C |
| 7 | Width of Pellet Die | Drg. No. | 222 H/C | |
| 8 | Grooves as per Drawing | Drg. No. | 12 x 8 x 5 H/C 12 x 8 x 5 H/C | |
| 9 | Fitting Sizes on CNC Plate | Drg. No. | ok | |
| 10 | Drilling Area Surface Smoothness | | ok | |
| 11 | Tapping Operator | | H/C Shop | Tapping of Holes 12° Both Side |
| 12 | Tapping PCD | | 640 H/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: 20.3 H/C Tapping Depth: 18.6 H/C | |
| 16 | Perpendicularity of Tapped Hole | | Yes | |
| 17 | Visual Inspection Before Gun Drilling | | ok | |

Inspected By (Sign) & Date Ravi 30/11/24

| | | | |
|---|--------------------------------|--------|-------|
| 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

| | | | | | | | |
|---|--|---------|---------------|----|--------|--|-------------------------|
| 1 | Counter Sinking Depth & Finish | ok | | | | | Counter: 60° Rev: 18 |
| 2 | External Relief Dia | 8.5 H/C | outside (3-3) | | Inner | | |
| 3 | External Relief Depth | | 23 H/C | | 15 H/C | | |
| 4 | Inspection Done Before Hardening By (Name) | | | | | | Ravi |
| 5 | Material Sent For Hardening By (Name) | | | | | | Lark Porrace |
| 6 | Material Sent For Hardening On Date | | 09 | 11 | 24 | | |

Inspected By (Sign) & Date Ravi 20/11/24

Reviewed by (Engineer-CNC) Satyam 21/11/24

Manager-QA