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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.                        |                        | 13634 ✓                             | 48/50 ✓                         |
| 2     | Machined By                           |                        | V.T.C. N/C Shop                     | Drg No. - 1.2.01/8038           |
| 3     | Pallet Die No.                        |                        | 12772 (6.0) H4 ✓                    | Rev. 2.00 ✓                     |
| 4     | Die Category                          | Drg. No.               | Junior                              |                                 |
| 5     | Out Side Diameter                     | Drg. No.               | 42.2 H4 ✓                           | Step OD - 39.5 H4 ✓             |
| 6     | Inside Diameter                       | Drg. No.               | 32.12 H4 ✓                          | Step length - 14.5 ✓            |
| 7     | Width of Pellet Die                   | Drg. No.               | 142 H4 ✓                            |                                 |
| 8     | Grooves as per Drawing                | Drg. No.               | 15.5 x 7 x 2 H4 / 15.5 x 7 x 2 H4 ✓ |                                 |
| 9     | Fitting Sizes on CNC Plate            | Drg. No.               | ok                                  |                                 |
| 10    | Drilling Area Surface Smoothness      |                        | ok                                  |                                 |
| 11    | Tapping Operator                      |                        | N/C Shop                            | Tapping H. of 4.12.08 Both Side |
| 12    | Tapping PCD                           |                        | 355 H4 ✓                            |                                 |
| 13    | Tapping Hole Diameter                 |                        | M16 - Check by M16 Bolt ✓           |                                 |
| 14    | Tapping On Second Side                | Half pitch of 1st side | ok                                  |                                 |
| 15    | Tapping Hole Depth                    |                        | Drill Depth - 20.2 H4 ✓             | Tapping Depth - 18.5 H4 ✓       |
| 16    | Perpendicularity of Tapped Hole       |                        | yes                                 |                                 |
| 17    | Visual Inspection Before Gun Drilling |                        | ok                                  |                                 |

**Inspected By (Sign) & Date**

Ravi 8/125

|   |                                |        |       |
|---|--------------------------------|--------|-------|
| 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-Bo

|   |  |          |                 |   |              |  |  |  |  |  |
|---|--|----------|-----------------|---|--------------|--|--|--|--|--|
| 1 | Counter Sinking Depth & Finish             | ok       |                 |   |              |  |  |  |  |  |
| 2 | External Relief Dia                        | 6.5 H4 ✓ | 60 R side (2-2) |   | Inner        |  |  |  |  |  |
| 3 | External Relief Depth                      |          | 8 H4 ✓          |   | 2 H4 ✓       |  |  |  |  |  |
| 4 | Inspection Done Before Hardening By (Name) |          |                 |   | Ravi         |  |  |  |  |  |
| 5 | Material Sent For Hardening By (Name)      |          |                 |   | Lark furnace |  |  |  |  |  |
| 6 | Material Sent For Hardening On Date        |          | 8               | 1 | 25           |  |  |  |  |  |

**Inspected By (Sign) & Date**

Ravi 8/125

Reviewed by (Engineer-CNC)

Manager-QA