

9210

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. | | 14154 ✓ | 91/40 ✓ |
| 2 | Machined By | | V.T.L. H/C Shop | Dy. H. 26.03.21 |
| 3 | Pallet Die No. | | 13309 (2.8) H/C | Raw. 01 ✓ |
| 4 | Die Category | Drg. No. | Senior | |
| 5 | Out Side Diameter | Drg. No. | 500 H/C Shop 00.499 H/C | Tapper. 12° |
| 6 | Inside Diameter | Drg. No. | 420 H/C | Step length 17 H/C |
| 7 | Width of Pellet Die | Drg. No. | 158 H/C | |
| 8 | Grooves as per Drawing | Drg. No. | 12x8x3 H/C 12x8x3 H/C | |
| 9 | Fitting Sizes on CNC Plate | Drg. No. | ok | |
| 10 | Drilling Area Surface Smoothness | | ok | |
| 11 | Tapping Operator | | H/C Shop | Tapping H/C of holes. 8 Both Side |
| 12 | Tapping PCD | | 454 H/C | |
| 13 | Tapping Hole Diameter | | 0314" ± Check by 0316" B.H | |
| 14 | Tapping On Second Side | Half pitch of 1st side | ok | |
| 15 | Tapping Hole Depth | | Drill Depth 18.3 H/C Tapping | Depth 16.6 H/C |
| 16 | Perpendicularity of Tapped Hole | | yes | |
| 17 | Visual Inspection Before Gun Drilling | | ok | |

Inspected By (Sign) & Date

Ravi 17/2/25

| | | | |
|---|--------------------------------|--------|-------|
| 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 Bore Raw. 28 |
| 2 | External Relief Dia | 3.3 H/C | 200 Side (2-2) | Inner | | | | | |
| 3 | External Relief Depth | | 22 H/C | 19 H/C | | | | | |
| 4 | Inspection Done Before Hardening By (Name) | | | | | | | | Ravi |
| 5 | Material Sent For Hardening By (Name) | | | | | | | | Lark Forance |
| 6 | Material Sent For Hardening On Date | | 17 | 2 | 25 | | | | |

Inspected By (Sign) & Date

Ravi 17/2/25

Satyam 17/2/25

Reviewed by (Engineer-CNC)

Manager-QA