

9878



# 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.                             |                        | 14905                | 36/45              |
| 2                                                                              | Machined By                                |                        | V. T. L. H/c Shop    | Dr. No. 13.02.29   |
| 3                                                                              | Pallet Die No.                             |                        | 14110 (3.0) H/c      | Rev. 00            |
| 4                                                                              | Die Category                               | Drg. No.               | SS870                |                    |
| 5                                                                              | Out Side Diameter                          | Drg. No.               | 610 H/c              | Step length 2mm    |
| 6                                                                              | Inside Diameter                            | Drg. No.               | 520.14 H/c           | Under cut 1.5mm    |
| 7                                                                              | Width of Pellet Die                        | Drg. No.               | 186 H/c              |                    |
| 8                                                                              | Grooves as per Drawing                     | Drg. No.               | 13x8x3 H/c           | 13x8x3 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        |
| 12                                                                             | Tapping PCD                                |                        | 565 H/c              | of H/c 12          |
| 13                                                                             | Tapping Hole Diameter                      |                        | H/c 12               | Back Side          |
| 14                                                                             | Tapping On Second Side                     | Half pitch of 1st side | ok                   |                    |
| 15                                                                             | Tapping Hole Depth                         |                        | Drill Depth 20.3 H/c | Tapping Depth 18.5 |
| 16                                                                             | Perpendicularity of Tapped Hole            |                        | yes                  |                    |
| 17                                                                             | Visual Inspection Before Gun Drilling      |                        | ok                   |                    |
| Inspected By (Sign) & Date                                                     |                                            |                        | Ravi 16/5/25         |                    |
| 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                     |                      | Count 60           |
| 2                                                                              | External Relief Dia                        | 3.5 H/c                | outside (2.3)        | Inner              |
| 3                                                                              | External Relief Depth                      |                        | 15 H/c               | 9 H/c              |
| 4                                                                              | Inspection Done Before Hardening By (Name) |                        | Ravi                 |                    |
| 5                                                                              | Material Sent For Hardening By (Name)      |                        | Lark Porrore         |                    |
| 6                                                                              | Material Sent For Hardening On Date        |                        | 16                   | 5                  |
| Inspected By (Sign) & Date                                                     |                                            |                        | Ravi 16/5/25         |                    |

Reviewed by (Engineer-CNC)

Manager-QA