

6485



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. | | 10416 | 35/10 |
| 2 | Machined By | | V.T.L. n/c Shop | Dy. No. Lark 3310 |
| 3 | Pallet Die No. | | 10939 (4.0)HH | |
| 4 | Die Category | Drg. No. | Senior | |
| 5 | Out Side Diameter | Drg. No. | 499 HH / Step OD = 491 HH | Step length = 17.4 |
| 6 | Inside Diameter | Drg. No. | 420.12 HH | |
| 7 | Width of Pellet Die | Drg. No. | 158 HH | |
| 8 | Grooves as per Drawing | Drg. No. | 12x8x3 HH 12x8x3 HH | |
| 9 | Fitting Sizes on CNC Plate | Drg. No. | OK | |
| 10 | Drilling Area Surface Smoothness | | OK | |
| 11 | Tapping Operator | | n/c Shop | Tapping No. of holes = 8 Beta Side |
| 12 | Tapping PCD | | 454 HH | |
| 13 | Tapping Hole Diameter | | H20 = Check by H20 Ball | |
| 14 | Tapping On Second Side | Half pitch of 1st side | OK | |
| 15 | Tapping Hole Depth | | Ball Depth = 19.8 HH | Tapping Depth = 17.4 |
| 16 | Perpendicularity of Tapped Hole | | Yes | |
| 17 | Visual Inspection Before Gun Drilling | | OK | |

Inspected By (Sign) & Date *Ravi 18/10/23*

| | | | |
|---|--------------------------------|--------|----|
| 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 | | | | | | | | |
| 2 | External Relief Dia | 4.5 HH | outer side (2-2) | | Inner | | | | | |
| 3 | External Relief Depth | | 9 HH | | 5 HH | | | | | |
| 4 | Inspection Done Before Hardening By (Name) | | | | | | | | | |
| 5 | Material Sent For Hardening By (Name) | | | | | | | | | Lark Furnace |
| 6 | Material Sent For Hardening On Date | | | 18 | 10 | 23 | | | | |

Inspected By (Sign) & Date *Ravi 18/10/23*

Reviewed by (Engineer-CNC) *Sukh 18/10/23*

Manager-QA