

6438



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. | | 10665 | 33/47 |
| 2 | Machined By | | V.T.L n/c Shop | Drg No. 1 S.O 875 |
| 3 | Pallet Die No. | | 11075 (2.8) n/c | Recessed |
| 4 | Die Category | Drg. No. | Endgrain | |
| 5 | Out Side Diameter | Drg. No. | 6.14 n/c Step 02 = 6.23.8 n/c | Tapping 12 |
| 6 | Inside Diameter | Drg. No. | 5.20.12 n/c | Step length = 13 n/c |
| 7 | Width of Pellet Die | Drg. No. | 222 n/c | Undercut = 4.9 n/c |
| 8 | Grooves as per Drawing | Drg. No. | 13x8x5 n/c / 13x8x5 n/c | |
| 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: 12 Both Side |
| 12 | Tapping PCD | | 565 n/c | |
| 13 | Tapping Hole Diameter | | n/c Check by n/c Bolt | |
| 14 | Tapping On Second Side | Half pitch of 1st side | OK | |
| 15 | Tapping Hole Depth | | Drill Depth = 20.4 n/c | Tapping Depth = 18.8 n/c |
| 16 | Perpendicularity of Tapped Hole | | Yes | |
| 17 | Visual Inspection Before Gun Drilling | | OK | |

Inspected By (Sign) & Date

Ravi 17/11/23

| | | | |
|---|--------------------------------|--------|-------------------|
| 1 | As per programme no. | | |
| 2 | Gun Drilling Work Completed On | | |
| 3 | Hole Finish In Gun Drilling | Marked | OK (A) |
| 4 | Defective Holes (If Any) | | No. 1 Hole Closed |

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

| | | | | | | | | | |
|---|--|---------|---------------|----|--------------|--|--|--|---------|
| 1 | Counter Sinking Depth & Finish | OK | | | | | | | Rev. 40 |
| 2 | External Relief Dia | 2.3 n/c | Outside (3-3) | | Inner | | | | |
| 3 | External Relief Depth | | 20 n/c | | 14 n/c | | | | |
| 4 | Inspection Done Before Hardening By (Name) | | | | Ravi | | | | |
| 5 | Material Sent For Hardening By (Name) | | | | Lark Furnace | | | | |
| 6 | Material Sent For Hardening On Date | | 17 | 11 | 23 | | | | |

Inspected By (Sign) & Date

Ravi 17/11/23

Reviewed by (Engineer-CNC)

Manager-QA