


6510

|  Lark Engineering Co. (India) ITI, Sasoli Road, YAMUNA NAGAR- 135 002 (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. | | 10784 | 37/47 |
| 2 | Machined By | | V.T.L. h/c Shop | Dy. No. L.E.G. 15431 |
| 3 | Pellet Die No. | | 11097 (3.0) H | Rev. 00 |
| 4 | Die category | Drg. No. | Extrusion die | |
| 5 | Outside diameter | Drg. No. | 614 H, Step OD, 612 H | step length = 19.5 |
| 6 | Inside Diameter | Drg. No. | 520.12 H / 520.7 H | |
| 7 | Width Of Pellet Die | Drg. No. | 222 H | |
| 8 | Grooves As Per Drawing | Drg. No. | 13x8.5 H / 13x8.5 H | |
| 9 | Fitting Sizes on CNC Plate | Drg. No. | OK | |
| 10 | Drilling Area Surface Smoothness | | OK | |
| 11 | Tapping Operator | | h/c Shop | Tapping No. of Holes 12 Both Side |
| 12 | Tapping PCD | | 565 H / 564.9 H | |
| 13 | Tapping Hole Diameter | | M20 - Check by M20 Bolt | |
| 14 | Tapping On Second Side | Half pitch of 1st side | OK | |
| 15 | Tapping Hole Depth | | Drill Depth, 21.4 H | Tapping Depth 19 H |
| 16 | Perpendicularity of Tapped Hole | | yes | |
| 17 | Visual Inspection Before Gun Drilling | | OK | |
| Inspected By (Sign) & Date | | | Ravi 28/11/23 | |
| 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 - 1 Hole Closed | |
| Note: Mark the defective holes/Missed holes with the help of Permanent Marker | | | | |
| 1 | Counter Sinking Depth & Finish | OK | | Low = 38 |
| 2 | External Relief Dia. | 3.5 H | Outside / Inner | |
| 3 | External Relief Depth | | 23 H / 20 H | |
| 4 | Inspection Done Before Hardening By (Name) | | Ravi | |
| 5 | Material Sent For Hardening By (Name) | | Lark Furnace | |
| 6 | Material Sent For Hardening On Date | | 28/11/23 | |
| Inspected By (Sign) & Date | | | Ravi 28/11/23 | |


 Reviewed by (Engineer (CNC))

Manager-QA