

6644



Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

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|-----------|--------------|
| 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. | | | |
| 2 | Machined By | | 10898 | 30/40 |
| 3 | Pallet Die No. | | V.T.L. H/c Shop | 9179 Dy. No. Lark 9310 |
| 4 | Die Category | Drg. No. | 10404 (3.0) | |
| 5 | Out Side Diameter | Drg. No. | 500mm | Step length 7.5 |
| 6 | Inside Diameter | Drg. No. | 420.12mm | |
| 7 | Width of Pellet Die | Drg. No. | 182mm | |
| 8 | Grooves as per Drawing | Drg. No. | 12x8x3mm 12x8x3mm | |
| 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 Bolt side |
| 12 | Tapping PCD | | 454mm | |
| 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: 19mm | Tapping Depth: 17mm |
| 16 | Perpendicularity of Tapped Hole | | Yes | |
| 17 | Visual Inspection Before Gun Drilling | | OK | |

Inspected By (Sign) & Date

Ravi 25/12/13

| | | | |
|---|--------------------------------|--------|----|
| 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 | 3.5mm | Outside (2-2) | Inner | | | | | | |
| 3 | External Relief Depth | | 13mm | 10mm | | | | | | |
| 4 | Inspection Done Before Hardening By (Name) | | | | | | | | | |
| 5 | Material Sent For Hardening By (Name) | | | | | | | | | |
| 6 | Material Sent For Hardening On Date | | 25 | 12 | 28 | | | | | |

Inspected By (Sign) & Date

Ravi 25/12/13

25/12/13

Reviewed by (Engineer-CNC)

Manager-QA