

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. | | | |
| 2 | Machined By | | 10909 | |
| 3 | Pallet Die No. | | V.T.L n/c Shop | 22/50 6355 Dy. No. 10780 |
| 4 | Die Category | Drg. No. | 11087 (2.8) n/c | |
| 5 | Out Side Diameter | Drg. No. | Endrowide | |
| 6 | Inside Diameter | Drg. No. | 620 n/c Step 00: 612 n/c | Step length = 19.5 |
| 7 | Width of Pellet Die | Drg. No. | 520.14 n/c (D) | |
| 8 | Grooves as per Drawing | Drg. No. | 222 n/c | |
| 9 | Fitting Sizes on CNC Plate | Drg. No. | 13x8x5 n/c 13x8x5 n/c | |
| 10 | Drilling Area Surface Smoothness | | ok | |
| 11 | Tapping Operator | | ok | |
| 12 | Tapping PCD | | n/c Shop | Tapping No. of Hole: 12 Both Side |
| 13 | Tapping Hole Diameter | | 565 n/c | |
| 14 | Tapping On Second Side | Half pitch of 1st side | n/c Shop Check by n/c Bolt | |
| 15 | Tapping Hole Depth | | ok | |
| 16 | Perpendicularity of Tapped Hole | | Drill Depth = 21.3 n/c Tapping Depth = 19 n/c | |
| 17 | Visual Inspection Before Gun Drilling | | yes ok | |

Inspected By (Sign) & Date

Ravi 30/12/13

| | | | |
|---|--------------------------------|--------|----|
| 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 | | | | | Counter 60° |
| 2 | External Relief Dia | 3.3 n/c | outside (3-3) | | | | Row 40 |
| 3 | External Relief Depth | ✓ | 25 n/c | | Inner 22 n/c | | |
| 4 | Inspection Done Before Hardening By (Name) | | ✓ | | | | Ravi ✓ |
| 5 | Material Sent For Hardening By (Name) | | | | | | Lark Ravi |
| 6 | Material Sent For Hardening On Date | | | 30 | 12 | 23 | |

Inspected By (Sign) & Date

Ravi 30/12/13

Reviewed by (Engineer-CNC)

Manager-QA