

6690



# 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.                        |                        | 10938                   | 43/55                               |
| 2     | Machined By                           |                        | V.T.L. H/c Shop         | Dy No. 120/14724                    |
| 3     | Pallet Die No.                        |                        | 11361 (G.C) H/c         | Rev. 2.00                           |
| 4     | Die Category                          | Drg. No.               | Extra wide              |                                     |
| 5     | Out Side Diameter                     | Drg. No.               | 630 H/c                 | Step OD: 612 H/c                    |
| 6     | Inside Diameter                       | Drg. No.               | 520.12 H/c              | Step length = 19.5                  |
| 7     | Width of Pellet Die                   | Drg. No.               | 222 H/c                 |                                     |
| 8     | Grooves as per Drawing                | Drg. No.               | 13x8x5 H/c / 13x8x5 H/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 H/c                 |                                     |
| 13    | Tapping Hole Diameter                 |                        | M2 = Check by M2 Bolt   |                                     |
| 14    | Tapping On Second Side                | Half pitch of 1st side | ok                      |                                     |
| 15    | Tapping Hole Depth                    |                        | Drill Depth = 20.4 H/c  | Tapping Depth = 19.8                |
| 16    | Perpendicularity of Tapped Hole       |                        | yes                     |                                     |
| 17    | Visual Inspection Before Gun Drilling |                        | ok                      |                                     |

### Inspected By (Sign) & Date

Ravi 28/12/23

|   |                                |        |    |
|---|--------------------------------|--------|----|
| 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

Counter = 60°

|   |  |         |               |        |    |  |  |  |         |
|---|--|---------|---------------|--------|----|--|--|--|---------|
| 1 | Counter Sinking Depth & Finish             | ok      |               |        |    |  |  |  | Ravi 28 |
| 2 | External Relief Dia                        | 6.5 H/c | outside (3-3) | Inner  |    |  |  |  |         |
| 3 | External Relief Depth                      |         | 19 H/c        | 13 H/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        |         | 28            | 12     | 23 |  |  |  |         |

### Inspected By (Sign) & Date

Ravi 28/12/23

Saty 28/12/23

Reviewed by (Engineer-CNC)

Manager-QA