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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. | | 11014 | 45/60 |
| 2 | Machined By | | V.T.C. N/C Shop | Drg No. L3.0. 584 |
| 3 | Pallet Die No. | | 11000 (8.0) H4 | Revised |
| 4 | Die Category | Drg. No. | 7ombo | |
| 5 | Out Side Diameter | Drg. No. | 780 H4, 2 step OD = 798 H4 | Tappers 4° |
| 6 | Inside Diameter | Drg. No. | 660.12 H4 | Step length 85.5 |
| 7 | Width of Pellet Die | Drg. No. | 324 H4 | Under cut - 9 H4 |
| 8 | Grooves as per Drawing | Drg. No. | 21.5 x 8 x 10 H4 / 21.5 x 8 x 10 H4 | |
| 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 |
| 12 | Tapping PCD | | 725 H4 | Both Side |
| 13 | Tapping Hole Diameter | | H20, Check by H20 Bolt | |
| 14 | Tapping On Second Side | Half pitch of 1st side | OK | |
| 15 | Tapping Hole Depth | | Drill Depth = 31.3 H4 | Tapping Depth = 28.7 |
| 16 | Perpendicularity of Tapped Hole | | Yes | |
| 17 | Visual Inspection Before Gun Drilling | | OK | |
| Inspected By (Sign) & Date | | | Ravi 19/1/24 | 2 Slot |
| 1 | As per programme no. | | | 32 H4 width |
| 2 | Gun Drilling Work Completed On | | | 8 H4 Depth |
| 3 | Hole Finish In Gun Drilling | Marked | OK | Both Side |
| 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 = 65° |
| 2 | External Relief Dia | 8.5 H4 | Outside (3-3) | Row = 27 |
| 3 | External Relief Depth | | 23 H4 | |
| 4 | Inspection Done Before Hardening By (Name) | | Ravi | |
| 5 | Material Sent For Hardening By (Name) | | Lark Furnace | |
| 6 | Material Sent For Hardening On Date | | 19 | 1 |
| Inspected By (Sign) & Date | | | Ravi 19/1/24 | |

Reviewed by (Engineer-CNC)

Manager-QA