

7083



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. | | 11395 | 10/20/65 |
| 2 | Machined By | | N.T.L. n/c Shop | Dy. No. 18.0.698 |
| 3 | Pallet Die No. | | 11739 (3.0) n/c | Rev. 00 |
| 4 | Die Category | Drg. No. | M. Jumbo | |
| 5 | Out Side Diameter | Drg. No. | 610 n/c, Step OD: 630.5 n/c / 632 n/c | |
| 6 | Inside Diameter | Drg. No. | 500.12 n/c ID Boss 480.12 n/c | Step length: 19 n/c / 15.5 |
| 7 | Width of Pellet Die | Drg. No. | 181 n/c | Undercut = 10.25 n/c |
| 8 | Grooves as per Drawing | Drg. No. | 25 n/c / 34 n/c | |
| 9 | Fitting Sizes on CNC Plate | Drg. No. | ok | |
| 10 | Drilling Area Surface Smoothness | | ok | |
| 11 | Tapping Operator | | n/c Shop | Tapping Holes of holes 4 |
| 12 | Tapping PCD | | 538 n/c | |
| 13 | Tapping Hole Diameter | | n/c - Check by M16 Bolt | |
| 14 | Tapping On Second Side | Half pitch of 1st side | one side Tapping Done | And side of slot |
| 15 | Tapping Hole Depth | | Drill Depth: 29 n/c | Tapping Depth: 26.4 n/c |
| 16 | Perpendicularity of Tapped Hole | | Yes | |
| 17 | Visual Inspection Before Gun Drilling | | ok | |

Inspected By (Sign) & Date

Ravi 8/3/24

| | | | | |
|---|--------------------------------|--------|---------------------|---|
| 1 | As per programme no. | | | 2 slot 29.1 n/c width 14 n/c Deep |
| 2 | Gun Drilling Work Completed On | | | |
| 3 | Hole Finish In Gun Drilling | Marked | ok | |
| 4 | Defective Holes (If Any) | | No - 3 Hole Colored | |

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

Counter 65

| | | | | | | | | |
|---|--|-------------------|------------------|------------------|----|--|--|--------|
| 1 | Counter Sinking Depth & Finish | ok | | | | | | Row 24 |
| 2 | External Relief Dia | 3.5 n/c / 4.0 n/c | 3.5 n/c All Rows | 4.0 n/c All Rows | | | | |
| 3 | External Relief Depth | | 55 n/c | 45 n/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 | | 8 | 2 | 24 | | | |

Inspected By (Sign) & Date

Ravi 8/3/24

Reviewed by (Engineer-CNC)
Sats 8/3/24

Manager-QA