

7109 8039



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. | | 11467 ✓ | 36/46/60 ✓ |
| 2 | Machined By | | V. T. L. H/c Shop | Dy. Insp. L.S.D. 787 |
| 3 | Pallet Die No. | | 11934 (4.0) H/H ✓ | Rev. 2.00 ✓ |
| 4 | Die Category | Drg. No. | Jumbo | |
| 5 | Out Side Diameter | Drg. No. | 780 H/H ✓ Step OD = 792 H/H ✓ | Step length = 36.5 ✓ |
| 6 | Inside Diameter | Drg. No. | 66.012 H/H ✓ | Under cut = 6 H/H ✓ |
| 7 | Width of Pellet Die | Drg. No. | 384 H/H ✓ | |
| 8 | Grooves as per Drawing | Drg. No. | 21.5 x 8 x 8 H/H ✓ 21.5 x 8 x 8 H/H ✓ | |
| 9 | Fitting Sizes on CNC Plate | Drg. No. | ok | |
| 10 | Drilling Area Surface Smoothness | | ok | |
| 11 | Tapping Operator | | H/c Shop | Tapping No of Holes = 12 Both Side |
| 12 | Tapping PCD | | 785 H/H ✓ | |
| 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 31.8 H/H ✓ | Tapping Depth 39.6 ✓ |
| 16 | Perpendicularity of Tapped Hole | | Yes | |
| 17 | Visual Inspection Before Gun Drilling | | ok | |

Inspected By (Sign) & Date *Ravi* 15/3/24

| | | | |
|---|--------------------------------|--------|-------|
| 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 Counted 60

| | | | | | | | | | |
|---|--|-------------------|---------------------|----------|---------|----------|--|--|--|
| 1 | Counter Sinking Depth & Finish | ok | | | | | | | |
| 2 | External Relief Dia | 4.5 H/H 5.0 H/H | 4.5 H/H | All Rows | 5.0 H/H | All Rows | | | |
| 3 | External Relief Depth | | 34 H/H | | 14 | | | | |
| 4 | Inspection Done Before Hardening By (Name) | | <i>Ravi</i> | | | | | | |
| 5 | Material Sent For Hardening By (Name) | | <i>Lark Furnace</i> | | | | | | |
| 6 | Material Sent For Hardening On Date | | 15 | 3 | 24 | | | | |

Inspected By (Sign) & Date *Ravi* 15/3/24

Satyam
15/3/24
Reviewed by (Engineer-CNC)

Manager-QA