

7140



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. | | 11535 | 38/50 |
| 2 | Machined By | | V.T.L. n/c Shop | Dry nos 1-8-02 998 |
| 3 | Pallet Die No. | | 11963 (3.0) n/c | Rev: 00 |
| 4 | Die Category | Drg. No. | cut outside | |
| 5 | Out Side Diameter | Drg. No. | 620 n/c | Step 00. Tapper 12° Step length 18.5 |
| 6 | Inside Diameter | Drg. No. | 520.14 n/c | |
| 7 | Width of Pellet Die | Drg. No. | 222 n/c | |
| 8 | Grooves as per Drawing | Drg. No. | 13x8x5 n/c / 13x8x5 n/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 n/c | |
| 13 | Tapping Hole Diameter | | M20, Check by M20 Ball | |
| 14 | Tapping On Second Side | Half pitch of 1st side | ok | |
| 15 | Tapping Hole Depth | | Drill Depth 20.7 n/c | Tapping Depth 18.2 |
| 16 | Perpendicularity of Tapped Hole | | yes | |
| 17 | Visual Inspection Before Gun Drilling | | ok | |

Inspected By (Sign) & Date

Ravi 19/3/24

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

| | | | | | | | | | |
|---|--|---------|---------------|---|--------|--|--|--|------------------------|
| 1 | Counter Sinking Depth & Finish | ok | | | | | | | Counter 26° Rev: 38 |
| 2 | External Relief Dia | 3.5 n/c | outside (3-3) | | Inner | | | | |
| 3 | External Relief Depth | | 18 n/c | | 12 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 | | 19 | 3 | 24 | | | | |

Inspected By (Sign) & Date

Ravi 19/3/24

Satish 19/3/24

Reviewed by (Engineer-CNC)

Manager-QA