

7286



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. | | 11708 | 40/50 |
| 2 | Machined By | | V.T.G H/c Shop | Dry No. (8.0) 289 |
| 3 | Pallet Die No. | | 12067 (4.0) H | Recess |
| 4 | Die Category | Drg. No. | External die | |
| 5 | Out Side Diameter | Drg. No. | 620.1 H, Step 00, 623.8 H | Tabber 12° |
| 6 | Inside Diameter | Drg. No. | 520.12 H, (6.0) H | Step length 19.5 |
| 7 | Width of Pellet Die | Drg. No. | 222 H | Under cut 1.9 H |
| 8 | Grooves as per Drawing | Drg. No. | 1448x5 H / 1448x5 H | |
| 9 | Fitting Sizes on CNC Plate | Drg. No. | OK | |
| 10 | Drilling Area Surface Smoothness | | OK | |
| 11 | Tapping Operator | | H/c Shop | Tapping H/c of holes 12 Bob Side |
| 12 | Tapping PCD | | 565 H | |
| 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 22.7 H | Tapping Depth 20.2 |
| 16 | Perpendicularity of Tapped Hole | | yes | |
| 17 | Visual Inspection Before Gun Drilling | | OK | |

Inspected By (Sign) & Date

Ravi 31/7/24

| | | | |
|---|--------------------------------|--------|----|
| 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 60 |
| 2 | External Relief Dia | 4.5 H | Outside (3-3) | 1mm H | | | |
| 3 | External Relief Depth | | 14 H | 10 H | | | |
| 4 | Inspection Done Before Hardening By (Name) | | | | | | Ravi |
| 5 | Material Sent For Hardening By (Name) | | | | | | Lark Furnace |
| 6 | Material Sent For Hardening On Date | | 6 | 4 | 24 | | |

Inspected By (Sign) & Date

Ravi 31/7/24

Sat 31/7/24

Reviewed by (Engineer-CNC)

Manager-QA