

7330



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

Inprocess Inspection (Pellet Dies)

Rev. Date 31-07-2013

| S.No. | Check Parameter | Specification | Observations | Remarks |
|-------|---------------------------------------|------------------------|-------------------------|--------------------------------------|
| 1 | Work Order No. | | 11624 | 45/55 |
| 2 | Machined By | | V.T.L. w/c Shop | Drill No. 12.0-838 |
| 3 | Pallet Die No. | | 9462 (3.5)mm | Rev. 100 |
| 4 | Die Category | Drg. No. | Jumbo | |
| 5 | Out Side Diameter | Drg. No. | 810mm, Step 00, 798.6mm | Tapper 4° |
| 6 | Inside Diameter | Drg. No. | 700.12mm | Step length 04 |
| 7 | Width of Pellet Die | Drg. No. | 370mm | [R 27] |
| 8 | Grooves as per Drawing | Drg. No. | 25x10x9mm / 25x10x9mm | |
| 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 Back Side |
| 12 | Tapping PCD | | 750mm | |
| 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 36mm | Tapping Depth 33.8 |
| 16 | Perpendicularity of Tapped Hole | | yes | |
| 17 | Visual Inspection Before Gun Drilling | | ok | |

Inspected By (Sign) & Date

Rasi 16/4/24

| | | | |
|---|--------------------------------|--------|----|
| 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 59

| | | | | | | | |
|---|--|-------|---------------|---|-------|--|--|
| 1 | Counter Sinking Depth & Finish | ok | | | | | |
| 2 | External Relief Dia | 4.0mm | outside (3-3) | | Inner | | |
| 3 | External Relief Depth | | 17mm | | 10mm | | |
| 4 | Inspection Done Before Hardening By (Name) | | Rasi | | | | |
| 5 | Material Sent For Hardening By (Name) | | Lark Purchase | | | | |
| 6 | Material Sent For Hardening On Date | | 16 | 4 | 24 | | |

Inspected By (Sign) & Date

Rasi 16/4/24

Sotgi 16/4/24

Reviewed by (Engineer-CNC)

Manager-QA