



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. | | 9910 | 27/47 |
| 2 | Machined By | | V. T. L. n/c Shop | Drg No: L.E.C. 21897 |
| 3 | Pallet Die No. | | 10009 (2.0) n/c | Rev 2.00 |
| 4 | Die Category | Drg. No. | Extraxide | ✓ |
| 5 | Out Side Diameter | Drg. No. | 614 n/c Step 00. 621.5 n/c | Step length 21.5 |
| 6 | Inside Diameter | Drg. No. | 52.12 n/c | Tapper 12° |
| 7 | Width of Pellet Die | Drg. No. | 222 n/c | Perpendicular 0.375 |
| 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 | | M202 Check by M20 Bolt | |
| 14 | Tapping On Second Side | Half pitch of 1st side | ok | |
| 15 | Tapping Hole Depth | | Drill Depth 20.4 n/c | Tapping Depth 18.8 n/c |
| 16 | Perpendicularity of Tapped Hole | | yes | ✓ |
| 17 | Visual Inspection Before Gun Drilling | | ok | |

Inspected By (Sign) & Date

Ravi 2/8/23

| | | | |
|---|--------------------------------|--------|----|
| 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 | | | | | | | |
| 2 | External Relief Dia | 3.5 n/c | Outside (3-3) | | Inner | | | | Ravi 27 |
| 3 | External Relief Depth | | 23 n/c | | 20 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 | | 2 | 8 | 23 | | | | |

Inspected By (Sign) & Date

Ravi 2/8/23

Reviewed by (Engineer-CNC)

Manager-QA