



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. | | 9996 | 40/50 |
| 2 | Machined By | | V.T.L. M/C Shop | Dr. H. L. C. 16178 |
| 3 | Pallet Die No. | | 8814 (4.0)M | Rev 2.00 |
| 4 | Die Category | Drg. No. | MJ9W | |
| 5 | Out Side Diameter | Drg. No. | 700M, Step OD = 702M | Step length = 94 |
| 6 | Inside Diameter | Drg. No. | 300.12M | Tapper = 12° |
| 7 | Width of Pellet Die | Drg. No. | 265M | Under cut = 1M |
| 8 | Grooves as per Drawing | Drg. No. | 15x8x7M, 15x8x7M | |
| 9 | Fitting Sizes on CNC Plate | Drg. No. | OK | |
| 10 | Drilling Area Surface Smoothness | | OK | |
| 11 | Tapping Operator | | M/C Shop | |
| 12 | Tapping PCD | | 640M | Tapping No. of holes = 12 Both side |
| 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 = 20.4M, Tapping Depth = 18.8 | |
| 16 | Perpendicularity of Tapped Hole | | Yes | |
| 17 | Visual Inspection Before Gun Drilling | | OK | |

Inspected By (Sign) & Date

Ravi 21/8/23

| | | | |
|---|--------------------------------|--------|----|
| 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 | 4.5M | Outside (3-3) | | Inner | | | | Rev 2.38 |
| 3 | External Relief Depth | | 14M | | 10M | | | | |
| 4 | Inspection Done Before Hardening By (Name) | | | | Ravi | | | | |
| 5 | Material Sent For Hardening By (Name) | | | | Lark Forwace | | | | |
| 6 | Material Sent For Hardening On Date | | 2 | 8 | 23 | | | | |

Inspected By (Sign) & Date

Ravi 21/8/23

Reviewed by (Engineer-CNC)

Manager-QA