

# 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.                        |                        |                            |   |
| 2     | Machined By                           |                        | 12420                      | 34/44/50                                |
| 3     | Pallet Die No.                        |                        | V. T.L. H/C Shop           | Dg H/C Lark 353                         |
| 4     | Die Category                          | Drg. No.               | 12096 (4.0) H/C            |   |
| 5     | Out Side Diameter                     | Drg. No.               | Extra side                 |   |
| 6     | Inside Diameter                       | Drg. No.               | 6.20 H/C Step 0.2 6.12 H/C | Step length 19.5                        |
| 7     | Width of Pellet Die                   | Drg. No.               | 5.20 1.2 H/C               |   |
| 8     | Grooves as per Drawing                | Drg. No.               | 2.2 2 H/C                  |   |
| 9     | Fitting Sizes on CNC Plate            | Drg. No.               | 13x8x5 H/C / 13x8x5 H/C    |   |
| 10    | Drilling Area Surface Smoothness      |                        | ok                         |   |
| 11    | Tapping Operator                      |                        | H/C Shop                   | Tapping No. of Holes: 12<br>Bottom Side |
| 12    | Tapping PCD                           |                        | 5.65 H/C                   |   |
| 13    | Tapping Hole Diameter                 |                        | M20.2 Check by M2 Bolt     |   |
| 14    | Tapping On Second Side                | Half pitch of 1st side | ok                         |   |
| 15    | Tapping Hole Depth                    |                        | Drill Depth 20.4 H/C       | Tapping Depth 18.5                      |
| 16    | Perpendicularity of Tapped Hole       |                        | yes                        |   |
| 17    | Visual Inspection Before Gun Drilling |                        | ok                         |   |

Inspected By (Sign) & Date

Ravi 8/7/24

|   |                                |        |       |
|---|--------------------------------|--------|-------|
| 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 31 |
| 2 | External Relief Dia                        | 4.5 H/C / 5.0 H/C | 4.5 H/C | All Rows | 5.0 H/C | All Rows |           |            |
| 3 | External Relief Depth                      |                   |         | 1.6 H/C  |         | 6 H/C    |           |            |
| 4 | Inspection Done Before Hardening By (Name) |                   |         |          |         |          | Ravi      |            |
| 5 | Material Sent For Hardening By (Name)      |                   |         |          |         |          | Lark Ravi |            |
| 6 | Material Sent For Hardening On Date        |                   | 8       | 7        | 24      |          |           |            |

Inspected By (Sign) & Date

Ravi 8/7/24

Manager-QA

Reviewed by (Engineer-CNC)