



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 | | 12326 | 49/52 |
| 3 | Pallet Die No. | | V.T.L. n/c Shop | Qty No. 1.3.0.933 |
| 4 | Die Category | Drg. No. | 12277 (3.2) n/c | Rev. 00 |
| 5 | Out Side Diameter | Drg. No. | 58870 | |
| 6 | Inside Diameter | Drg. No. | 62444 ✓ Step 00, 61344 ✓ Step length | 19.5 |
| 7 | Width of Pellet Die | Drg. No. | 520.12 n/c | |
| 8 | Grooves as per Drawing | Drg. No. | 186 n/c | |
| 9 | Fitting Sizes on CNC Plate | Drg. No. | 13x8x3 n/c 13x8x3 n/c | |
| 10 | Drilling Area Surface Smoothness | | ok | |
| 11 | Tapping Operator | | ok | |
| 12 | Tapping PCD | | n/c Shop | Tapping No. of holes 12 Both Side |
| 13 | Tapping Hole Diameter | | 565 n/c | |
| 14 | Tapping On Second Side | Half pitch of 1st side | M20 = Check by M20 Ball | |
| 15 | Tapping Hole Depth | | ok | Tapping Depth 18.5 |
| 16 | Perpendicularity of Tapped Hole | | Drill Depth 20.3 n/c | |
| 17 | Visual Inspection Before Gun Drilling | | yes ok | |

Inspected By (Sign) & Date

Ravi 9/7/24

| | | | |
|---|--------------------------------|--------|----|
| 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 | | | | | | | Coorden. 60 Row = 29 |
| 2 | External Relief Dia | 3.8 n/c | Outside 23-35 | Inner | | | | | |
| 3 | External Relief Depth | | 15 n/c | 10 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 | | 9 | 7 | 24 | | | | |

Inspected By (Sign) & Date

Ravi 9/7/24

Satya 9/7/24

Reviewed by (Engineer-CNC)

Manager-QA