



# 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.                        |                        | 12542                                     | 40/45                      |
| 2     | Machined By                           |                        | V.T.L M/C Shop                            | Drg No - LSD 890           |
| 3     | Pallet Die No.                        |                        | 11774 (5.0mm)                             | (REV 00)                   |
| 4     | Die Category                          | Drg. No.               | Junior                                    |                            |
| 5     | Out Side Diameter                     | Drg. No.               | 410mm / Step dia 384mm                    | step length - 10.5mm       |
| 6     | Inside Diameter                       | Drg. No.               | 320.12mm                                  |                            |
| 7     | Width of Pellet Die                   | Drg. No.               | 134mm                                     |                            |
| 8     | Grooves as per Drawing                | Drg. No.               | 8x5x4mm / 8x5x4mm                         |                            |
| 9     | Fitting Sizes on CNC Plate            | Drg. No.               | ok  | [ Tapping No. of Holes 8 ] |
| 10    | Drilling Area Surface Smoothness      |                        | ok  |                            |
| 11    | Tapping Operator                      |                        | M/C Shop                                  | [ Both Side ]              |
| 12    | Tapping PCD                           |                        | 350mm                                     |                            |
| 13    | Tapping Hole Diameter                 |                        | 1/2" check by 1/2" Bolt                   |                            |
| 14    | Tapping On Second Side                | Half pitch of 1st side | ok  |                            |
| 15    | Tapping Hole Depth                    |                        | Drill Depth - 19.8mm Tapping Depth - 17mm |                            |
| 16    | Perpendicularity of Tapped Hole       |                        | Yes                                       |                            |
| 17    | Visual Inspection Before Gun Drilling |                        | ok  |                            |

Inspected By (Sign) & Date Ramanpreet Singh 21/08/14

|   |                                |        |    |
|---|--------------------------------|--------|----|
| 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 counter - 60°

|   |  |       |                  |       |    |  |  |  |          |
|---|--|-------|------------------|-------|----|--|--|--|----------|
| 1 | Counter Sinking Depth & Finish             | ok    |                  |       |    |  |  |  | Row - 14 |
| 2 | External Relief Dia                        | 5.5mm | outside (CR-??)  | Inner |    |  |  |  |          |
| 3 | External Relief Depth                      |       | 10mm             | 5mm   |    |  |  |  |          |
| 4 | Inspection Done Before Hardening By (Name) |       | Ramanpreet Singh |       |    |  |  |  |          |
| 5 | Material Sent For Hardening By (Name)      |       | Lark Furnace     |       |    |  |  |  |          |
| 6 | Material Sent For Hardening On Date        |       | 21               | 08    | 24 |  |  |  |          |

Inspected By (Sign) & Date Ramanpreet Singh 21/08/14

Reviewed by (Engineer-CNC)

Manager-QA