



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. | | 12638 + 12705 | 32/70 |
| 2 | Machined By | | V.T.L M/c Shop | Drg No - LSP 377 |
| 3 | Pallet Die No. | | 12927 (6.0mm) | (Rev 03) |
| 4 | Die Category | Drg. No. | M. Jumbo | |
| 5 | Out Side Diameter | Drg. No. | 688 mm ✓ Step of 697.8 mm | Step length - 38.5 mm ✓ |
| 6 | Inside Diameter | Drg. No. | 548.12 mm ✓ | Tapper - 5° ✓ |
| 7 | Width of Pellet Die | Drg. No. | 215 mm ✓ | Under cut - 1.8 mm ✓ |
| 8 | Grooves as per Drawing | Drg. No. | 29.5 x 10 x 8 mm / 29.5 x 10 x 8 mm | 6 x 8 mm ✓ |
| 9 | Fitting Sizes on CNC Plate | Drg. No. | OK | [Tapping No. of Holes 2 Both Side] |
| 10 | Drilling Area Surface Smoothness | | OK | |
| 11 | Tapping Operator | | M/c Shop | |
| 12 | Tapping PCD | | 618 mm ✓ | |
| 13 | Tapping Hole Diameter | | M16 check by M16 Bolt ✓ | Face Side Step |
| 14 | Tapping On Second Side | Half pitch of 1st side | OK | 1mm Deep Both Side ✓ |
| 15 | Tapping Hole Depth | | Drill Depth - 32.6 mm Tapping Depth - 30.5 mm ✓ | |
| 16 | Perpendicularity of Tapped Hole | | Yes | |
| 17 | Visual Inspection Before Gun Drilling | | OK | |

Inspected By (Sign) & Date

Ramanjeet Singh 06/09/14

Relief Approved

| | | | | |
|---|--------------------------------|--------|----|--------------------------------|
| 1 | As per programme no. | | — | By Sales Shivania's On mail |
| 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 - 30°

| | | | | | | | | |
|---|--|----------|-----------------|-----|----|--|--|----------|
| 1 | Counter Sinking Depth & Finish | OK | | | | | | Row - 14 |
| 2 | External Relief Dia | 7.0 mm ✓ | All Rows | (A) | | | | |
| 3 | External Relief Depth | | 38 mm | | | | | |
| 4 | Inspection Done Before Hardening By (Name) | | Ramanjeet Singh | | | | | |
| 5 | Material Sent For Hardening By (Name) | | Leak Furnace | | | | | |
| 6 | Material Sent For Hardening On Date | | 07 | 09 | 24 | | | |

Inspected By (Sign) & Date

Ramanjeet Singh 06/09/14

Signature

Reviewed by (Engineer-CNC)

Manager-QA