



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. | | 12828 + 01287/ | 60/66 |
| 2 | Machined By | | V.T.G. N/C Shop | 66/66 |
| 3 | Pallet Die No. | | 13330 13330 (10.0) | Drig No. 1.8.0 609 |
| 4 | Die Category | Drg. No. | M. Jumbo | Rev. 02 |
| 5 | Out Side Diameter | Drg. No. | 680.7 mm ✓ Step 002 693 mm ✓ | Tapper. 8° ✓ |
| 6 | Inside Diameter | Drg. No. | 548.12 mm ✓ | Step length. 31 mm ✓ |
| 7 | Width of Pellet Die | Drg. No. | 195 mm ✓ | Under cut = 2.5 mm ✓ |
| 8 | Grooves as per Drawing | Drg. No. | 32x7x8 mm / 32x7x8 mm (4x8) mm ✓ | |
| 9 | Fitting Sizes on CNC Plate | Drg. No. | OK | Fore Side Step 3 mm Deep Back Side |
| 10 | Drilling Area Surface Smoothness | | OK | |
| 11 | Tapping Operator | | N/C Shop | |
| 12 | Tapping PCD | | 619 mm ✓ | Tapping No of holes = 2 Back Side |
| 13 | Tapping Hole Diameter | | M16 = Check by M16 Bolt ✓ | |
| 14 | Tapping On Second Side | Half pitch of 1st side | OK | |
| 15 | Tapping Hole Depth | | Drill Depth. 34.8 mm ✓ Tapping Depth. 32 mm ✓ | |
| 16 | Perpendicularity of Tapped Hole | | Yes | |
| 17 | Visual Inspection Before Gun Drilling | | OK | |

Inspected By (Sign) & Date

Ravi 20/9/24

| | | | |
|---|--------------------------------|--------|-------|
| 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

Count error 65

| | | | | | | | |
|---|--|-----------|---------------|---------------------|----|--|---------|
| 1 | Counter Sinking Depth & Finish | OK | | | | | Row = 8 |
| 2 | External Relief Dia | 11.0 mm ✓ | [1st Pad 6mm] | [2nd Pad No-Relief] | | | |
| 3 | External Relief Depth | | | | | | |
| 4 | Inspection Done Before Hardening By (Name) | | Ravi | | | | |
| 5 | Material Sent For Hardening By (Name) | | Lark Furnace | | | | |
| 6 | Material Sent For Hardening On Date | | 20 | 9 | 24 | | |

Inspected By (Sign) & Date

Ravi 20/9/24

Reviewed by (Engineer-CNC)

Manager-QA