



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 | | 12953 | 36/40 |
| 3 | Pallet Die No. | | V.T.L M/C Shop | 195 |
| 4 | Die Category | Drg. No. | 12463 (3.2) HH | 3370 |
| 5 | Out Side Diameter | Drg. No. | Senior | |
| 6 | Inside Diameter | Drg. No. | 500 HH Step 002 491 HH | Step length 75 |
| 7 | Width of Pellet Die | Drg. No. | 420.12 HH | |
| 8 | Grooves as per Drawing | Drg. No. | 158 HH | |
| 9 | Fitting Sizes on CNC Plate | Drg. No. | 12x8x3 HH / 12x8x3 HH | |
| 10 | Drilling Area Surface Smoothness | | OK | |
| 11 | Tapping Operator | | M/C Shop | |
| 12 | Tapping PCD | | 454 HH | Tapping No. of Holes = 8 Both Side |
| 13 | Tapping Hole Diameter | | M20, Check by M20 Bolt | |
| 14 | Tapping On Second Side | Half pitch of 1st side | OK | |
| 15 | Tapping Hole Depth | | Drill Depth: 18.4 HH | Tapping Depth: 18.5 HH |
| 16 | Perpendicularity of Tapped Hole | | yes | |
| 17 | Visual Inspection Before Gun Drilling | | OK | |

Inspected By (Sign) & Date

Ravi 30/09/24

| | | | |
|---|--------------------------------|--------|----|
| 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 - 60° |
| 2 | External Relief Dia | 3.5 HH | outside (2-2) | Inner | | | Row - 23 |
| 3 | External Relief Depth | | 10 HH | 4 HH | | | |
| 4 | Inspection Done Before Hardening By (Name) | | | Ravi | | | |
| 5 | Material Sent For Hardening By (Name) | | | Lark Furnace | | | |
| 6 | Material Sent For Hardening On Date | | 30 | 09 | 24 | | |

Inspected By (Sign) & Date

Ravi 30/9/24

Reviewed by (Engineer-CNC)

Manager-QA