



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

Inprocess Inspection (Pellet Dies)

Rev. Date 31-07-2013

| S.No. | Check Parameter | Specification | Observations | Remarks |
|-------|---------------------------------------|------------------------|---------------------------|---------------------------------------|
| 1 | Work Order No. | | | |
| 2 | Machined By | | 13038 ✓ | 40/50 |
| 3 | Pallet Die No. | | V.T.L. n/c Shop | Dy No. 1.2.02450 |
| 4 | Die Category | Drg. No. | 12752(4.0) n/c | Recs 00 ✓ |
| 5 | Out Side Diameter | Drg. No. | JES | |
| 6 | Inside Diameter | Drg. No. | 730 n/c ✓ | Step 00, 743.5 n/c ✓ |
| 7 | Width of Pellet Die | Drg. No. | 630.12 n/c ✓ | Tapper 10° |
| 8 | Grooves as per Drawing | Drg. No. | 290 n/c ✓ | Step lengths 28 n/c |
| 9 | Fitting Sizes on CNC Plate | Drg. No. | 15x8x7 n/c 15x8x7 n/c ✓ | Under cut 6.75 n/c ✓ |
| 10 | Drilling Area Surface Smoothness | | OK | |
| 11 | Tapping Operator | | OK | |
| 12 | Tapping PCD | | n/c Shop | Tapping No of holes 16 Bottom Side |
| 13 | Tapping Hole Diameter | | 685 n/c | |
| 14 | Tapping On Second Side | Half pitch of 1st side | n/c Check by H2 Bolt ✓ | |
| 15 | Tapping Hole Depth | | OK | |
| 16 | Perpendicularity of Tapped Hole | | Drill Depth 20.4 n/c ✓ | Tapping Depth 18.5 ✓ |
| 17 | Visual Inspection Before Gun Drilling | | yes | |
| | | | OK | |

Inspected By (Sign) & Date

Ravi 31/07/24

| | | | |
|---|--------------------------------|--------|--------------------|
| 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 - 1 Hole Closed |

Note : Mark the defective holes/missed holes with the help of Permanent Marker

Counter - 60

| | | | | | | | | | | |
|---|--|-----------|---------------|----|-------------|--|--|--|--|--|
| 1 | Counter Sinking Depth & Finish | OK | | | | | | | | |
| 2 | External Relief Dia | 4.5 n/c ✓ | outside (3.3) | | Inner | | | | | |
| 3 | External Relief Depth | | 14 n/c ✓ | | 10 n/c ✓ | | | | | |
| 4 | Inspection Done Before Hardening By (Name) | | | | Ravi | | | | | |
| 5 | Material Sent For Hardening By (Name) | | | | Lark Ramare | | | | | |
| 6 | Material Sent For Hardening On Date | | 7 | 10 | 24 | | | | | |

Inspected By (Sign) & Date

Ravi 31/07/24

Reviewed by (Engineer-CNC)

Manager-QA