



# 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.                        |                        | 13044 ✓                   | 36/55 ✓                           |
| 2     | Machined By                           |                        | V.T.L. n/c Shop           | Dy. No. 13.02 ✓ of                |
| 3     | Pallet Die No.                        |                        | 13401 (4.0) n/c ✓         | Rev. 00 ✓                         |
| 4     | Die Category                          | Drg. No.               | M. Jumbo                  |                                   |
| 5     | Out Side Diameter                     | Drg. No.               | 700 n/c ✓                 | Step 00 + 693 n/c ✓               |
| 6     | Inside Diameter                       | Drg. No.               | 600.12 n/c ✓              | Tappet 12 ✓                       |
| 7     | Width of Pellet Die                   | Drg. No.               | 222 n/c ✓                 | Step length 20 n/c ✓              |
| 8     | Grooves as per Drawing                | Drg. No.               | 12x8x7 n/c ✓              |                                   |
| 9     | Fitting Sizes on CNC Plate            | Drg. No.               | ok ✓                      |                                   |
| 10    | Drilling Area Surface Smoothness      |                        | ok                        |                                   |
| 11    | Tapping Operator                      |                        | n/c Shop                  | Tapping No. of Holes 12 Both Side |
| 12    | Tapping PCD                           |                        | 640 n/c ✓                 |                                   |
| 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 20.4 n/c ✓    | Tapping Depth 18.5 ✓              |
| 16    | Perpendicularity of Tapped Hole       |                        | yes                       |                                   |
| 17    | Visual Inspection Before Gun Drilling |                        | ok                        |                                   |

### Inspected By (Sign) & Date

Ravi 8/10/24

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

Counter 60  
Raw 32

|   |  |           |               |          |    |  |  |
|---|--|-----------|---------------|----------|----|--|--|
| 1 | Counter Sinking Depth & Finish             | ok        |               |          |    |  |  |
| 2 | External Relief Dia                        | 4.5 n/c ✓ | Outside (3-3) | Inner    |    |  |  |
| 3 | External Relief Depth                      |           | 23 n/c ✓      | 19 n/c ✓ |    |  |  |
| 4 | Inspection Done Before Hardening By (Name) |           | Ravi ✓        |          |    |  |  |
| 5 | Material Sent For Hardening By (Name)      |           | Lark Furnace  |          |    |  |  |
| 6 | Material Sent For Hardening On Date        |           | 8             | 10       | 24 |  |  |

### Inspected By (Sign) & Date

Ravi 8/10/24

Reviewed by (Engineer-CNC)

Manager-QA