



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 | | 1300 ✓ | 49/55 ✓ |
| 3 | Pallet Die No. | | V.T.L. H/A Shop | Drg No 13.D=355 |
| 4 | Die Category | Drg. No. | 12680(4.0)mm ✓ | Rev 2.00 ✓ |
| 5 | Out Side Diameter | Drg. No. | 53310 | |
| 6 | Inside Diameter | Drg. No. | 630mm ✓ Step OD = 612mm ✓ | Step length 2mm ✓ |
| 7 | Width of Pellet Die | Drg. No. | 520.12 mm ✓ | |
| 8 | Grooves as per Drawing | Drg. No. | 186mm ✓ | |
| 9 | Fitting Sizes on CNC Plate | Drg. No. | 13x8x3mm 13x8x3mm ✓ | |
| 10 | Drilling Area Surface Smoothness | | OK | |
| 11 | Tapping Operator | | N/A Shop | |
| 12 | Tapping PCD | | 565mm ✓ | Tapping No of holes = 2 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 = 2.4mm | Tapping Depth = 18.5 |
| 16 | Perpendicularity of Tapped Hole | | yes | |
| 17 | Visual Inspection Before Gun Drilling | | OK | |

Inspected By (Sign) & Date

Ravi 11/10/24

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

| | | | | | | | | | | |
|---|--|-------|---------------|---------------|----|--|--|--|--|--|
| 1 | Counter Sinking Depth & Finish | OK | | | | | | | | |
| 2 | External Relief Dia | 4.5mm | Outside (2-3) | Inner | | | | | | |
| 3 | External Relief Depth | ✓ | 17mm ✓ | 13mm ✓ | | | | | | |
| 4 | Inspection Done Before Hardening By (Name) | | | Ravi | | | | | | |
| 5 | Material Sent For Hardening By (Name) | | | Lark For race | | | | | | |
| 6 | Material Sent For Hardening On Date | | 11 | 10 | 24 | | | | | |

Inspected By (Sign) & Date

Ravi 11/10/24

Reviewed by (Engineer-CNC)

Manager-QA