



Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

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| 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. | | 13097 | 30/45/60 |
| 2 | Machined By | | V. T. C. n/c Shop | Drg No. 1302/11 |
| 3 | Pallet Die No. | | 12988 (6.0) n/c | Revised |
| 4 | Die Category | Drg. No. | Jumbo | |
| 5 | Out Side Diameter | Drg. No. | 780 n/c Sidep OD, 792 n/c | Step length = 28.5 |
| 6 | Inside Diameter | Drg. No. | 660.12 n/c | Step length = 25.5 |
| 7 | Width of Pellet Die | Drg. No. | 324 n/c | Under cut, 6mm |
| 8 | Grooves as per Drawing | Drg. No. | 21.5 x 8 x 8 n/c 21.5 x 8 x 8 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 Roh Side |
| 12 | Tapping PCD | | 725 n/c | |
| 13 | Tapping Hole Diameter | | M20 Check by M20 Ball | |
| 14 | Tapping On Second Side | Half pitch of 1st side | ok | |
| 15 | Tapping Hole Depth | | Drill Depth, 31 n/c Tapping Depth, 28.5 | |
| 16 | Perpendicularity of Tapped Hole | | yes | |
| 17 | Visual Inspection Before Gun Drilling | | ok | |

Inspected By (Sign) & Date

Ravi 24/10/24

| | | | | |
|---|--------------------------------|--------|----|---|
| 1 | As per programme no. | | | 2 slot 32.1 n/c width 8 n/c Depth Roh Side |
| 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
Ravi 34

| | | | | | | | |
|---|--|-------------------|---------|----------|---------|----------|---------------|
| 1 | Counter Sinking Depth & Finish | ok | | | | | |
| 2 | External Relief Dia | 6.5 n/c 6.8 n/c | 6.5 n/c | All Rows | 6.8 n/c | All Rows | |
| 3 | External Relief Depth | ✓ | 30 n/c | | 15 n/c | | |
| 4 | Inspection Done Before Hardening By (Name) | | | | | | Ravi |
| 5 | Material Sent For Hardening By (Name) | | | | | | Lark Purchase |
| 6 | Material Sent For Hardening On Date | | 24 | 10 | 24 | | |

Inspected By (Sign) & Date

Ravi 24/10/24

Satya
24/10/24
Reviewed by (Engineer-CNC)

Manager-QA