



# 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.                        |                        | 13141 ✓                 | 33/4 ✓                            |
| 2     | Machined By                           |                        | V. T. L. H/c Shop       | Dy. No. 120215062                 |
| 3     | Pallet Die No.                        |                        | 12687 (3.0) H/c ✓       | Raw 200 ✓                         |
| 4     | Die Category                          | Drg. No.               | Senior                  |                                   |
| 5     | Out Side Diameter                     | Drg. No.               | 500 H/c ✓               | Step 02 498.33 H/c                |
| 6     | Inside Diameter                       | Drg. No.               | 480.12 H/c ✓            | Tap hole 18 H/c                   |
| 7     | Width of Pellet Die                   | Drg. No.               | 158 H/c ✓               | Step length 18 H/c                |
| 8     | Grooves as per Drawing                | Drg. No.               | 12x8x3 H/c / 12x8x3 H/c |                                   |
| 9     | Fitting Sizes on CNC Plate            | Drg. No.               | OK                      |                                   |
| 10    | Drilling Area Surface Smoothness      |                        | OK                      |                                   |
| 11    | Tapping Operator                      |                        | H/c Shop                |                                   |
| 12    | Tapping PCD                           |                        | 454 H/c ✓               | [ Tapping of holes on Back 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 H/c    | Tapping Depth 16.6                |
| 16    | Perpendicularity of Tapped Hole       |                        | yes                     |                                   |
| 17    | Visual Inspection Before Gun Drilling |                        | OK                      |                                   |

### Inspected By (Sign) & Date

Ravi 5/11/24

|   |                                |        |    |
|---|--------------------------------|--------|----|
| 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 600

|   |                                            |         |               |    |              |  |  |  |  |
|---|--------------------------------------------|---------|---------------|----|--------------|--|--|--|--|
| 1 | Counter Sinking Depth & Finish             | OK      |               |    |              |  |  |  |  |
| 2 | External Relief Dia                        | 3.3 H/c | outside (2-2) |    | Inner        |  |  |  |  |
| 3 | External Relief Depth                      |         | 13 H/c        |    | 7 H/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        |         | 5             | 11 | 24           |  |  |  |  |

### Inspected By (Sign) & Date

Ravi 5/11/24

Sutya 5/11/24

Reviewed by (Engineer-CNC)

Manager-QA