

8479

# 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.                        |                        | 13189 ✓                   | 29/40                              |
| 2     | Machined By                           |                        | V. T. L. n/c Shop         | Dy. Mr. Lark 25/10                 |
| 3     | Pallet Die No.                        |                        | 12688 (3.0) n/c ✓         |                                    |
| 4     | Die Category                          | Dr. No.                | Senior                    |                                    |
| 5     | Out Side Diameter                     | Dr. No.                | 500 n/c ✓                 | Step length 17.4                   |
| 6     | Inside Diameter                       | Dr. No.                | 420.12 n/c ✓              |                                    |
| 7     | Width of Pellet Die                   | Dr. No.                | 158 n/c ✓                 |                                    |
| 8     | Grooves as per Drawing                | Dr. No.                | 12x8x3 n/c   12x8x3 n/c ✓ |                                    |
| 9     | Fitting Sizes on CNC Plate            | Dr. No.                | ok                        |                                    |
| 10    | Drilling Area Surface Smoothness      |                        | ok                        |                                    |
| 11    | Tapping Operator                      |                        | n/c Shop                  | Tapping No. of Holes = 8 Both side |
| 12    | Tapping PCD                           |                        | 454 n/c ✓                 |                                    |
| 13    | Tapping Hole Diameter                 |                        | M202 Check by M20 Bolt ✓  |                                    |
| 14    | Tapping On Second Side                | Half pitch of 1st side | ok                        |                                    |
| 15    | Tapping Hole Depth                    |                        | Drill Depth 18.4 n/c      | Tapping Depth = 16.5               |
| 16    | Perpendicularity of Tapped Hole       |                        | yes                       |                                    |
| 17    | Visual Inspection Before Gun Drilling |                        | ok                        |                                    |

**Inspected By (Sign) & Date**

Ravi 6/11/24

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

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

Counter = 60

|   |  |         |               |    |        |  |  |  |              |
|---|--|---------|---------------|----|--------|--|--|--|--------------|
| 1 | Counter Sinking Depth & Finish             | ok      |               |    |        |  |  |  | Ravi 24      |
| 2 | External Relief Dia                        | 3.5 n/c | Outside 22-23 |    | Inner  |  |  |  |              |
| 3 | External Relief Depth                      |         | 14 n/c        |    | 11 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        |         | 6             | 11 | 24     |  |  |  |              |

**Inspected By (Sign) & Date**

Ravi 6/11/24

Reviewed by (Engineer-CNC)

Manager-QA