



# 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                           |                        | 13256                           |                         |
| 3     | Pallet Die No.                        |                        | UTL MIC Shop                    | 26/36/86                |
| 4     | Die Category                          | Drg. No.               | 13328 (8.0) mm                  | Drg. No. 609 Pro 2      |
| 5     | Out Side Diameter                     | Drg. No.               | M. Jumbo                        |                         |
| 6     | Inside Diameter                       | Drg. No.               | 680-7 mm - 1st step OD - 698 mm | Step height - 3/4       |
| 7     | Width of Pellet Die                   | Drg. No.               | 548/1 mm                        | Undercut = 2.5 mm       |
| 8     | Grooves as per Drawing                | Drg. No.               | 195 mm                          | cap per 8°              |
| 9     | Fitting Sizes on CNC Plate            | Drg. No.               | 32x7x8 (4x8) mm                 |                         |
| 10    | Drilling Area Surface Smoothness      |                        | ok                              | face groove - 2 mm deep |
| 11    | Tapping Operator                      |                        | ok                              |                         |
| 12    | Tapping PCD                           |                        | MIC Shop                        | Tapping No. of          |
| 13    | Tapping Hole Diameter                 |                        | 619 mm                          | hole - 2 Both side      |
| 14    | Tapping On Second Side                | Half pitch of 1st side | M16 (check M16 Bolt)            |                         |
| 15    | Tapping Hole Depth                    |                        | ok                              |                         |
| 16    | Perpendicularity of Tapped Hole       |                        | Drilling Depth - 33 mm          | Tapping Depth - 32 mm   |
| 17    | Visual Inspection Before Gun Drilling |                        | yes<br>ok                       |                         |

### Inspected By (Sign) & Date

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

|   |  |              |                |    |             |  |     |  |     |
|---|--|--------------|----------------|----|-------------|--|-----|--|-----|
| 1 | Counter Sinking Depth & Finish             | ok           |                |    |             |  |     |  | 30° |
| 2 | External Relief Dia                        | Ø 8.5, Ø 9.0 | 1st step       |    | 2nd step    |  |     |  |     |
| 3 | External Relief Depth                      |              | Ø 8.5 40 mm    |    | Ø 9.0 30 mm |  | All |  |     |
| 4 | Inspection Done Before Hardening By (Name) |              | Sanjeev        |    |             |  |     |  |     |
| 5 | Material Sent For Hardening By (Name)      |              | K. O. K. Perum |    |             |  |     |  |     |
| 6 | Material Sent For Hardening On Date        |              | 8              | 11 | 24          |  |     |  |     |

### Inspected By (Sign) & Date

Reviewed by (Engineer-CNC) *Sanjeev 8/11/24* Manager-QA *Sanjeev 8/11/24*