



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. | | 13157 | Go/65 | |
| 2 | Machined By | | V.T.L. H/c Shop | Drg No. 1-8-0-017 | |
| 3 | Pallet Die No. | | 12990(3.5)H/H | Rev. 00 | |
| 4 | Die Category | Drg. No. | Tombo | | |
| 5 | Out Side Diameter | Drg. No. | 790H/H, Step 00: 792H/H | Step length 28.5 | |
| 6 | Inside Diameter | Drg. No. | 660.14H/H | Under cut: 1H/H | |
| 7 | Width of Pellet Die | Drg. No. | 324H/H | | |
| 8 | Grooves as per Drawing | Drg. No. | 21.5x8x8H/H / 21.5x8x8H/H | | |
| 9 | Fitting Sizes on CNC Plate | Drg. No. | ok | | |
| 10 | Drilling Area Surface Smoothness | | ok | | |
| 11 | Tapping Operator | | H/c Shop | Tapping No. of Holes: 12 Both Side | |
| 12 | Tapping PCD | | 725H/H | | |
| 13 | Tapping Hole Diameter | | H20 - Check by H20 Bolt | | |
| 14 | Tapping On Second Side | Half pitch of 1st side | ok | | |
| 15 | Tapping Hole Depth | | Drill Depth 31.4H/H | Tapping Depth 29.6 | |
| 16 | Perpendicularity of Tapped Hole | | Yes | | |
| 17 | Visual Inspection Before Gun Drilling | | ok | | |
| Inspected By (Sign) & Date | | | Ravi 9/11/24 | 2 slot | |
| 1 | As per programme no. | | — | 32.1mm Width & 4mm Deep Both 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 | | | | | |
| 1 | Counter Sinking Depth & Finish | ok | | Counter 60° Rev. 51 | |
| 2 | External Relief Dia | 4.0mm | outside (3-3) | inner | |
| 3 | External Relief Depth | ✓ | 12mm | 5mm | |
| 4 | Inspection Done Before Hardening By (Name) | | Ravi | | |
| 5 | Material Sent For Hardening By (Name) | | Lark Furnace | | |
| 6 | Material Sent For Hardening On Date | | 9 | 11 | 24 |
| Inspected By (Sign) & Date | | | Ravi 9/11/24 | | |

Reviewed by (Engineer-CNC)

Manager-QA