



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 | | 13263 | |
| 3 | Pallet Die No. | | U76 - MIC Shop | 34/50 |
| 4 | Die Category | Drg. No. | 13384 (4.0) mm | Drill at back |
| 5 | Out Side Diameter | Drg. No. | SSFW | |
| 6 | Inside Diameter | Drg. No. | 620 mm OD Step - 612 mm | Step length - 19.5 mm |
| 7 | Width of Pellet Die | Drg. No. | 520 mm | |
| 8 | Grooves as per Drawing | Drg. No. | 222 mm | |
| 9 | Fitting Sizes on CNC Plate | Drg. No. | 13x8x5 mm | Tapping Mark |
| 10 | Drilling Area Surface Smoothness | | ok | Holes - 12 |
| 11 | Tapping Operator | | ok | |
| 12 | Tapping PCD | | MIC Shop | |
| 13 | Tapping Hole Diameter | | 565 mm | |
| 14 | Tapping On Second Side | Half pitch of 1st side | M20 check M20 Belt | |
| 15 | Tapping Hole Depth | | ok | |
| 16 | Perpendicularity of Tapped Hole | | Drilling Depth - 20.5 mm Tapping Depth - 18.6 | |
| 17 | Visual Inspection Before Gun Drilling | | yes ok | |

Inspected By (Sign) & Date

Jain 28/11/24

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

Counts - 60

| | | | | | | |
|---|--|-------------|-----------|-------|----|--|
| 1 | Counter Sinking Depth & Finish | ok | | | | |
| 2 | External Relief Dia | Ø 9.5 | outside | 1MM | | |
| 3 | External Relief Depth | 20 mm (3-3) | | 16 mm | | |
| 4 | Inspection Done Before Hardening By (Name) | | Jain | | | |
| 5 | Material Sent For Hardening By (Name) | | Lark firm | | | |
| 6 | Material Sent For Hardening On Date | | 20 | 11 | 24 | |

Inspected By (Sign) & Date

Jain 28/11/24

Jain 20/11/24

Reviewed by (Engineer-CNC)

Manager-QA