



# 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.                             |                        | 10038 ✓                   | 65/70 ✓  |
| 2   | Machined By                                |                        | V. T. L. n/c Shop         | Drg No. L.S.D-862 ✓                            |
| 3   | Pallet Die No.                             |                        | 10769 (4.0) ✓             | Rev 200 ✓                                      |
| 4   | Die Category                               | Drg. No.               | Jumbo ✓                   |  |
| 5   | Out Side Diameter                          | Drg. No.               | 800mm ✓ Step OD: 792mm    | Step length: 36.5 ✓                            |
| 6   | Inside Diameter                            | Drg. No.               | 660.14mm ✓                |  |
| 7   | Width of Pellet Die                        | Drg. No.               | 324mm ✓                   |  |
| 8   | Grooves as per Drawing                     | Drg. No.               | 21.5x8x8mm   21.5x8x8mm ✓ |  |
| 9   | Fitting Sizes on CNC Plate                 | Drg. No.               | OK                        |  |
| 10  | Drilling Area Surface Smoothness           |                        | OK                        |  |
| 11  | Tapping Operator                           |                        | n/c Shop                  | Tapping No. of Holes: 12 Both Side             |
| 12  | Tapping PCD                                |                        | 725mm ✓                   |  |
| 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: 31.4mm ✓     | Tapping Depth: 29.7 ✓                          |
| 16  | Perpendicularity of Tapped Hole            |                        | yes                       |  |
| 17  | Visual Inspection Before Gun Drilling      |                        | OK                        |  |
| Inspected By (Sign) & Date  |  |                        | Ravi 21/8/23              | 2 Slot<br>32.1mm wide<br>8mm Deep<br>Both Side |
| 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 - 4 Hole Closed (A) ✓  |  |
| <b>Note : Mark the defective holes/Missed holes with the help of Permanent Marker</b> |  |                        |                           |  |
| 1   | Counter Sinking Depth & Finish             | OK                     |                           | Row 247  |
| 2   | External Relief Dia                        | 4.5mm ✓                | Outside (3-3)             | Inner  |
| 3   | External Relief Depth                      |                        | 13mm ✓                    | 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        |                        | 21 8 23                   |  |
| Inspected By (Sign) & Date  |  |                        | Ravi 21/8/23              |  |

Reviewed by (Engineer-CNC)

Manager-QA