



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. | | 10075 | 45/50 |
| 2 | Machined By | | V.T.L. n/c Shop | By No. 1-3-02 370 |
| 3 | Pallet Die No. | | 10881 (6.0) n/c | Rev. 2.00 |
| 4 | Die Category | Drg. No. | Senior | |
| 5 | Out Side Diameter | Drg. No. | 520 n/c | Step length 17.5 |
| 6 | Inside Diameter | Drg. No. | 420.1 n/c | 19 n/c |
| 7 | Width of Pellet Die | Drg. No. | 159.5 n/c | |
| 8 | Grooves as per Drawing | Drg. No. | 12x8x3 n/c 13.5x8x3 n/c | |
| 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 = 8 Both side |
| 12 | Tapping PCD | | 454 n/c | |
| 13 | Tapping Hole Diameter | | φ31.2 = Check by φ31.2 Bolt | |
| 14 | Tapping On Second Side | Half pitch of 1st side | ok | |
| 15 | Tapping Hole Depth | | Drill Depth 18.4 n/c | Tapping Depth 16.8 |
| 16 | Perpendicularity of Tapped Hole | | yes | |
| 17 | Visual Inspection Before Gun Drilling | | ok | |
| Inspected By (Sign) & Date | | | Ravi 22/8/23 | |
| 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 | | Low = 15 |
| 2 | External Relief Dia | 6.5 n/c | Both side (3-2) | Inner |
| 3 | External Relief Depth | ✓ | 11 n/c | 5 n/c |
| 4 | Inspection Done Before Hardening By (Name) | | Ravi | |
| 5 | Material Sent For Hardening By (Name) | | Lark Forge | |
| 6 | Material Sent For Hardening On Date | | 22 | 8 |
| Inspected By (Sign) & Date | | | Ravi 22/8/23 | |

Reviewed by (Engineer-CNC)

Manager-QA