



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

Inprocess Inspection (Pellet Dies)

Rev. Date

31-07-2013

| S.No. | Check Parameter | Specification | Observations | Remarks |
|-------|---------------------------------------|------------------------|-----------------------------|------------------------------------|
| 1 | Work Order No. | | 13173 | 40/50/60 |
| 2 | Machined By | | V.T.L. n/a Shop | Dry Hole 1.3.02 58G |
| 3 | Pallet Die No. | | 13168(4.0) n/a | Rev 2.00 |
| 4 | Die Category | Drg. No. | Jumbo | |
| 5 | Out Side Diameter | Drg. No. | 780 n/a, Step 00, 800 n/a | Tabber 10° |
| 6 | Inside Diameter | Drg. No. | 660.12 n/a | Step length 30 n/a |
| 7 | Width of Pellet Die | Drg. No. | 290 n/a | Under cut 11 n/a |
| 8 | Grooves as per Drawing | Drg. No. | 27x8x7.5 n/a / 27x8x7.5 n/a | |
| 9 | Fitting Sizes on CNC Plate | Drg. No. | OK | |
| 10 | Drilling Area Surface Smoothness | | OK | |
| 11 | Tapping Operator | | n/a Shop | |
| 12 | Tapping PCD | | 724 n/a | |
| 13 | Tapping Hole Diameter | | M22 Check by M22 Bolt | Tapping No. of Hole = 12 Both Side |
| 14 | Tapping On Second Side | Half pitch of 1st side | OK | |
| 15 | Tapping Hole Depth | | Drill Depth 29.3 n/a | Tapping Depth 27.6 |
| 16 | Perpendicularity of Tapped Hole | | Yes | |
| 17 | Visual Inspection Before Gun Drilling | | OK | |

Inspected By (Sign) & Date

Ravi 5/11/24

| | | | |
|---|--------------------------------|--------|----------------------|
| 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 - 1 Hole Coloured |

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

Counter = 60°

| | | | | | | | | | |
|---|--|-------------------|---------|----------|----------|--|--|--|--------------|
| 1 | Counter Sinking Depth & Finish | OK | | | | | | | |
| 2 | External Relief Dia | 4.5 n/a 5.0 n/a | 4.5 n/a | 2.80 n/a | All Rows | | | | Ravi 22/39 |
| 3 | External Relief Depth | | 5.0 n/a | 2.10 n/a | All Rows | | | | |
| 4 | Inspection Done Before Hardening By (Name) | | | | | | | | Ravi |
| 5 | Material Sent For Hardening By (Name) | | | | | | | | Lark Furnace |
| 6 | Material Sent For Hardening On Date | | | | | | | | 5 11 24 |

Inspected By (Sign) & Date

Ravi 5/11/24

Reviewed by (Engineer-CNC)

Manager-QA