



Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

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| 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 | | 13393 ✓ | 25/36/66 ✓ |
| 3 | Pallet Die No. | | V-T-L H/C Shop | Dwg No. 13.0.330 |
| 4 | Die Category | Drg. No. | 13630 (6.0) H/C | Rev 2.08 ✓ |
| 5 | Out Side Diameter | Drg. No. | M. Tomba | |
| 6 | Inside Diameter | Drg. No. | 680.1 H/C Step 0.0 - 693.1 H/C | Tapper = 3° |
| 7 | Width of Pellet Die | Drg. No. | 546.12 H/C (Proc 2 548.12 H/C) | Step length = 2.1 H/C |
| 8 | Grooves as per Drawing | Drg. No. | 195 H/C | Under cut = 2.3 H/C |
| 9 | Fitting Sizes on CNC Plate | Drg. No. | 32 x 7 x 9.1 H/C / 32 x 7 x 9.1 H/C | (4 x 8) H/C |
| 10 | Drilling Area Surface Smoothness | | ok | [Face Side Step 2 nos Deep Raku Side] |
| 11 | Tapping Operator | | ok | |
| 12 | Tapping PCD | | H/C Shop | [Tapping H/C of holes - 2 Raku Side] |
| 13 | Tapping Hole Diameter | | 619 H/C | |
| 14 | Tapping On Second Side | Half pitch of 1st side | H/C 2 Check by H/C Bolt | |
| 15 | Tapping Hole Depth | | ok | |
| 16 | Perpendicularity of Tapped Hole | | Drill Depth = 33.4 H/C | Tapping Depth = 31.8 H/C |
| 17 | Visual Inspection Before Gun Drilling | | yes | |
| | | | ok | |

Inspected By (Sign) & Date

Ravi 12/12/14

| | | | | |
|---|--------------------------------|--------|----|----------------|
| 1 | As per programme no. | | | Dwg change to |
| 2 | Gun Drilling Work Completed On | | | |
| 3 | Hole Finish In Gun Drilling | Marked | ok | LSD 609 Rev 03 |
| 4 | Defective Holes (If Any) | | No | |

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

Counter = 30

| | | | | | | | | | | |
|---|--|-------------------|---------|-------------------|----|----|--|--|--|----------|
| 1 | Counter Sinking Depth & Finish | ok | | | | | | | | Row 2 12 |
| 2 | External Relief Dia | 6.5 H/C / 7.0 H/C | 6.5 H/C | All Rows 2 UO H/C | | | | | | |
| 3 | External Relief Depth | | 7.0 H/C | All Rows 2 30 H/C | | | | | | |
| 4 | Inspection Done Before Hardening By (Name) | | | Ravi | | | | | | |
| 5 | Material Sent For Hardening By (Name) | | | Lark Purchase | | | | | | |
| 6 | Material Sent For Hardening On Date | | | 10 | 12 | 24 | | | | |

Inspected By (Sign) & Date

Ravi 12/12/14

Reviewed by (Engineer-CNC)
Sats... 12/12/14

Manager-QA