



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. | | 13383 | 42/47/79 |
| 2 | Machined By | | V.T.L. n/c Shop | Dy No. 180-719 |
| 3 | Pallet Die No. | | 12964 (8.0) n/c | Rev. 01 |
| 4 | Die Category | Drg. No. | S. Jumbo | |
| 5 | Out Side Diameter | Drg. No. | 1008 n/c, Step 00, 1003 n/c | Tabbers 8 |
| 6 | Inside Diameter | Drg. No. | 850.1 n/c | Step length 4 n/c |
| 7 | Width of Pellet Die | Drg. No. | 266 n/c | Under cut 2.4 n/c |
| 8 | Grooves as per Drawing | Drg. No. | 45x8x10 n/c / 45x8x10 n/c (8x10 n/c) | |
| 9 | Fitting Sizes on CNC Plate | Drg. No. | ok | |
| 10 | Drilling Area Surface Smoothness | | ok | |
| 11 | Tapping Operator | | n/c Shop | Tapping n/c of holes - 2 Both Side |
| 12 | Tapping PCD | | 935 n/c | |
| 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 42 n/c, Tapping Depth 39.8 | |
| 16 | Perpendicularity of Tapped Hole | | yes | |
| 17 | Visual Inspection Before Gun Drilling | | ok | |

Inspected By (Sign) & Date

Ravi 9/12/24

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

Counter: 30

| | | | | | | | | | |
|---|--|-------------------|---------|-------------------|----|--|--|--|--|
| 1 | Counter Sinking Depth & Finish | ok | | | | | | | |
| 2 | External Relief Dia | 8.5 n/c / 9.5 n/c | 8.5 n/c | All Rows = 37 n/c | | | | | |
| 3 | External Relief Depth | | 9.5 n/c | All Rows = 38 n/c | | | | | |
| 4 | Inspection Done Before Hardening By (Name) | | | Ravi | | | | | |
| 5 | Material Sent For Hardening By (Name) | | | Lark For race | | | | | |
| 6 | Material Sent For Hardening On Date | | 9 | 12 | 24 | | | | |

Inspected By (Sign) & Date

Ravi 9/12/24

Satya 10/12/24

Reviewed by (Engineer-CNC)

Manager-QA