



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. | | | |
| 2 | Machined By | | 13547 ✓ | 40/48/55 |
| 3 | Pallet Die No. | | V.T.L n/c Shop | Qty No. 1.50 = 666 |
| 4 | Die Category | Drg. No. | 13873 (G.O) n/c | Rev. cv ✓ |
| 5 | Out Side Diameter | Drg. No. | M. Tombo | |
| 6 | Inside Diameter | Drg. No. | 710 n/c ✓ Step OD: 693 n/c | Tappet: 12" |
| 7 | Width of Pellet Die | Drg. No. | 600.12 n/c ✓ | Step length 40 mm |
| 8 | Grooves as per Drawing | Drg. No. | 922 n/c | |
| 9 | Fitting Sizes on CNC Plate | Drg. No. | 12 x 1047.5 n/c / 12 x 1047.5 n/c ✓ | |
| 10 | Drilling Area Surface Smoothness | | ok | |
| 11 | Tapping Operator | | ok | |
| 12 | Tapping PCD | | n/c Shop | Tapping No. of Holes 12 Both Side |
| 13 | Tapping Hole Diameter | | 640 n/c ✓ | |
| 14 | Tapping On Second Side | Half pitch of 1st side | M2-2 Check by M2 Bolt | |
| 15 | Tapping Hole Depth | | ok | |
| 16 | Perpendicularity of Tapped Hole | | Drill Depth 90.4 n/c | Tapping Depth = 18.0 |
| 17 | Visual Inspection Before Gun Drilling | | yes | |
| | | | ok | |

Inspected By (Sign) & Date

Ravi 12/12/24

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

| | | | | | | | | |
|---|--|-------------------|------------------|----------|----|--|--|--------------|
| 1 | Counter Sinking Depth & Finish | ok | | | | | | Counter 60 |
| 2 | External Relief Dia | 6.5 n/c / 7.0 n/c | 6.5 n/c All Rows | 2 15 n/c | | | | Row 2 22 |
| 3 | External Relief Depth | | 7.0 n/c All Rows | 2 7 n/c | | | | |
| 4 | Inspection Done Before Hardening By (Name) | | | | | | | Ravi |
| 5 | Material Sent For Hardening By (Name) | | | | | | | Lark Furnace |
| 6 | Material Sent For Hardening On Date | | 18 | 18 | 24 | | | |

Inspected By (Sign) & Date

Ravi 12/12/24

Reviewed by (Engineer-CNC)

Manager-QA