



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. | | 13602 | 34/50 |
| 2 | Machined By | | V.T.L. n/c Shop | Drig No. 13602 |
| 3 | Pallet Die No. | | 13647 (2.8) mm | Rev 200 |
| 4 | Die Category | Drig. No. | Extra side | |
| 5 | Out Side Diameter | Drig. No. | 6.20 mm Step 00 = Tapper 12 | |
| 6 | Inside Diameter | Drig. No. | 5.20 ± 0.02 mm | Step length 18.5 |
| 7 | Width of Pellet Die | Drig. No. | 22.2 mm | |
| 8 | Grooves as per Drawing | Drig. No. | 13687.5 mm 13787.5 mm | |
| 9 | Fitting Sizes on CNC Plate | Drig. No. | ok | |
| 10 | Drilling Area Surface Smoothness | | ok | |
| 11 | Tapping Operator | | n/c Shop | Tapping No. of holes = 12 Both Side |
| 12 | Tapping PCD | | 56.5 mm | |
| 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 = 20.3 mm Tapping Depth = 18.2 mm | |
| 16 | Perpendicularity of Tapped Hole | | yes | |
| 17 | Visual Inspection Before Gun Drilling | | ok | |

Inspected By (Sign) & Date

Ravi 16/12/24

| | | | |
|---|--------------------------------|--------|-------|
| 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° Row = 40° |
| 2 | External Relief Dia | 3.3 mm | Outside (3-3) | | Inner | | | |
| 3 | External Relief Depth | | 2.2 mm | | 1.6 mm | | | |
| 4 | Inspection Done Before Hardening By (Name) | | | | | | | Ravi |
| 5 | Material Sent For Hardening By (Name) | | | | | | | Lark Furnace |
| 6 | Material Sent For Hardening On Date | | 16 | 12 | 24 | | | |

Inspected By (Sign) & Date

Ravi 16/12/24

Satyam 17/12/24

Reviewed by (Engineer-CNC)

Manager-QA