



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. | | 13582 | 48/50 | |
| 2 | Machined By | | V.T.L n/c Shop | Dryste, 130-289 | |
| 3 | Pallet Die No. | | 13483(4.0) n/c | Pen = 00 | |
| 4 | Die Category | Drg. No. | Extra wide | | |
| 5 | Out Side Diameter | Drg. No. | 68.2 n/c, Step OD = 68.3 n/c | Tabber = 12 | |
| 6 | Inside Diameter | Drg. No. | 52.12 n/c | Step length = 17.5 | |
| 7 | Width of Pellet Die | Drg. No. | 222 n/c | Under cot = 1.8 n/c | |
| 8 | Grooves as per Drawing | Drg. No. | 14x8x5 n/c 14x8x5 n/c | | |
| 9 | Fitting Sizes on CNC Plate | Drg. No. | ok | | |
| 10 | Drilling Area Surface Smoothness | | ok | | |
| 11 | Tapping Operator | | n/c Shop | Tapping of holes = 12 Both Side | |
| 12 | Tapping PCD | | 565 n/c | | |
| 13 | Tapping Hole Diameter | | M20 - Check by M2 - Bolt | | |
| 14 | Tapping On Second Side | Half pitch of 1st side | ok | | |
| 15 | Tapping Hole Depth | | Drill Depth = 28.3 n/c | Tapping Depth = 2.6 n/c | |
| 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 - Hole Closed | | |
| Note : Mark the defective holes/missed holes with the help of Permanent Marker | | | | | |
| 1 | Counter Sinking Depth & Finish | ok | | Counter = 60° Low = 31 | |
| 2 | External Relief Dia | 4.5 n/c | outside (3-3) | inner | |
| 3 | External Relief Depth | | 10 n/c | 2 n/c | |
| 4 | Inspection Done Before Hardening By (Name) | | Ravi | | |
| 5 | Material Sent For Hardening By (Name) | | Lark For case | | |
| 6 | Material Sent For Hardening On Date | | 16 | 12 | 24 |
| Inspected By (Sign) & Date | | | Ravi 16/12/24 | | |

Reviewed by (Engineer-CNC) *Satish 16/12/24*

Manager-QA