# 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. | | 13422 | 40/48/55 |
| 2 | Machined By | | V.T.L N/C Shop | Drg No. L.S.D.1096 Rev. 00 |
| 3 | Pallet Die No. | | 13818(3.5) HH | |
| 4 | Die Category | Drg. No. | Jumbo | |
| 5 | Out Side Diameter | Drg. No. | 770 HH, Step OD. 792 HH | |
| 6 | Inside Diameter | Drg. No. | 660.12 HH | Step length = 25.5 Undercut = 1 HH |
| 7 | Width of Pellet Die | Drg. No. | 32.4 HH | |
| 8 | Grooves as per Drawing | Drg. No. | 21.5 x 8 x 8 HH / 21.5 x 8 x 8 HH | |
| 9 | Fitting Sizes on CNC Plate | Drg. No. | Ok | |
| 10 | Drilling Area Surface Smoothness | | Ok | |
| 11 | Tapping Operator | | N/C Shop | Tapping No of Holes 12 Both Side |
| 12 | Tapping PCD | | 725 HH | |
| 13 | Tapping Hole Diameter | | M20 x Check by M20 Bolt | |
| 14 | Tapping On Second Side | Half pitch of 1st side | Ok | |
| 15 | Tapping Hole Depth | | Drill Depth 31.3 HH Tapping Depth 29 HH | |
| 16 | Perpendicularity of Tapped Hole | | Yes | |
| 17 | Visual Inspection Before Gun Drilling | | Ok | |
| | **Inspected By (Sign) & Date** | | Ravi 17/12/24 | |
| 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 — 1 Hole Closed (A) | |

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

Counter = 30°

| | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|
| 1 | Counter Sinking Depth & Finish | Ok | | | | | | | Rows 59 |
| 2 | External Relief Dia | 4.2 HH / 4.5 HH | 4.2 HH | All Rows | 2.15 HH | | | | |
| 3 | External Relief Depth | | 4.5 HH | All Rows | 7 HH | | | | |
| 4 | Inspection Done Before Hardening By (Name) | | Ravi | | | | | | |
| 5 | Material Sent For Hardening By (Name) | | Lark Furnace | | | | | | |
| 6 | Material Sent For Hardening On Date | | 17 | 12 | 24 | | | | |
| | **Inspected By (Sign) & Date** | | Ravi 17/12/24 | | | | | | |

17/12/24

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner