



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. | | 13731 | 32/50 |
| 2 | Machined By | | V.T.L H/c Shop | Dy. No. L-90, 9790 |
| 3 | Pallet Die No. | | 13480 (3.0) H/c | Done |
| 4 | Die Category | Drg. No. | Extrawide | |
| 5 | Out Side Diameter | Drg. No. | 619.8 H/c | Step on |
| 6 | Inside Diameter | Drg. No. | 520.12 H/c | Tapper: 12° |
| 7 | Width of Pellet Die | Drg. No. | 222 H/c | Step length: 13.5 |
| 8 | Grooves as per Drawing | Drg. No. | 13x8x5 H/c / 13x8x5 H/c | |
| 9 | Fitting Sizes on CNC Plate | Drg. No. | ok | |
| 10 | Drilling Area Surface Smoothness | | ok | |
| 11 | Tapping Operator | | H/c Shop | |
| 12 | Tapping PCD | | 56.5 H/c | Tapping H. of 4.1 on 12 Both Side |
| 13 | Tapping Hole Diameter | | H20, Check by H20 Bolt | |
| 14 | Tapping On Second Side | Half pitch of 1st side | ok | |
| 15 | Tapping Hole Depth | | Drill Depth: 20.2 H/c | Tapping Depth: 18.5 H/c |
| 16 | Perpendicularity of Tapped Hole | | yes | |
| 17 | Visual Inspection Before Gun Drilling | | ok | |

Inspected By (Sign) & Date

Ravi 24/12/24

| | | | | |
|---|--------------------------------|--------|------------------------|--|
| 1 | As per programme no. | | ok | |
| 2 | Gun Drilling Work Completed On | | ok | |
| 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: 60

| | | | | | | | | | | |
|---|--|---------|---------------|----|--------------|--|--|--|--|--|
| 1 | Counter Sinking Depth & Finish | ok | | | | | | | | |
| 2 | External Relief Dia | 3.5 H/c | Outside (3-3) | | Inner | | | | | |
| 3 | External Relief Depth | | 2.1 H/c | | 1.8 H/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 | | 24 | 12 | 24 | | | | | |

Inspected By (Sign) & Date

Ravi 24/12/24

Reviewed by (Engineer-CNC)

Manager-QA