



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. | | 13438 ✓ | 30/50/60 ✓ |
| 2 | Machined By | | V.T.L. n/c Shop | Dy. No. 4302532 |
| 3 | Pallet Die No. | | 14105 (3.8) n/c ✓ | Rev. 100 ✓ |
| 4 | Die Category | Drg. No. | Tombo | |
| 5 | Out Side Diameter | Drg. No. | 820 n/c, Step 00. 823 n/c | Tabbers 4" |
| 6 | Inside Diameter | Drg. No. | 700.12 n/c ✓ | Step length 38 n/c |
| 7 | Width of Pellet Die | Drg. No. | 324 n/c ✓ | Under cut = 1.5 n/c ✓ |
| 8 | Grooves as per Drawing | Drg. No. | 30x8x7 n/c / 30x8x7 n/c ✓ | |
| 9 | Fitting Sizes on CNC Plate | Drg. No. | ok | |
| 10 | Drilling Area Surface Smoothness | | ok | |
| 11 | Tapping Operator | | n/c Shop | [Tapping n/c of Holes. 12 Both Side] |
| 12 | Tapping PCD | | 760 n/c ✓ | |
| 13 | Tapping Hole Diameter | | M22 = Check by M22 Bolt ✓ | |
| 14 | Tapping On Second Side | Half pitch of 1st side | ok | |
| 15 | Tapping Hole Depth | | Drill Depth 36.3 n/c Tapping Depth 34.5 n/c ✓ | |
| 16 | Perpendicularity of Tapped Hole | | yes | |
| 17 | Visual Inspection Before Gun Drilling | | ok | |

Inspected By (Sign) & Date

Ravi 28/12/24

| | | | |
|---|--------------------------------|--------|------------------------|
| 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 = 60°

| | | | | | | | | | | |
|---|--|-------------------|---------|---------------------|----|--|--|--|--|--|
| 1 | Counter Sinking Depth & Finish | ok | | | | | | | | |
| 2 | External Relief Dia | 4.3 n/c / 4.8 n/c | 4.3 n/c | All Rows = 30 n/c ✓ | | | | | | |
| 3 | External Relief Depth | | 4.8 n/c | All Rows = 10 n/c ✓ | | | | | | |
| 4 | Inspection Done Before Hardening By (Name) | | | Ravi | | | | | | |
| 5 | Material Sent For Hardening By (Name) | | | Lark Forrace | | | | | | |
| 6 | Material Sent For Hardening On Date | | 28 | 12 | 24 | | | | | |

Inspected By (Sign) & Date

Ravi 28/12/24

Reviewed by (Engineer-CNC)

Manager-QA