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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. | | 14069 | 45/45 |
| 2 | Machined By | | V.T.L n/c Shop | Dy No. 1.2.014949 |
| 3 | Pallet Die No. | | 12086 (6.0) n/c | Rev. 00 |
| 4 | Die Category | Drg. No. | Senior | |
| 5 | Out Side Diameter | Drg. No. | 510 n/c, Step OD: 49 n/c | Step length 17.5 |
| 6 | Inside Diameter | Drg. No. | 420.12 n/c (Box: 419.9 n/c) | |
| 7 | Width of Pellet Die | Drg. No. | 158 n/c | |
| 8 | Grooves as per Drawing | Drg. No. | 12x8x3 n/c 12x8x3 n/c | |
| 9 | Fitting Sizes on CNC Plate | Drg. No. | ok | |
| 10 | Drilling Area Surface Smoothness | | ok | |
| 11 | Tapping Operator | | n/c Shop | Tapping H of holes .8 Both Side |
| 12 | Tapping PCD | | 454 n/c | |
| 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: 18.3 n/c | Tapping Depth: 18.6 |
| 16 | Perpendicularity of Tapped Hole | | yes | |
| 17 | Visual Inspection Before Gun Drilling | | ok | |

Inspected By (Sign) & Date

Ravi 29/1/25

| | | | |
|---|--------------------------------|--------|----|
| 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 Bg 202 15 |
| 2 | External Relief Dia | 6.5 n/c | 6 outside (2.2) | | Inner | | | |
| 3 | External Relief Depth | | 5 n/c | | Mill | | | |
| 4 | Inspection Done Before Hardening By (Name) | | | | Ravi | | | |
| 5 | Material Sent For Hardening By (Name) | | | | Lark Furnace | | | |
| 6 | Material Sent For Hardening On Date | | 29 | 1 | 25 | | | |

Inspected By (Sign) & Date

Ravi 29/1/25

Satish 29/1/25

Reviewed by (Engineer-CNC)

Manager-QA