

9201

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. | | | 40/60/66 |
| 2 | Machined By | | 14161 ✓ | |
| 3 | Pallet Die No. | | M.T.L. HLC Shop | Drg. No. 12.02.09 |
| 4 | Die Category | Drg. No. | 14396(6.0) H4 ✓ | Rev. 03 |
| 5 | Out Side Diameter | Drg. No. | M. Jaw ha | |
| 6 | Inside Diameter | Drg. No. | 680.7 H4, Step 005 692.7 H4 | Tappers 8° |
| 7 | Width of Pellet Die | Drg. No. | 546.12 H4 (Bore 548.4 H4) | Step length 31.7 |
| 8 | Grooves as per Drawing | Drg. No. | 195 H4 | Undercut = 2.5 H4 |
| 9 | Fitting Sizes on CNC Plate | Drg. No. | 327.7 x 9.2 H4 / 327.7 x 9.2 H4 (4 x 2) | |
| 10 | Drilling Area Surface Smoothness | | ok | Face Side Step |
| 11 | Tapping Operator | | M/LC Shop | Back Side |
| 12 | Tapping PCD | | 619 H4 | Tapping No. of holes = 2 |
| 13 | Tapping Hole Diameter | | M16: Check by M16 Bolt | Back Side |
| 14 | Tapping On Second Side | Half pitch of 1st side | ok | |
| 15 | Tapping Hole Depth | | Drill Depth 38.4 H4 | Tapping Depth 31.7 |
| 16 | Perpendicularity of Tapped Hole | | yes | |
| 17 | Visual Inspection Before Gun Drilling | | ok | |

Inspected By (Sign) & Date

Ravi 15/2/25

| | | | |
|---|--------------------------------|--------|----|
| 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

Counter 30

| | | | | | | | | | |
|---|--|-----------------|--------|-----------------|----|--|--|--|--|
| 1 | Counter Sinking Depth & Finish | ok | | | | | | | |
| 2 | External Relief Dia | 6.5 H4 / 7.0 H4 | 6.5 H4 | All Rows = 2 H4 | | | | | |
| 3 | External Relief Depth | | 7.0 H4 | All Rows = 6 H4 | | | | | |
| 4 | Inspection Done Before Hardening By (Name) | | | | | | | | |
| 5 | Material Sent For Hardening By (Name) | | | | | | | | |
| 6 | Material Sent For Hardening On Date | | 15 | 2 | 25 | | | | |

Inspected By (Sign) & Date

Ravi 15/2/25

Satya 15/2/25

Reviewed by (Engineer-CNC)

Manager-QA