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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           |
| Rev. Date | 31-07-2013   |

## Inprocess Inspection (Pellet Dies)

| S.No. | Check Parameter                       | Specification          | Observations              | Remarks                             |
|-------|---------------------------------------|------------------------|---------------------------|-------------------------------------|
| 1     | Work Order No.                        |                        | 14331                     | 38/50                               |
| 2     | Machined By                           |                        | V. T. L. N/C Shop         | Drg No. 13.02 382                   |
| 3     | Pallet Die No.                        |                        | 14263(4.0) N/C            | Rev 2.00                            |
| 4     | Die Category                          | Drg. No.               | Senior                    |                                     |
| 5     | Out Side Diameter                     | Drg. No.               | 520 N/C, Step 00. 500 N/C | Step length 18 N/C                  |
| 6     | Inside Diameter                       | Drg. No.               | 420.12 N/C                | Tapper 10                           |
| 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 No of holes, 8<br>Rote Side |
| 12    | Tapping PCD                           |                        | 455 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 19.4 N/C      | Tapping Depth 16.7 N/C              |
| 16    | Perpendicularity of Tapped Hole       |                        | yes                       |                                     |
| 17    | Visual Inspection Before Gun Drilling |                        | ok                        |                                     |

**Inspected By (Sign) & Date**

Ravi 1/3/25

|   |                                |        |    |
|---|--------------------------------|--------|----|
| 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 60

|   |  |         |               |   |        |    |  |  |              |
|---|--|---------|---------------|---|--------|----|--|--|--------------|
| 1 | Counter Sinking Depth & Finish             | ok      |               |   |        |    |  |  |              |
| 2 | External Relief Dia                        | 4.5 N/C | outside (2.2) |   | inner  |    |  |  |              |
| 3 | External Relief Depth                      |         | 16 N/C        |   | 12 N/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        |         |               | 1 | 3      | 25 |  |  |              |

**Inspected By (Sign) & Date**

Ravi 1/3/25

Satyam 31/3/25

Reviewed by (Engineer-CNC)

Manager-QA