

9335



Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

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| 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. | | 14294 | 60/60 |
| 2 | Machined By | | N.T.L. n/c stop | Dy. No. 68.02 1176 |
| 3 | Pallet Die No. | | 14509 (8.0) H4 | Rev. 1.00 |
| 4 | Die Category | Dr. No. | Junior | |
| 5 | Out Side Diameter | Dr. No. | 4.29.6 H4 Step 0.2 387.6 H4 Step length 9.5 | |
| 6 | Inside Diameter | Dr. No. | 310.12 H4 | |
| 7 | Width of Pellet Die | Dr. No. | 146 H4 | |
| 8 | Grooves as per Drawing | Dr. No. | 15x8x3 H4 / 15x8x3 H4 | |
| 9 | Fitting Sizes on CNC Plate | Dr. No. | OK | |
| 10 | Drilling Area Surface Smoothness | | OK | |
| 11 | Tapping Operator | | n/c stop | |
| 12 | Tapping PCD | | 352 H4 | Tapping Ho of holes 4 Rake side |
| 13 | Tapping Hole Diameter | | 0.314" - Check by 0.314" Bolt | |
| 14 | Tapping On Second Side | Half pitch of 1st side | OK | |
| 15 | Tapping Hole Depth | | Drill Depth 25.2 H4 | Tapping Depth 23.6 |
| 16 | Perpendicularity of Tapped Hole | | yes | |
| 17 | Visual Inspection Before Gun Drilling | | OK | |

Inspected By (Sign) & Date

Ravi 2/3/25

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

| | | | | | | | | |
|---|--|--------|---------------|--------------|----|--|--|------------|
| 1 | Counter Sinking Depth & Finish | OK | | | | | | Counter 60 |
| 2 | External Relief Dia | 8.5 H4 | Outside (2.2) | Inner | | | | 8.029 |
| 3 | External Relief Depth | | 5 H4 | Mill | | | | |
| 4 | Inspection Done Before Hardening By (Name) | | | Ravi | | | | |
| 5 | Material Sent For Hardening By (Name) | | | Lark Ravnath | | | | |
| 6 | Material Sent For Hardening On Date | | 7 | 3 | 25 | | | |

Inspected By (Sign) & Date

Ravi 2/3/25

Reviewed by (Engineer-CNC)

Manager-QA