



# 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.                        |                        | 14399                                  | 36/4                 |
| 2     | Machined By                           |                        | V.T.L. M/C. Shop                       | Dr. H. L. S. 17/8/13 |
| 3     | Pallet Die No.                        |                        | 13979 (G.O.)                           | Rev. 1000            |
| 4     | Die Category                          | Drg. No.               | Senior                                 |                      |
| 5     | Out Side Diameter                     | Drg. No.               | 500.3 mm Step 00, 492                  | Step length 17.4     |
| 6     | Inside Diameter                       | Drg. No.               | 420.12 mm                              |                      |
| 7     | Width of Pellet Die                   | Drg. No.               | 158.1 mm                               |                      |
| 8     | Grooves as per Drawing                | Drg. No.               | 12x8x3 mm / 12x8x3 mm                  |                      |
| 9     | Fitting Sizes on CNC Plate            | Drg. No.               | OK                                     |                      |
| 10    | Drilling Area Surface Smoothness      |                        | OK                                     |                      |
| 11    | Tapping Operator                      |                        | M/C. Shop                              |                      |
| 12    | Tapping PCD                           |                        | 454 mm                                 |                      |
| 13    | Tapping Hole Diameter                 |                        | H202 Check by H202 Ball                |                      |
| 14    | Tapping On Second Side                | Half pitch of 1st side | OK                                     |                      |
| 15    | Tapping Hole Depth                    |                        | Drill Depth 18.3 mm Tapping Depth 16.5 |                      |
| 16    | Perpendicularity of Tapped Hole       |                        | Yes                                    |                      |
| 17    | Visual Inspection Before Gun Drilling |                        | OK                                     |                      |

### Inspected By (Sign) & Date

Ravi 17/8/13

|   |                                |        |    |
|---|--------------------------------|--------|----|
| 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                        | 6.5 mm | 80 Side 2.25 |   | Inner |  |  |  | Low 15      |
| 3 | External Relief Depth                      |        | 10 mm        |   | 4 mm  |  |  |  |             |
| 4 | Inspection Done Before Hardening By (Name) |        |              |   |       |  |  |  | Ravi        |
| 5 | Material Sent For Hardening By (Name)      |        |              |   |       |  |  |  | Lark Permac |
| 6 | Material Sent For Hardening On Date        |        | 17           | 3 | 25    |  |  |  |             |

### Inspected By (Sign) & Date

Ravi 17/8/13

Reviewed by (Engineer-CNC)

Manager-QA