



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. | | 9858 | 40/40 |
| 2 | Machined By | | V.T.C H/C Shop | Drg Nos Lark 9109 |
| 3 | Pallet Die No. | | 10364 (4.5)H | |
| 4 | Die Category | Drg. No. | Junior | |
| 5 | Out Side Diameter | Drg. No. | 400H Step OD 395H | Step length 14.5 |
| 6 | Inside Diameter | Drg. No. | 320.2H | |
| 7 | Width of Pellet Die | Drg. No. | 142H | |
| 8 | Grooves as per Drawing | Drg. No. | 15.5x7x2H / 15.5x7x2H | |
| 9 | Fitting Sizes on CNC Plate | Drg. No. | OK | |
| 10 | Drilling Area Surface Smoothness | | OK | |
| 11 | Tapping Operator | | H/C Shop | Tapping No of holes 8 Both Side |
| 12 | Tapping PCD | | 355H | |
| 13 | Tapping Hole Diameter | | M16x Check by M16 Ball | |
| 14 | Tapping On Second Side | Half pitch of 1st side | OK | |
| 15 | Tapping Hole Depth | | Drill Depth = 20.6H Tapping Depth = 18.8 | |
| 16 | Perpendicularity of Tapped Hole | | Yes | |
| 17 | Visual Inspection Before Gun Drilling | | OK | |

Inspected By (Sign) & Date

Ravi 21/7/23

| | | | |
|---|--------------------------------|--------|-------|
| 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 | | | | | | | Ravi 15 |
| 2 | External Relief Dia | 4.8H | Outside (2-2) | | Inner | | | | |
| 3 | External Relief Depth | | 4H | | 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 | | | | | | | | 21/7/23 |

Inspected By (Sign) & Date

Ravi 21/7/23

Reviewed by (Engineer-CNC)

Manager-QA