5674

# 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. | | 9641 | 28/4- |
| 2 | Machined By | | V.T.L H/e Shop | Drg No. Lark 3510 |
| 3 | Pallet Die No. | | 9278 (28) | |
| 4 | Die Category | Drg. No. | SEO | |
| 5 | Out Side Diameter | Drg. No. | 500 MM Step OD: 491MM/490.6 MM Step length 17.4 | |
| 6 | Inside Diameter | Drg. No. | 420.12 MM | |
| 7 | Width of Pellet Die | Drg. No. | 182.1 MM ⌀ | |
| 8 | Grooves as per Drawing | Drg. No. | 12×8×3 MM / 12×8×3 MM | |
| 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 | | 454 MM | |
| 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 19.7 MM Tapping Depth 17.3 | |
| 16 | Perpendicularity of Tapped Hole | | yes | |
| 17 | Visual Inspection Before Gun Drilling | | Ok | |
| | Inspected By (Sign) & Date | | Ravi 19/6/23 | |
| 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 — 1 Hole Closed (Δ) | |

**Note :** Mark the defective holes/Missed holes with the help of Permanent Marker

| | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|
| 1 | Counter Sinking Depth & Finish | Ok | | | | | | | Row-31 |
| 2 | External Relief Dia | 3.3 MM | Outside 9-23 | | Inner | | | | |
| 3 | External Relief Depth | | 15 MM | | 12 MM | | | | |
| 4 | Inspection Done Before Hardening By (Name) | | Ravi | | | | | | |
| 5 | Material Sent For Hardening By (Name) | | Lark Furnace | | | | | | |
| 6 | Material Sent For Hardening On Date | | 19 | 6 | 23 | | | | |
| | Inspected By (Sign) & Date | | Ravi 19/6/23 | | | | | | |

21/6/23

Reviewed by (Engineer-CNC)

Manager-QA