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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.                             |                        | 14715                                       | 30/6             |
| 2                                                                              | Machined By                                |                        | V.T.C. H/c Shop                             | Dy. H. L. S. 797 |
| 3                                                                              | Pallet Die No.                             |                        | 14545(4.0) H/c                              | Rev. 00          |
| 4                                                                              | Die Category                               | Drg. No.               | Jumbo                                       |                  |
| 5                                                                              | Out Side Diameter                          | Drg. No.               | 780 H/c, Step 00, 791.8 H/c, Step length 98 |                  |
| 6                                                                              | Inside Diameter                            | Drg. No.               | 660.12 H/c   660.2 H/c                      | Undercut: 6 H/c  |
| 7                                                                              | Width of Pellet Die                        | Drg. No.               | 324 H/c                                     |                  |
| 8                                                                              | Grooves as per Drawing                     | Drg. No.               | 21.5 x 8 x 8 H/c   21.5 x 8 x 8 H/c         |                  |
| 9                                                                              | Fitting Sizes on CNC Plate                 | Drg. No.               | OK                                          |                  |
| 10                                                                             | Drilling Area Surface Smoothness           |                        | OK                                          |                  |
| 11                                                                             | Tapping Operator                           |                        | H/c Shop                                    |                  |
| 12                                                                             | Tapping PCD                                |                        | 785 H/c                                     |                  |
| 13                                                                             | Tapping Hole Diameter                      |                        | H/c Check by H/c Ball                       |                  |
| 14                                                                             | Tapping On Second Side                     | Half pitch of 1st side | OK                                          |                  |
| 15                                                                             | Tapping Hole Depth                         |                        | Drill Depth: 31.4 H/c, Tapping Depth: 29.5  |                  |
| 16                                                                             | Perpendicularity of Tapped Hole            |                        | Yes                                         |                  |
| 17                                                                             | Visual Inspection Before Gun Drilling      |                        | OK                                          |                  |
| Inspected By (Sign) & Date                                                     |                                            |                        | Res: 29/4/25                                |                  |
| 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                     |                                             |                  |
| 2                                                                              | External Relief Dia                        | 5.0 H/c                | 30 Side (3-35)                              | Inner            |
| 3                                                                              | External Relief Depth                      |                        | 34 H/c                                      | 30 H/c           |
| 4                                                                              | Inspection Done Before Hardening By (Name) |                        | Res:                                        |                  |
| 5                                                                              | Material Sent For Hardening By (Name)      |                        | Lark Furnace                                |                  |
| 6                                                                              | Material Sent For Hardening On Date        |                        | 29 4 25                                     |                  |
| Inspected By (Sign) & Date                                                     |                                            |                        | Res: 29/4/25                                |                  |

Reviewed by (Engineer-CNC)

Manager-QA