



# 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.                        |                        |                                             |                  |
| 2     | Machined By                           |                        | 15031                                       | 27/40            |
| 3     | Pallet Die No.                        |                        | N.T.C. H/c Shop                             | 21/25            |
| 4     | Die Category                          | Drg. No.               | 14900 (3.0) H/c                             | 21/25            |
| 5     | Out Side Diameter                     | Drg. No.               | Senior                                      |                  |
| 6     | Inside Diameter                       | Drg. No.               | 500 H/c Step 00. 490.9 H/c                  | Step length 17.5 |
| 7     | Width of Pellet Die                   | Drg. No.               | 420.14 H/c                                  |                  |
| 8     | Grooves as per Drawing                | Drg. No.               | 158 H/c                                     |                  |
| 9     | Fitting Sizes on CNC Plate            | Drg. No.               | 12x8x3 H/c / 12x8x3 H/c                     |                  |
| 10    | Drilling Area Surface Smoothness      |                        | ok                                          |                  |
| 11    | Tapping Operator                      |                        | H/c Shop                                    |                  |
| 12    | Tapping PCD                           |                        | 454 H/c                                     |                  |
| 13    | Tapping Hole Diameter                 |                        | H/c Shop                                    |                  |
| 14    | Tapping On Second Side                | Half pitch of 1st side | ok                                          |                  |
| 15    | Tapping Hole Depth                    |                        | Drill Depth 18.8 H/c Tapping Depth 18.8 H/c |                  |
| 16    | Perpendicularity of Tapped Hole       |                        | yes                                         |                  |
| 17    | Visual Inspection Before Gun Drilling |                        | ok                                          |                  |

Inspected By (Sign) & Date

Ravi 21/25

|   |                                |        |    |
|---|--------------------------------|--------|----|
| 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                        | 3.5 H/c | Outside (2-2) |  | Inner  |  |  |  |  |
| 3 | External Relief Depth                      |         | 16 H/c        |  | 13 H/c |  |  |  |  |
| 4 | Inspection Done Before Hardening By (Name) |         |               |  |        |  |  |  |  |
| 5 | Material Sent For Hardening By (Name)      |         |               |  |        |  |  |  |  |
| 6 | Material Sent For Hardening On Date        |         |               |  |        |  |  |  |  |

Inspected By (Sign) & Date

Ravi 21/25

Reviewed by (Engineer-CNC)

Manager-QA