



# 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.                        |                        | 14991                   | 46/55                  |
| 2     | Machined By                           |                        | V.T.L. H/c Shop         | Drill. 190-28          |
| 3     | Pallet Die No.                        |                        | 15780 (10.0) H/c        | Rev. 100               |
| 4     | Die Category                          | Drg. No.               | 58870                   |                        |
| 5     | Out Side Diameter                     | Drg. No.               | 629.9 H/c               | Step 002 623.9 H/c     |
| 6     | Inside Diameter                       | Drg. No.               | 520.14 H/c              | Tapped 12"             |
| 7     | Width of Pellet Die                   | Drg. No.               | 180 H/c                 | Step length. 200       |
| 8     | Grooves as per Drawing                | Drg. No.               | 137873 H/c / 137873 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                           |                        | 565 H/c                 | Tapping of holes - 12" |
| 13    | Tapping Hole Diameter                 |                        | H202 Crack by H20 Bolt  | Both Side              |
| 14    | Tapping On Second Side                | Half pitch of 1st side | OK                      |                        |
| 15    | Tapping Hole Depth                    |                        | Drill Depth 20.4 H/c    | Tapping Depth 18"      |
| 16    | Perpendicularity of Tapped Hole       |                        | Yes                     |                        |
| 17    | Visual Inspection Before Gun Drilling |                        | OK                      |                        |

Inspected By (Sign) & Date

Ravi 21/6/13

|   |                                |        |    |
|---|--------------------------------|--------|----|
| 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                        | 10.5 H/c | 6.3-3.5 | 1mm or |    |  |  | 10.2-10      |
| 3 | External Relief Depth                      |          | 1 H/c   | 9 H/c  |    |  |  |              |
| 4 | Inspection Done Before Hardening By (Name) |          |         |        |    |  |  | Ravi         |
| 5 | Material Sent For Hardening By (Name)      |          |         |        |    |  |  | Shrikumar    |
| 6 | Material Sent For Hardening On Date        |          | 21      | 6      | 25 |  |  |              |

Inspected By (Sign) & Date

Ravi 21/6/13

Reviewed by (Engineer-CNC)

Manager-QA