



# Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

10846

|           |              |
|-----------|--------------|
| 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.                        |                        | 16255                           | 45/55                   |
| 2     | Machined By                           |                        | V.T.C. H/c Shop                 | Dy No. 180.512          |
| 3     | Pallet Die No.                        |                        | 15581 (3.8) H/c                 | Revised                 |
| 4     | Die Category                          | Drg. No.               | Senior                          |                         |
| 5     | Out Side Diameter                     | Drg. No.               | 530 H/c                         | Step 00. 490.9 H/c      |
| 6     | Inside Diameter                       | Drg. No.               | 420.14 H/c                      | Step length 14.5        |
| 7     | Width of Pellet Die                   | Drg. No.               | 158 H/c                         |                         |
| 8     | Grooves as per Drawing                | Drg. No.               | 12 x 8 x 3 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                           |                        | 454 H/c                         | Tapping H/c of 1.12 x 3 |
| 13    | Tapping Hole Diameter                 |                        | 03 1/4" - Check by 03 1/4" Bolt | Both Side               |
| 14    | Tapping On Second Side                | Half pitch of 1st side | ok                              |                         |
| 15    | Tapping Hole Depth                    |                        | Drill Depth. 18.6 H/c           | Tapping Depth 18.6      |
| 16    | Perpendicularity of Tapped Hole       |                        | yes                             |                         |
| 17    | Visual Inspection Before Gun Drilling |                        | ok                              |                         |

### Inspected By (Sign) & Date

|   |                                |        |    |
|---|--------------------------------|--------|----|
| 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                        | 4.3 H/c | 20 B. dia (2.2) |  | Inner  |  |  | Rev 2.21    |
| 3 | External Relief Depth                      |         | 17 H/c          |  | 10 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

Reviewed by (Engineer-CNC)

Manager-QA