



# 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.                        |                        | 10489                                     | 21/40                                 |
| 2     | Machined By                           |                        | V.T.L N/C Shop                            | Drg No. = I.S.O. 177                  |
| 3     | Pallet Die No.                        |                        | 10343 (3.2) H                             | Rev. 2.00                             |
| 4     | Die Category                          | Drg. No.               | 3810                                      |                                       |
| 5     | Out Side Diameter                     | Drg. No.               | 500 H                                     | Step 002 Tapper 12°                   |
| 6     | Inside Diameter                       | Drg. No.               | 420.12 H                                  | Step length 175                       |
| 7     | Width of Pellet Die                   | Drg. No.               | 182 H                                     |                                       |
| 8     | Grooves as per Drawing                | Drg. No.               | 13x8x4 H   13x8x4 H                       |                                       |
| 9     | Fitting Sizes on CNC Plate            | Drg. No.               | ok  |                                       |
| 10    | Drilling Area Surface Smoothness      |                        | ok  |                                       |
| 11    | Tapping Operator                      |                        | N/C Shop                                  | Tapping No. of holes = 8<br>Bolt side |
| 12    | Tapping PCD                           |                        | 455 H / 454.9 H                           |                                       |
| 13    | Tapping Hole Diameter                 |                        | 03/4" - Check by 03/4" Bolt               |                                       |
| 14    | Tapping On Second Side                | Half pitch of 1st side | ok  |                                       |
| 15    | Tapping Hole Depth                    |                        | Drill Depth = 21.8 H Tapping Depth = 19.7 |                                       |
| 16    | Perpendicularity of Tapped Hole       |                        | yes                                       |                                       |
| 17    | Visual Inspection Before Gun Drilling |                        | ok  |                                       |

Inspected By (Sign) & Date

Ravi 28/10/23

|   |                                |        |    |
|---|--------------------------------|--------|----|
| 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 |

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

|   |  |       |               |    |       |  |  |  |              |
|---|--|-------|---------------|----|-------|--|--|--|--------------|
| 1 | Counter Sinking Depth & Finish             | ok    |               |    |       |  |  |  | Ravi 28      |
| 2 | External Relief Dia                        | 3.8 H | Outside (2-2) |    | Inner |  |  |  |              |
| 3 | External Relief Depth                      |       | 22 H          |    | 19 H  |  |  |  |              |
| 4 | Inspection Done Before Hardening By (Name) |       |               |    |       |  |  |  | Ravi         |
| 5 | Material Sent For Hardening By (Name)      |       |               |    |       |  |  |  | Lark Porrace |
| 6 | Material Sent For Hardening On Date        |       | 28            | 10 | 23    |  |  |  |              |

Inspected By (Sign) & Date

Ravi 28/10/23

Reviewed by (Engineer-CNC)

Manager-QA