



# 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.                        |                        | 10304 ✓                                 | 410/40 ✓                        |
| 2     | Machined By                           |                        | V.T.L. H/C Shop                         | Dy. No. Lark 9370               |
| 3     | Pallet Die No.                        |                        | 11196 (4.0) ✓                           |                                 |
| 4     | Die Category                          | Drg. No.               | Junior ✓                                |                                 |
| 5     | Out Side Diameter                     | Drg. No.               | 400H ✓ Step 002 395H ✓                  | Step length 14.5 ✓              |
| 6     | Inside Diameter                       | Drg. No.               | 325.12 ✓                                |                                 |
| 7     | Width of Pellet Die                   | Drg. No.               | 148 ✓                                   |                                 |
| 8     | Grooves as per Drawing                | Drg. No.               | 15.5x7x2 ✓   15.5x7x2 ✓                 |                                 |
| 9     | Fitting Sizes on CNC Plate            | Drg. No.               | ok                                      |                                 |
| 10    | Drilling Area Surface Smoothness      |                        | ok                                      |                                 |
| 11    | Tapping Operator                      |                        | H/C Shop                                | Tapping W. of holes & Both Side |
| 12    | Tapping PCD                           |                        | 355 ✓                                   |                                 |
| 13    | Tapping Hole Diameter                 |                        | MIG - Check by MIG Bolt                 |                                 |
| 14    | Tapping On Second Side                | Half pitch of 1st side | ok                                      |                                 |
| 15    | Tapping Hole Depth                    |                        | Drill Depth 20.4 ✓ Tapping Depth 18.5 ✓ |                                 |
| 16    | Perpendicularity of Tapped Hole       |                        | yes ✓                                   |                                 |
| 17    | Visual Inspection Before Gun Drilling |                        | ok                                      |                                 |

Inspected By (Sign) & Date

Ravi 21/11/23

|   |                                |        |       |
|---|--------------------------------|--------|-------|
| 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 16 |
| 2 | External Relief Dia                        | 4.5H ✓ | outside (2-2) |    | inner        |  |  |  |         |
| 3 | External Relief Depth                      |        | 4mm ✓         |    | Mill ✓       |  |  |  |         |
| 4 | Inspection Done Before Hardening By (Name) |        |               |    | Ravi         |  |  |  |         |
| 5 | Material Sent For Hardening By (Name)      |        |               |    | Lark Furnace |  |  |  |         |
| 6 | Material Sent For Hardening On Date        |        | 2             | 11 | 23           |  |  |  |         |

Inspected By (Sign) & Date

Ravi 21/11/23

Reviewed by (Engineer-CNC)

Manager-QA