



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. | | 10716 | 33/49 |
| 2 | Machined By | | V.T.L n/c Shop | Dyn No, Lark SS10 |
| 3 | Pallet Die No. | | 9277 (3.0) | |
| 4 | Die Category | Drg. No. | SEP | |
| 5 | Out Side Diameter | Drg. No. | 500mm Step 00 - 49mm Step length | 7.5 |
| 6 | Inside Diameter | Drg. No. | 420.12mm | |
| 7 | Width of Pellet Die | Drg. No. | 182mm | |
| 8 | Grooves as per Drawing | Drg. No. | 12x8x3mm / 12x8x3mm | |
| 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 Both Side |
| 12 | Tapping PCD | | 454mm | |
| 13 | Tapping Hole Diameter | | M20 = Check by M20 Bolt | |
| 14 | Tapping On Second Side | Half pitch of 1st side | OK | |
| 15 | Tapping Hole Depth | | Drill Depth 19.7mm Tapping Depth 17.2mm | |
| 16 | Perpendicularity of Tapped Hole | | Yes | |
| 17 | Visual Inspection Before Gun Drilling | | OK | |

Inspected By (Sign) & Date

Ravi 7/11/23

| | | | |
|---|--------------------------------|--------|--------------------|
| 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 - 1 Hole Closed |

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

| | | | | | | | | | |
|---|--|-------|-------------|---|--------------|----|--|--|--|
| 1 | Counter Sinking Depth & Finish | OK | | | | | | | |
| 2 | External Relief Dia | 3.3mm | Outside 2.3 | | Inner | | | | |
| 3 | External Relief Depth | | 13mm | | 7mm | | | | |
| 4 | Inspection Done Before Hardening By (Name) | | | | Ravi | | | | |
| 5 | Material Sent For Hardening By (Name) | | | | Lark Forance | | | | |
| 6 | Material Sent For Hardening On Date | | | 7 | 11 | 23 | | | |

Inspected By (Sign) & Date

Ravi 7/11/23

Reviewed by (Engineer-CNC)

Manager-QA