



Lark Engineering Company (India) Pvt. Ltd.

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

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| 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. | | 10714 | 38/40 |
| 2 | Machined By | | V.T.L H/C Shop | Pyntal 18.0.450 Rev: 00 |
| 3 | Pallet Die No. | | 10728 (4.0) H/C | |
| 4 | Die Category | Drg. No. | Senior | |
| 5 | Out Side Diameter | Drg. No. | 500 H/C, Step OD: 499 H/C | Step length: 13.5 |
| 6 | Inside Diameter | Drg. No. | 420.12 H/C | |
| 7 | Width of Pellet Die | Drg. No. | 159 H/C | |
| 8 | Grooves as per Drawing | Drg. No. | 7x7x5 H/C / 7x7x5 H/C | |
| 9 | Fitting Sizes on CNC Plate | Drg. No. | OK | |
| 10 | Drilling Area Surface Smoothness | | OK | |
| 11 | Tapping Operator | | H/C Shop | Tapping No. of Holes = 8 Both Side |
| 12 | Tapping PCD | | 455 H/C | |
| 13 | Tapping Hole Diameter | | Ø3/4" - Check by Ø3/4" Bolt | |
| 14 | Tapping On Second Side | Half pitch of 1st side | OK | |
| 15 | Tapping Hole Depth | | Drill Depth: 22.6 H/C | Tapping Depth: 20.8 H/C |
| 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 slot 20mm width 7mm deep Both Side |
| 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 | | | | | | | | Con-21 |
| 2 | External Relief Dia | 4.5 H/C | Outside C2-2 | | Inner | | | | | |
| 3 | External Relief Depth | | 6 H/C | | 2 H/C | | | | | |
| 4 | Inspection Done Before Hardening By (Name) | | | Ravi | | | | | | |
| 5 | Material Sent For Hardening By (Name) | | | Lark Furnace | | | | | | |
| 6 | Material Sent For Hardening On Date | | 21 | 11 | 23 | | | | | |

Inspected By (Sign) & Date

Ravi 21/11/23

S. J. 21/11/23

Reviewed by (Engineer-CNC)

Manager-QA