



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. | | 10627 | 47/50 |
| 2 | Machined By | | V. T. L. NLC Shop | By N. L. S. O. 450 |
| 3 | Pallet Die No. | | 10781 (3.0) MM | Rev. 00 |
| 4 | Die Category | Drg. No. | J&W | |
| 5 | Out Side Diameter | Drg. No. | 730 MM, Step 00, 743 MM | Tappers 10 |
| 6 | Inside Diameter | Drg. No. | 630.12 MM | |
| 7 | Width of Pellet Die | Drg. No. | 290 MM | |
| 8 | Grooves as per Drawing | Drg. No. | 15x8x5 MM 15x8x5 MM | |
| 9 | Fitting Sizes on CNC Plate | Drg. No. | OK | |
| 10 | Drilling Area Surface Smoothness | | OK | |
| 11 | Tapping Operator | | NLC Shop | Tapping no. of holes 16 Both Side |
| 12 | Tapping PCD | | 685 MM | |
| 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 20.4 MM, Tapping Depth 18.8 MM | |
| 16 | Perpendicularity of Tapped Hole | | Yes | |
| 17 | Visual Inspection Before Gun Drilling | | OK | |

Inspected By (Sign) & Date

Ravi 22/11/23

| | | | |
|---|--------------------------------|--------|----|
| 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 | | | | | | Rev 251 |
| 2 | External Relief Dia | 3.5 MM | Outside (3-3) | | Inner | | | |
| 3 | External Relief Depth | | 9 MM | | 3 MM | | | |
| 4 | Inspection Done Before Hardening By (Name) | | | | | | | Ravi |
| 5 | Material Sent For Hardening By (Name) | | | | | | | Lark Porrace |
| 6 | Material Sent For Hardening On Date | | 22 | 11 | 23 | | | |

Inspected By (Sign) & Date

Ravi 22/11/23

Satya 22/11/23

Reviewed by (Engineer-CNC)

Manager-QA