



# 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.                        |                        | 10673 ✓                                   | 40/55/80 ✓                |
| 2     | Machined By                           |                        | V.T.L n/c Shop                            | Drg No. I.S.O. 700        |
| 3     | Pallet Die No.                        |                        | 11430 (8.0) ✓                             | Rev. 02 ✓                 |
| 4     | Die Category                          | Drg. No.               | Jumbo                                     |                           |
| 5     | Out Side Diameter                     | Drg. No.               | 730mm, Step OD = 732mm                    | 1632mm Step length 13.5mm |
| 6     | Inside Diameter                       | Drg. No.               | 572.14mm                                  | Undercut 1mm              |
| 7     | Width of Pellet Die                   | Drg. No.               | 219mm                                     |                           |
| 8     | Grooves as per Drawing                | Drg. No.               | 75x8x8mm   58x8x8mm                       |                           |
| 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: 6   |
| 12    | Tapping PCD                           |                        | 650mm                                     |                           |
| 13    | Tapping Hole Diameter                 |                        | M16 - Check by M16 Bolt                   |                           |
| 14    | Tapping On Second Side                | Half pitch of 1st side | One side Tapping and 2nd side One slot    |                           |
| 15    | Tapping Hole Depth                    |                        | Drill Depth: 40.5mm Tapping Depth: 33.7mm |                           |
| 16    | Perpendicularity of Tapped Hole       |                        | Yes                                       |                           |
| 17    | Visual Inspection Before Gun Drilling |                        | OK  |                           |

### Inspected By (Sign) & Date

Poo: 24/11/23

|   |                                |        |    |            |
|---|--------------------------------|--------|----|------------|
| 1 | As per programme no.           |        |    | 1 Slot     |
| 2 | Gun Drilling Work Completed On |        |    | 36mm width |
| 3 | Hole Finish In Gun Drilling    | Marked | OK | 19mm Deep  |
| 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. 8 |
| 2 | External Relief Dia                        | 8.5mm   9.0mm | 8.5mm All Lines | 9.0mm All Lines |        |
| 3 | External Relief Depth                      |               | 40mm            | 25mm            |        |
| 4 | Inspection Done Before Hardening By (Name) |               | Poo             |                 |        |
| 5 | Material Sent For Hardening By (Name)      |               | Lark Furnace    |                 |        |
| 6 | Material Sent For Hardening On Date        |               | 24              | 11              | 23     |

### Inspected By (Sign) & Date

Poo: 24/11/23

Reviewed by (Engineer-CNC)

Manager-QA