



# 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

## Inprocess Inspection (Pellet Dies)

Rev. Date

31-07-2013

| S.No. | Check Parameter                       | Specification          | Observations                                | Remarks                            |
|-------|---------------------------------------|------------------------|---|------------------------------------|
| 1     | Work Order No.                        |                        | 10829                                       | 40/40                              |
| 2     | Machined By                           |                        | V.T.L. H/c Shop                             | g 195<br>Dy. No. Lark 9870         |
| 3     | Pallet Die No.                        |                        | 10730 (4.5)                                 |                                    |
| 4     | Die Category                          | Drg. No.               | Senior                                      |                                    |
| 5     | Out Side Diameter                     | Drg. No.               | 500 H/c Step OD: 491 H/c                    | Step length: 17.5 H/c              |
| 6     | Inside Diameter                       | Drg. No.               | 420.12 H/c                                  |                                    |
| 7     | Width of Pellet Die                   | Drg. No.               | 158 H/c                                     |                                    |
| 8     | Grooves as per Drawing                | Drg. No.               | 12x8x3 H/c   12x8x3 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 = 2 Both Side |
| 12    | Tapping PCD                           |                        | 454 H/c   453.9 H/c                         |                                    |
| 13    | Tapping Hole Diameter                 |                        | M20 2 Check by M20 Bolt                     |                                    |
| 14    | Tapping On Second Side                | Half pitch of 1st side | ok  |                                    |
| 15    | Tapping Hole Depth                    |                        | Drill Depth 19.2 H/c Tapping Depth 17.2 H/c |                                    |
| 16    | Perpendicularity of Tapped Hole       |                        | yes   |                                    |
| 17    | Visual Inspection Before Gun Drilling |                        | ok  |                                    |

Inspected By (Sign) & Date

Ravi 14/12/23

|   |                                |        |    |
|---|--------------------------------|--------|----|
| 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 18 |
| 2 | External Relief Dia                        | 5.0 H/c | Outside (2-2) |    | Innen        |    |  |  |  |         |
| 3 | External Relief Depth                      |         | 4 H/c         |    | 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        |         |               | 14 | 12           | 23 |  |  |  |         |

Inspected By (Sign) & Date

Ravi 14/12/23

Reviewed by (Engineer-CNC)

Manager-QA