



# 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.                        |                        | 9976  | 25/35/32.5               |
| 2     | Machined By                           |                        | V.T.L. H/c Shop                             | Drg No. 1.8.0.2.857      |
| 3     | Pallet Die No.                        |                        | 11351 (6.0) H/H                             | Rev 200                  |
| 4     | Die Category                          | Drg. No.               | SEP   |                          |
| 5     | Out Side Diameter                     | Drg. No.               | 545 H/H Step 002 581 H/H / 502 H/H          |                          |
| 6     | Inside Diameter                       | Drg. No.               | 420/12 H/H                                  | Step length = 35 H/H     |
| 7     | Width of Pellet Die                   | Drg. No.               | 190 H/H                                     | 13 H/H                   |
| 8     | Grooves as per Drawing                | Drg. No.               | 30x24x8.5 H/H / 22x24x8.5 H/H               | Under cut = 18 H/H       |
| 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 |
| 12    | Tapping PCD                           |                        | 481 H/H                                     |                          |
| 13    | Tapping Hole Diameter                 |                        | MIG 2 Check by MIG Bolt                     |                          |
| 14    | Tapping On Second Side                | Half pitch of 1st side | one side Tapping and Third side One Slot    |                          |
| 15    | Tapping Hole Depth                    |                        | Drill Depth = 32 H/H Tapping Depth = 29 H/H |                          |
| 16    | Perpendicularity of Tapped Hole       |                        | yes   |                          |
| 17    | Visual Inspection Before Gun Drilling |                        | ok  |                          |

### Inspected By (Sign) & Date

Ravi 26/7/13

|   |                                |        |    |   |
|---|--------------------------------|--------|----|---|
| 1 | As per programme no.           |        |    | 1 SLOT<br>28.2 H/H width<br>13.5 H/H Deep |
| 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

Counter = 60°

|   |  |                   |                   |          |           |  |  |  |  |  |
|---|--|-------------------|-------------------|----------|-----------|--|--|--|--|--|
| 1 | Counter Sinking Depth & Finish             | ok                |                   |          |           |  |  |  |  |  |
| 2 | External Relief Dia                        | 6.5 H/H / 7.3 H/H | 6.5 H/H All Lines | 7.3 H/H  | All Lines |  |  |  |  |  |
| 3 | External Relief Depth                      |                   | 37.5 H/H          | 27.5 H/H |           |  |  |  |  |  |
| 4 | Inspection Done Before Hardening By (Name) |                   | Ravi              |          |           |  |  |  |  |  |
| 5 | Material Sent For Hardening By (Name)      |                   | Lark Furnace      |          |           |  |  |  |  |  |
| 6 | Material Sent For Hardening On Date        |                   | 28                | 12       | 23        |  |  |  |  |  |

### Inspected By (Sign) & Date

Ravi 26/7/13

*(Signature)*  
26/7/13

Reviewed by (Engineer-CNC)

Manager-QA