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# 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.                        |                        | 11060                            | 34/50                               |
| 2     | Machined By                           |                        | V.T.L. n/c Shop                  | Drg No. L.S.O. 289                  |
| 3     | Pallet Die No.                        |                        | 11464 (4.0) n/c                  | Reverse                             |
| 4     | Die Category                          | Drg. No.               | Ext 29 side                      |                                     |
| 5     | Out Side Diameter                     | Drg. No.               | 620 n/c / 3rd of 002 - 622.9 n/c | Tapper 12°                          |
| 6     | Inside Diameter                       | Drg. No.               | 520.12 n/c                       | Step length = 19.5                  |
| 7     | Width of Pellet Die                   | Drg. No.               | 222 n/c                          | Under cut = 1.2 n/c                 |
| 8     | Grooves as per Drawing                | Drg. No.               | 14x8x5 n/c / 14x8x5 n/c          |                                     |
| 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 = 12 Both Side |
| 12    | Tapping PCD                           |                        | 565 n/c                          |                                     |
| 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 = 23 n/c             | Tapping Depth = 20.8 n/c            |
| 16    | Perpendicularity of Tapped Hole       |                        | yes                              |                                     |
| 17    | Visual Inspection Before Gun Drilling |                        | ok                               |                                     |

### Inspected By (Sign) & Date

Ravi 18/1/24

|   |                                |        |    |
|---|--------------------------------|--------|----|
| 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

Counter 60°

|   |  |         |                |   |        |  |             |
|---|--|---------|----------------|---|--------|--|-------------|
| 1 | Counter Sinking Depth & Finish             | ok      |                |   |        |  | Ravi = 31   |
| 2 | External Relief Dia                        | 4.5 n/c | outside (23-3) |   | Inner  |  |             |
| 3 | External Relief Depth                      |         | 20 n/c         |   | 16 n/c |  |             |
| 4 | Inspection Done Before Hardening By (Name) |         |                |   |        |  | Ravi        |
| 5 | Material Sent For Hardening By (Name)      |         |                |   |        |  | Lark Forner |
| 6 | Material Sent For Hardening On Date        |         | 18             | 1 | 24     |  |             |

### Inspected By (Sign) & Date

Ravi 18/1/24

24/9/24  
18/01/24

Reviewed by (Engineer-CNC)

Manager-QA