



# 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.                        |                        | 9867                                    | 25/50/60                          |
| 2     | Machined By                           |                        | V.T.L. n/c Shop                         | Dy No. 18.02/11                   |
| 3     | Pallet Die No.                        |                        | 10374 (4.0) n/c                         | Rev. 00                           |
| 4     | Die Category                          | Drg. No.               | Jumbo                                   |                                   |
| 5     | Out Side Diameter                     | Drg. No.               | 780 n/c Step OD 2 792 n/c               | Step length 12.5                  |
| 6     | Inside Diameter                       | Drg. No.               | 660.12 n/c / 660.14 n/c                 | Under cut 2.6 n/c                 |
| 7     | Width of Pellet Die                   | Drg. No.               | 224 n/c                                 |                                   |
| 8     | Grooves as per Drawing                | Drg. No.               | 21.5 x 8 x 8 n/c / 21.5 x 8 x 8 n/c     |                                   |
| 9     | Fitting Sizes on CNC Plate            | Drg. No.               | ok                                      |                                   |
| 10    | Drilling Area Surface Smoothness      |                        | ok                                      |                                   |
| 11    | Tapping Operator                      |                        | n/c Shop                                |                                   |
| 12    | Tapping PCD                           |                        | 725 n/c                                 | Tapping No. of holes 12 Both Side |
| 13    | Tapping Hole Diameter                 |                        | M20 - Check by M20 B.H                  |                                   |
| 14    | Tapping On Second Side                | Half pitch of 1st side | ok                                      |                                   |
| 15    | Tapping Hole Depth                    |                        | Drill Depth 31.5 n/c Tapping Depth 29.7 |                                   |
| 16    | Perpendicularity of Tapped Hole       |                        | yes                                     |                                   |
| 17    | Visual Inspection Before Gun Drilling |                        | ok                                      |                                   |

### Inspected By (Sign) & Date

Ravi 13/7/23

|   |                                |        |                      |   |
|---|--------------------------------|--------|----------------------|---|
| 1 | As per programme no.           |        |                      | 2 Slot<br>39.1 n/c width<br>8 n/c Deep<br>Both Side |
| 2 | Gun Drilling Work Completed On |        |                      |   |
| 3 | Hole Finish In Gun Drilling    | Marked | ok                   |   |
| 4 | Defective Holes (If Any)       |        | No - Hole Closed (A) |   |

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

|   |  |                   |                   |                   |    |  |  |  |  |         |
|---|--|-------------------|-------------------|-------------------|----|--|--|--|--|---------|
| 1 | Counter Sinking Depth & Finish             | OK                |                   |                   |    |  |  |  |  | Ravi 47 |
| 2 | External Relief Dia                        | 4.5 n/c / 4.8 n/c | 4.5 n/c All Lines | 4.8 n/c All Lines |    |  |  |  |  |         |
| 3 | External Relief Depth                      |                   | 35 n/c            | 10 n/c            |    |  |  |  |  |         |
| 4 | Inspection Done Before Hardening By (Name) |                   | Ravi              |                   |    |  |  |  |  |         |
| 5 | Material Sent For Hardening By (Name)      |                   | Lark Forncore     |                   |    |  |  |  |  |         |
| 6 | Material Sent For Hardening On Date        |                   | 13                | 7                 | 25 |  |  |  |  |         |

### Inspected By (Sign) & Date

Ravi 13/7/23

Reviewed by (Engineer-CNC)

Manager-QA