



# 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.                        |                        | 11815/                                | 35/50/70                         |
| 2     | Machined By                           |                        | V.T.L n/c Shop                        | 40/55/70                         |
| 3     | Pallet Die No.                        |                        | 10749 (8.0) n/c                       | Drill Hole L.S.D. 277            |
| 4     | Die Category                          | Drg. No.               | M. Tumbo                              | Rev: 03                          |
| 5     | Out Side Diameter                     | Drg. No.               | 688 n/c, Step 00, 697.7 n/c           | Tapping 25                       |
| 6     | Inside Diameter                       | Drg. No.               | 548.1 n/c                             | Step length 38.5                 |
| 7     | Width of Pellet Die                   | Drg. No.               | 215 n/c                               |                                  |
| 8     | Grooves as per Drawing                | Drg. No.               | 29.5 x 16 x 8 n/c / 29.5 x 10 x 8 n/c | (6 x 8) n/c<br>Face Side Stepped |
| 9     | Fitting Sizes on CNC Plate            | Drg. No.               | ok                                    | Deep Both Side                   |
| 10    | Drilling Area Surface Smoothness      |                        | ok                                    |                                  |
| 11    | Tapping Operator                      |                        | n/c Shop                              | Tapping Ho                       |
| 12    | Tapping PCD                           |                        | 618 n/c                               | of holes 2                       |
| 13    | Tapping Hole Diameter                 |                        | N16 = Check by N16 Bolt               | Both Side                        |
| 14    | Tapping On Second Side                | Half pitch of 1st side | ok                                    |                                  |
| 15    | Tapping Hole Depth                    |                        | Drill Depth 33.3 n/c                  | Tapping Depth 29.8               |
| 16    | Perpendicularity of Tapped Hole       |                        | yes                                   |                                  |
| 17    | Visual Inspection Before Gun Drilling |                        | ok                                    |                                  |

Inspected By (Sign) & Date

Ravi 28/24

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

| S.No. | Check Parameter                            | 1st Pad      |       |       |       | 2nd Pad |       |       |       | Count etc.    |
|-------|--|--------------|-------|-------|-------|---------|-------|-------|-------|---------------|
|       |  | 8.5mm        | 9.0mm | 8.5mm | 9.0mm | 8.5mm   | 9.0mm | 8.5mm | 9.0mm |               |
| 1     | Counter Sinking Depth & Finish             | OK           |       |       |       |         |       |       |       | Count etc. 80 |
| 2     | External Relief Dia                        | 8.5mm        | 9.0mm | 8.5mm | 9.0mm | 8.5mm   | 9.0mm | 8.5mm | 9.0mm | Count = 12    |
| 3     | External Relief Depth                      |              |       | 35mm  | 30mm  | 30mm    | 15mm  |       |       |               |
| 4     | Inspection Done Before Hardening By (Name) | Ravi         |       |       |       |         |       |       |       |               |
| 5     | Material Sent For Hardening By (Name)      | Lark Forcase |       |       |       |         |       |       |       |               |
| 6     | Material Sent For Hardening On Date        | 8            | 2     | 24    |       |         |       |       |       |               |

Inspected By (Sign) & Date

Ravi 28/24

Reviewed by (Engineer-CNC)

Manager-QA