



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. | | 9685 | 37/50 |
| 2 | Machined By | | V. T. L n/c Shop | Dry No = 1.2.0 = 71 |
| 3 | Pallet Die No. | | 9937(3.5) n/c | Res = 00 |
| 4 | Die Category | Drg. No. | Extra side | |
| 5 | Out Side Diameter | Drg. No. | 620 n/c | Tap 12° |
| 6 | Inside Diameter | Drg. No. | 622.6 n/c 520.12 n/c / 520.14 | Step length = 17 n/c |
| 7 | Width of Pellet Die | Drg. No. | 220 n/c | Under cut = 1.2 n/c / 1.4 n/c |
| 8 | Grooves as per Drawing | Drg. No. | 94104 n/c / 94104 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 | | 565 n/c | Tapping No of Holes = 1.2 Both Side |
| 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 20.4 n/c | Tapping Depth 18.8 n/c |
| 16 | Perpendicularity of Tapped Hole | | yes | |
| 17 | Visual Inspection Before Gun Drilling | | ok | |
| Inspected By (Sign) & Date | | | Ravi 8/6/23 | |
| 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 | | |
| 2 | External Relief Dia | 3.8 n/c | outside (3-3) | Inner |
| 3 | External Relief Depth | 17 n/c | | 13 n/c |
| 4 | Inspection Done Before Hardening By (Name) | | Ravi | |
| 5 | Material Sent For Hardening By (Name) | | Lark Furnace | |
| 6 | Material Sent For Hardening On Date | | 8 | 6 25 |
| Inspected By (Sign) & Date | | | Ravi 8/6/23 | |

Reviewed by (Engineer-CNC)

Manager-QA