



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. | | 11016, | 60/65, |
| 2 | Machined By | | V-T.L. H/c Shop | Dr. Hole L.S.D. 951 |
| 3 | Pallet Die No. | | 12032 (4.5)mm | Rev. 00 |
| 4 | Die Category | Drg. No. | Senior | |
| 5 | Out Side Diameter | Drg. No. | 549.8mm (A) Step OD: 491mm | Step length 17.4 |
| 6 | Inside Diameter | Drg. No. | 420.14mm (B) | |
| 7 | Width of Pellet Die | Drg. No. | 158mm | |
| 8 | Grooves as per Drawing | Drg. No. | 12x8x3mm 12x8x3mm | |
| 9 | Fitting Sizes on CNC Plate | Drg. No. | ok | |
| 10 | Drilling Area Surface Smoothness | | ok | |
| 11 | Tapping Operator | | H/c Shop | Tapping H of holes 8 Both Side |
| 12 | Tapping PCD | | 454mm | |
| 13 | Tapping Hole Diameter | | M20 - Check by M20 Ball | |
| 14 | Tapping On Second Side | Half pitch of 1st side | ok | |
| 15 | Tapping Hole Depth | | Drill Depth = 20mm | Tapping Depth = 17.6 |
| 16 | Perpendicularity of Tapped Hole | | yes | |
| 17 | Visual Inspection Before Gun Drilling | | ok | |

Inspected By (Sign) & Date

Ravi 19/8/24

| | | | |
|---|--------------------------------|--------|----|
| 1 | As per programme no. | | |
| 2 | Gun Drilling Work Completed On | | |
| 3 | Hole Finish In Gun Drilling | Marked | ok |
| 4 | Defective Holes (If Any) | | N. |

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

| | | | | | | | | |
|---|--|-------|---------------|---|-------|--|--|--------------|
| 1 | Counter Sinking Depth & Finish | ok | | | | | | Counter 60 |
| 2 | External Relief Dia | 5.0mm | Outside (2-2) | | Inner | | | |
| 3 | External Relief Depth | | 14mm | | 5mm | | | |
| 4 | Inspection Done Before Hardening By (Name) | | | | | | | Ravi |
| 5 | Material Sent For Hardening By (Name) | | | | | | | Lark Furnace |
| 6 | Material Sent For Hardening On Date | | 19 | 3 | 24 | | | |

Inspected By (Sign) & Date

Ravi 19/8/24

Reviewed by (Engineer-CNC)

Manager-QA