



# 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.                        |                        | 11546                     | 40/50                                    |
| 2     | Machined By                           |                        | V.T.L. H/c Shop           | Q355<br>Lark S10                         |
| 3     | Pallet Die No.                        |                        | 11966 (3.0) H/c           |  |
| 4     | Die Category                          | Drg. No.               | Extra wide                |  |
| 5     | Out Side Diameter                     | Drg. No.               | 6.20 H/c Step 002 612 H/c | Step length 19.4                         |
| 6     | Inside Diameter                       | Drg. No.               | 5.20 1.2 H/c              |  |
| 7     | Width of Pellet Die                   | Drg. No.               | 22.2 H/c                  |  |
| 8     | Grooves as per Drawing                | Drg. No.               | 13x8x5 H/c   13x8x5 H/c   |  |
| 9     | Fitting Sizes on CNC Plate            | Drg. No.               | OK                        |  |
| 10    | Drilling Area Surface Smoothness      |                        | OK                        |  |
| 11    | Tapping Operator                      |                        | H/c Shop                  | Tabbing Ho<br>of holes = 12<br>Both Side |
| 12    | Tapping PCD                           |                        | 565 H/c                   |  |
| 13    | Tapping Hole Diameter                 |                        | H202 Check by H20 Roll    |  |
| 14    | Tapping On Second Side                | Half pitch of 1st side | OK                        |  |
| 15    | Tapping Hole Depth                    |                        | Drill Depth = 20.8 H/c    | Tabbing Depth = 18.8                     |
| 16    | Perpendicularity of Tapped Hole       |                        | Yes                       |  |
| 17    | Visual Inspection Before Gun Drilling |                        | OK                        |  |

### Inspected By (Sign) & Date

Rao: 22/3/24

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

|   |  |         |               |        |    |  |  |                          |
|---|--|---------|---------------|--------|----|--|--|--------------------------|
| 1 | Counter Sinking Depth & Finish             | OK      |               |        |    |  |  | Counter, Gas<br>Rao 2 25 |
| 2 | External Relief Dia                        | 3.3 H/c | Outside (3.3) | Inner  |    |  |  |                          |
| 3 | External Relief Depth                      |         | 16 H/c        | 10 H/c |    |  |  |                          |
| 4 | Inspection Done Before Hardening By (Name) |         | Rao           |        |    |  |  |                          |
| 5 | Material Sent For Hardening By (Name)      |         | Lark Porner   |        |    |  |  |                          |
| 6 | Material Sent For Hardening On Date        |         | 22            | 3      | 24 |  |  |                          |

### Inspected By (Sign) & Date

Rao: 22/3/24

Reviewed by (Engineer-CNC)

Manager-QA