



Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

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| 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. | | 11627 | 40/45 |
| 2 | Machined By | | V. T. L. H/c Shop | Dr. No. 62.05 825 |
| 3 | Pallet Die No. | | 12252 (5.0) H-H | Rev. 1.00 |
| 4 | Die Category | Drg. No. | Junior | |
| 5 | Out Side Diameter | Drg. No. | 405 H-H, Step OD = 389 H-H | Step length 2.5 |
| 6 | Inside Diameter | Drg. No. | 315.12 H-H | |
| 7 | Width of Pellet Die | Drg. No. | 120 H-H | |
| 8 | Grooves as per Drawing | Drg. No. | 1048 x 3 H-H / 1078 x 3 H-H | |
| 9 | Fitting Sizes on CNC Plate | Drg. No. | OK | |
| 10 | Drilling Area Surface Smoothness | | OK | |
| 11 | Tapping Operator | | H/c Shop | Tapping of holes on Both Side |
| 12 | Tapping PCD | | 356 H-H | |
| 13 | Tapping Hole Diameter | | 031/4" = Check by 031/4" Bolt | |
| 14 | Tapping On Second Side | Half pitch of 1st side | OK | |
| 15 | Tapping Hole Depth | | Drill Depth = 20.8 H-H | Tapping Depth = 18.8 |
| 16 | Perpendicularity of Tapped Hole | | Yes | |
| 17 | Visual Inspection Before Gun Drilling | | OK | |

Inspected By (Sign) & Date

Ravi 4/4/24

| | | | |
|---|--------------------------------|--------|----|
| 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 | | | | | | | Countersink |
| 2 | External Relief Dia | 5.5 H-H | Outside (2-2) | | Inner | | | | |
| 3 | External Relief Depth | | 10 H-H | | 5 H-H | | | | |
| 4 | Inspection Done Before Hardening By (Name) | | | | | | | | Ravi |
| 5 | Material Sent For Hardening By (Name) | | | | | | | | Lark Furnace |
| 6 | Material Sent For Hardening On Date | | | 4 | 4 | 24 | | | |

Inspected By (Sign) & Date

Ravi 4/4/24

Reviewed by (Engineer-CNC)

Manager-QA