



# 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)

7253

| S.No. | Check Parameter                       | Specification          | Observations                  | Remarks                           |
|-------|---------------------------------------|------------------------|-------------------------------|-----------------------------------|
| 1     | Work Order No.                        |                        | 11615                         | 40/35                             |
| 2     | Machined By                           |                        | V. T. G. HLC Shop             | Dy. No. (B.D) 666                 |
| 3     | Pallet Die No.                        |                        | 12136 (4.0) HLC               | Rev. 01                           |
| 4     | Die Category                          | Drg. No.               | H-7 Jumbo                     |                                   |
| 5     | Out Side Diameter                     | Drg. No.               | 710 HLC Step 002 692.8 HLC    | Tapper 12                         |
| 6     | Inside Diameter                       | Drg. No.               | 600.12 HLC                    | Step length 19.8                  |
| 7     | Width of Pellet Die                   | Drg. No.               | 222 HLC                       |                                   |
| 8     | Grooves as per Drawing                | Drg. No.               | 12x10x7.5 HLC   12x10x7.5 HLC |                                   |
| 9     | Fitting Sizes on CNC Plate            | Drg. No.               | ok                            |                                   |
| 10    | Drilling Area Surface Smoothness      |                        | ok                            |                                   |
| 11    | Tapping Operator                      |                        | HLC Shop                      | Tapping HLC of Holes 12 Rate Side |
| 12    | Tapping PCD                           |                        | 640 HLC                       |                                   |
| 13    | Tapping Hole Diameter                 |                        | H20 - Check by H20 Bolt       |                                   |
| 14    | Tapping On Second Side                | Half pitch of 1st side | ok                            |                                   |
| 15    | Tapping Hole Depth                    |                        | Drill Depth = 20.8 HLC        | Tapping Depth = 18.2              |
| 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      |               |   |        |    |  |  | Counter 6.0<br>Rate 231 |
| 2 | External Relief Dia                        | 4.5 HLC | Outside (3-3) |   | Inner  |    |  |  |                         |
| 3 | External Relief Depth                      |         | 19 HLC        |   | 15 HLC |    |  |  |                         |
| 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

Satish 4/4/24

Reviewed by (Engineer-CNC)

Manager-QA