



# 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.                        |                        | 11594                               | 33/40                               |
| 2     | Machined By                           |                        | V. T.L. H/C Shop                    | Drg No. 11584                       |
| 3     | Pallet Die No.                        |                        | 11584 (3.0) H                       | 91.9                                |
| 4     | Die Category                          | Drg. No.               | Junior                              |                                     |
| 5     | Out Side Diameter                     | Drg. No.               | 4.00 H Step OD = 3.95 H             | Step length 1.5                     |
| 6     | Inside Diameter                       | Drg. No.               | 3.20 H                              |                                     |
| 7     | Width of Pellet Die                   | Drg. No.               | 1.40 H                              |                                     |
| 8     | Grooves as per Drawing                | Drg. No.               | 15.5 x 7 x 8 H / 15.5 x 7 x 8 H     |                                     |
| 9     | Fitting Sizes on CNC Plate            | Drg. No.               | ok                                  |                                     |
| 10    | Drilling Area Surface Smoothness      |                        | ok                                  |                                     |
| 11    | Tapping Operator                      |                        | H/C Shop                            | Tapping dia of holes 8<br>Back side |
| 12    | Tapping PCD                           |                        | 3.55 H                              |                                     |
| 13    | Tapping Hole Diameter                 |                        | M16 Check by M16 Bolt               |                                     |
| 14    | Tapping On Second Side                | Half pitch of 1st side | ok                                  |                                     |
| 15    | Tapping Hole Depth                    |                        | Drill Depth 21 H Tapping Depth 19 H |                                     |
| 16    | Perpendicularity of Tapped Hole       |                        | yes                                 |                                     |
| 17    | Visual Inspection Before Gun Drilling |                        | ok                                  |                                     |

Inspected By (Sign) & Date

Ravi Gul24

|   |                                |        |       |
|---|--------------------------------|--------|-------|
| 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 = 60 |
| 2                          | External Relief Dia                        | 3.5 H      | outside (2-2) | inner |    |  |  |              |
| 3                          | External Relief Depth                      |            | 13 H          | 7 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        |            | 6             | 4     | 24 |  |  |              |
| Inspected By (Sign) & Date |  | Ravi Gul24 |               |       |    |  |  |              |

Reviewed by (Engineer-CNC)

Manager-QA