



# 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.                        |                        | 11702                          | 34/50                                  |
| 2     | Machined By                           |                        | V.T.L. n/c Shop                | Dry No. L.S.O. 032                     |
| 3     | Pallet Die No.                        |                        | 11405 (H.O) n/c                | Rev. 01                                |
| 4     | Die Category                          | Drg. No.               | 53510                          |  |
| 5     | Out Side Diameter                     | Drg. No.               | 620.1 n/c, Step OD = 632.8 n/c | Tappet 12°                             |
| 6     | Inside Diameter                       | Drg. No.               | 520.14 n/c (A)                 | Step length 2.5 n/c                    |
| 7     | Width of Pellet Die                   | Drg. No.               | 186 n/c                        | Width 1.6 n/c                          |
| 8     | Grooves as per Drawing                | Drg. No.               | 13x8x5 n/c   13x8x5 n/c        |  |
| 9     | Fitting Sizes on CNC Plate            | Drg. No.               | ok                             |  |
| 10    | Drilling Area Surface Smoothness      |                        | ok                             |  |
| 11    | Tapping Operator                      |                        | n/c Shop                       | Tapping No. of holes = 12<br>Botu Side |
| 12    | Tapping PCD                           |                        | 565 n/c                        |  |
| 13    | Tapping Hole Diameter                 |                        | HIG - Check by HIG Bolt        |  |
| 14    | Tapping On Second Side                | Half pitch of 1st side | ok                             |  |
| 15    | Tapping Hole Depth                    |                        | Drill Depth = 20.8 n/c         | Tapping Depth = 18.8                   |
| 16    | Perpendicularity of Tapped Hole       |                        | yes                            |  |
| 17    | Visual Inspection Before Gun Drilling |                        | ok                             |  |

**Inspected By (Sign) & Date**

Ravi 8/1/24

|   |                                |        |    |
|---|--------------------------------|--------|----|
| 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 60°  |
| 2 | External Relief Dia                        | 4.5 n/c | Outside (3-3) |   | Inner  |  |              |
| 3 | External Relief Depth                      |         | 20 n/c        |   | 16 n/c |  |              |
| 4 | Inspection Done Before Hardening By (Name) |         |               |   |        |  | Ravi         |
| 5 | Material Sent For Hardening By (Name)      |         |               |   |        |  | Lark Furnace |
| 6 | Material Sent For Hardening On Date        |         | 8             | 4 | 24     |  |              |

**Inspected By (Sign) & Date**

Ravi 8/1/24

Reviewed by (Engineer-CNC)

Manager-QA