



# 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

7313

| S.No. | Check Parameter                       | Specification          | Observations                                | Remarks                            |
|-------|---------------------------------------|------------------------|---|------------------------------------|
| 1     | Work Order No.                        |                        | 11703                                       | 39/59                              |
| 2     | Machined By                           |                        | V.T.L n/c Shop                              | Drg no. 1.3.9.549                  |
| 3     | Pallet Die No.                        |                        | 12142 (3.0) n/c                             | Rev 200                            |
| 4     | Die Category                          | Drg. No.               | M. Jumbo                                    |                                    |
| 5     | Out Side Diameter                     | Drg. No.               | 704 n/c Step OD = 69.7 n/c                  | Tapper = 12°                       |
| 6     | Inside Diameter                       | Drg. No.               | 600.12 n/c                                  | Step length = 20 n/c               |
| 7     | Width of Pellet Die                   | Drg. No.               | 222 n/c                                     |                                    |
| 8     | Grooves as per Drawing                | Drg. No.               | 12x10x7.5 n/c / 12x10x7.5 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 Both Side |
| 12    | Tapping PCD                           |                        | 640 n/c                                     |                                    |
| 13    | Tapping Hole Diameter                 |                        | M20 Check by H20 Ball                       |                                    |
| 14    | Tapping On Second Side                | Half pitch of 1st side | ok  |                                    |
| 15    | Tapping Hole Depth                    |                        | Drill Depth = 20.7 n/c Tapping Depth = 18.2 |                                    |
| 16    | Perpendicularity of Tapped Hole       |                        | yes   |                                    |
| 17    | Visual Inspection Before Gun Drilling |                        | ok  |                                    |

Inspected By (Sign) & Date

Ravi 13/4/24

|   |                                |        |    |
|---|--------------------------------|--------|----|
| 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      |               |    |        |    |  |  |  | Count on 6° Row = 38 |
| 2 | External Relief Dia                        | 3.5 n/c | 60 Side (3-3) |    | Inner  |    |  |  |  |                      |
| 3 | External Relief Depth                      |         | 19 n/c        |    | 13 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        |         |               | 13 | 4      | 24 |  |  |  |                      |

Inspected By (Sign) & Date

Ravi 13/4/24

Reviewed by (Engineer-CNC) Satya 13/4/24

Manager-QA

Reviewed by (Engineer-CNC)

Manager-QA