



# 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.                        |                        | 9913                      | <del>34/57.5</del>       |
| 2     | Machined By                           |                        | V.T.L n/c Shop            | Drg No. 1.2.0.731        |
| 3     | Pallet Die No.                        |                        | 10291 (4.0) n/c           | Rev. 2.00                |
| 4     | Die Category                          | Drg. No.               | 580                       | Ⓟ                        |
| 5     | Out Side Diameter                     | Drg. No.               | 529 n/c, Step OD. 532 n/c | 461.6 n/c                |
| 6     | Inside Diameter                       | Drg. No.               | 420.12 n/c                | Step length. 20 n/c      |
| 7     | Width of Pellet Die                   | Drg. No.               | 190 n/c                   | 9.5 n/c                  |
| 8     | Grooves as per Drawing                | Drg. No.               | 42x6x7 n/c   18x6x7 n/c   | Under cut > 1.5 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 = 8 |
| 12    | Tapping PCD                           |                        | 480 n/c                   |                          |
| 13    | Tapping Hole Diameter                 |                        | M16, Check by M16 Bolt    |                          |
| 14    | Tapping On Second Side                | Half pitch of 1st side | one side Tapping and      | 1st Side One Slot        |
| 15    | Tapping Hole Depth                    |                        | Drill Depth 20 n/c        | Tapping Depth 13.8       |
| 16    | Perpendicularity of Tapped Hole       |                        | yes                       |                          |
| 17    | Visual Inspection Before Gun Drilling |                        | ok                        |                          |

### Inspected By (Sign) & Date

Ravi 31/7/13

|   |                                |        |    |   |
|---|--------------------------------|--------|----|---|
| 1 | As per programme no.           |        |    | 1 Slot<br>22.1 mm width<br>10.5 mm Deep |
| 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      |               |              |        |  |  |  | Low = 20     |
| 2                          | External Relief Dia                        | 4.5 n/c | outside (2-2) |              | Inner  |  |  |  |              |
| 3                          | External Relief Depth                      |         | 25 n/c        |              | 21 n/c |  |  |  |              |
| 4                          | Inspection Done Before Hardening By (Name) |         |               |              |        |  |  |  | Ravi         |
| 5                          | Material Sent For Hardening By (Name)      |         |               |              |        |  |  |  | Lark Parnone |
| 6                          | Material Sent For Hardening On Date        |         | 21            | 7            | 23     |  |  |  |              |
| Inspected By (Sign) & Date |  |         |               | Ravi 31/7/13 |        |  |  |  |              |

Reviewed by (Engineer-CNC)

Manager-QA