



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. | | 9788 | 55/60 |
| 2 | Machined By | | V.T.L n/c Shop | Dy No. 1.3.0 584 |
| 3 | Pallet Die No. | | 10506 (10.0)mm | Recessed |
| 4 | Die Category | Drg. No. | Jumbo | |
| 5 | Out Side Diameter | Drg. No. | 780mm Step OD, 798mm | Step length 25.5 |
| 6 | Inside Diameter | Drg. No. | 660.12mm | Undercut 9mm |
| 7 | Width of Pellet Die | Drg. No. | 324mm | |
| 8 | Grooves as per Drawing | Drg. No. | 21.5 x 8 x 10 mm / 21.5 x 8 x 10 mm | |
| 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 | | 785mm | |
| 13 | Tapping Hole Diameter | | M20, Check by M20 Bolt | |
| 14 | Tapping On Second Side | Half pitch of 1st side | OK | |
| 15 | Tapping Hole Depth | | Drill Depth 30.5mm | Tapping Depth 28.2 |
| 16 | Perpendicularity of Tapped Hole | | yes | |
| 17 | Visual Inspection Before Gun Drilling | | OK | |

Inspected By (Sign) & Date

| | | | | |
|---|--------------------------------|--------|----|---|
| 1 | As per programme no. | | | 2 Slot 38.1mm width & 2nd Deep Both Side |
| 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 | | | | | | | Recessed |
| 2 | External Relief Dia | 10.5mm | Outside (3-3) | | Inner | | | | |
| 3 | External Relief Depth | | 10mm | | 5mm | | | | |
| 4 | Inspection Done Before Hardening By (Name) | | | | | | | | Ravi |
| 5 | Material Sent For Hardening By (Name) | | | | | | | | Lark Furnace |
| 6 | Material Sent For Hardening On Date | | 21 | 7 | 23 | | | | |

Inspected By (Sign) & Date

| | | | | | | | | | |
|--|--|--|--|--|--|--|--|--|--------------|
| | | | | | | | | | Ravi 21/7/23 |
|--|--|--|--|--|--|--|--|--|--------------|

Reviewed by (Engineer-CNC)

Manager-QA